SERVICE BULLETIN
SUMMARY

AIRBUS
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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 - REAR FUSELAGE - REINFORCE FRAMES IN AREA OF STGR32 - STGR39 LHS SECTION 17

****CONF ALL**

MODIFICATIONS

MODIFICATION CLASSIFICATION					
MAJOR	None				
MINOR	153065K15435	153563K15481			

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

As a result of fatigue tests for the A320 aircraft, shear webs and some frame clips must be replaced in the aft lower fuselage.

This Service Bulletin gives the procedure to replace the existing shear webs and several frame clips. For each replaced frame clip one additional support angle is added for the structure support between frame and related stringer. Additionally one tack hole and one tooling hole in each frame is cold expanded to increase the fatigue life of the frames.

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 department for further instructions.

The accomplishment of this Service Bulletin cancels the inspection requirements of Service Bulletin No. A320-53-1257.

The Operational/Maintenance Consequences of this Service Bulletin are covered by the update of the affected publications detailed in 'PLANNING INFORMATION'.

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GENERAL EVALUATION

EVALUATION TABLE			
COMPLIANCE	MANDATORY (1)	CANCELS INSPECTION SB	YES
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
VALIDATION ON AIRCRAFT	YES	BOOKLET AVAILABLE	YES
DEFUELING	YES		

NOTE (1): Service Bulletin must be accomplished.

The equivalent of this Service Bulletin has been validated on A319 aircraft with Manufacturer Serial Number (MSN) 0616.

A booklet including photographs taken during the validation of the equivalent Service Bulletin is available on AirbusWorld - Maintenance and Engineering - AirN@v engineering (in the concerned SB file).

MATERIAL PRICE INFORMATION

****CONF 001**

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 531364D01R05	1	9,500.00	Angles, webs and attaching parts
Standard tool TOOLD01	1	See SB	FTI durable tooling, expendable tooling and capital tooling
Standard tool TOOLD02	1	See SB	WCI durable tooling, expendable tooling and capital tooling

****CONF 002**

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 531364D02R04	1	11,000.00	Angles, webs and attaching parts
Standard tool TOOLD01	1	See SB	FTI durable tooling, expendable tooling and capital tooling
Standard tool TOOLD02	1	See SB	WCI durable tooling, expendable tooling and capital tooling

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**CONF 003

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 531364D03R03	1	11,500.00	Angles, webs and attaching parts
Standard tool TOOLD01	1	See SB	FTI durable tooling, expendable tooling and capital tooling
Standard tool TOOLD02	1	See SB	WCI durable tooling, expendable tooling and capital tooling

**CONF 004

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 531364D04R04	1	13,500.00	Angles, webs and attaching parts
Standard tool TOOLD01	1	See SB	FTI durable tooling, expendable tooling and capital tooling
Standard tool TOOLD02	1	See SB	WCI durable tooling, expendable tooling and capital tooling

**CONF 005

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 531364D05R05	1	14,000.00	Angles, webs and attaching parts
Standard tool TOOLD01	1	See SB	FTI durable tooling, expendable tooling and capital tooling
Standard tool TOOLD02	1	See SB	WCI durable tooling, expendable tooling and capital tooling

**CONF 006

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 531364D06R06	1	14,500.00	Angles, webs and attaching parts
Standard tool TOOLD01	1	See SB	FTI durable tooling, expendable tooling and capital tooling
Standard tool TOOLD02	1	See SB	WCI durable tooling, expendable tooling and capital tooling

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**CONF 007

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 531364D07R06	1	15,000.00	Angles, webs and attaching parts
Standard tool TOOLD01	1	See SB	FTI durable tooling, expendable tooling and capital tooling
Standard tool TOOLD02	1	See SB	WCI durable tooling, expendable tooling and capital tooling

**CONF 008

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 531364D08R04	1	12,500.00	Angles, webs and attaching parts
Standard tool TOOLD01	1	See SB	FTI durable tooling, expendable tooling and capital tooling
Standard tool TOOLD02	1	See SB	WCI durable tooling, expendable tooling and capital tooling

**CONF 009

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 531364D09R04	1	13,000.00	Angles, webs and attaching parts
Standard tool TOOLD01	1	See SB	FTI durable tooling, expendable tooling and capital tooling
Standard tool TOOLD02	1	See SB	WCI durable tooling, expendable tooling and capital tooling

EFFECTIVITY

**CONF ALL

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

15T	41N	66X	95W	AAL	AAR	ABL	ABQ	AHY	ALK	ART	ASV	AUA
AUH	BEC	CBJ	CCA	CFG	ETD	FIN	GFA	GMI	GSW	HVN	IAW	JBU
KAC	KHV	KKK	MEA	MJN	MKR	MON	NIA	NVD	ORF	OTC	PKZ	QAF
QQE	RCT	RWZ	SAS	SBI	SVA	SVR	TAP	TCX	USA	VJC	VKG	WOW

CONCURRENT REQUIREMENTS

None

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REFERENCES / REPERCUSSIONS

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

NATURE OF THE WORK

AIRCRAFT	YES
EQUIPMENT	NO

MANPOWER

****CONF 001**

Task 531364-831-848-001: Modification	
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

****CONF 002**

Task 531364-831-848-001: Modification	
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

****CONF 003**

Task 531364-831-848-001: Modification	
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

****CONF 004**

Task 531364-831-848-001: Modification	
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

****CONF 005**

Task 531364-831-848-001: Modification	
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

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****CONF 006**

Task 531364-831-848-001: Modification	
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

****CONF 007**

Task 531364-831-848-001: Modification	
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

****CONF 008**

Task 531364-831-848-001: Modification	
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

****CONF 009**

Task 531364-831-848-001: Modification	
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

APPENDICES

****CONF ALL**

Appendix 01 - Manpower Gantt Chart

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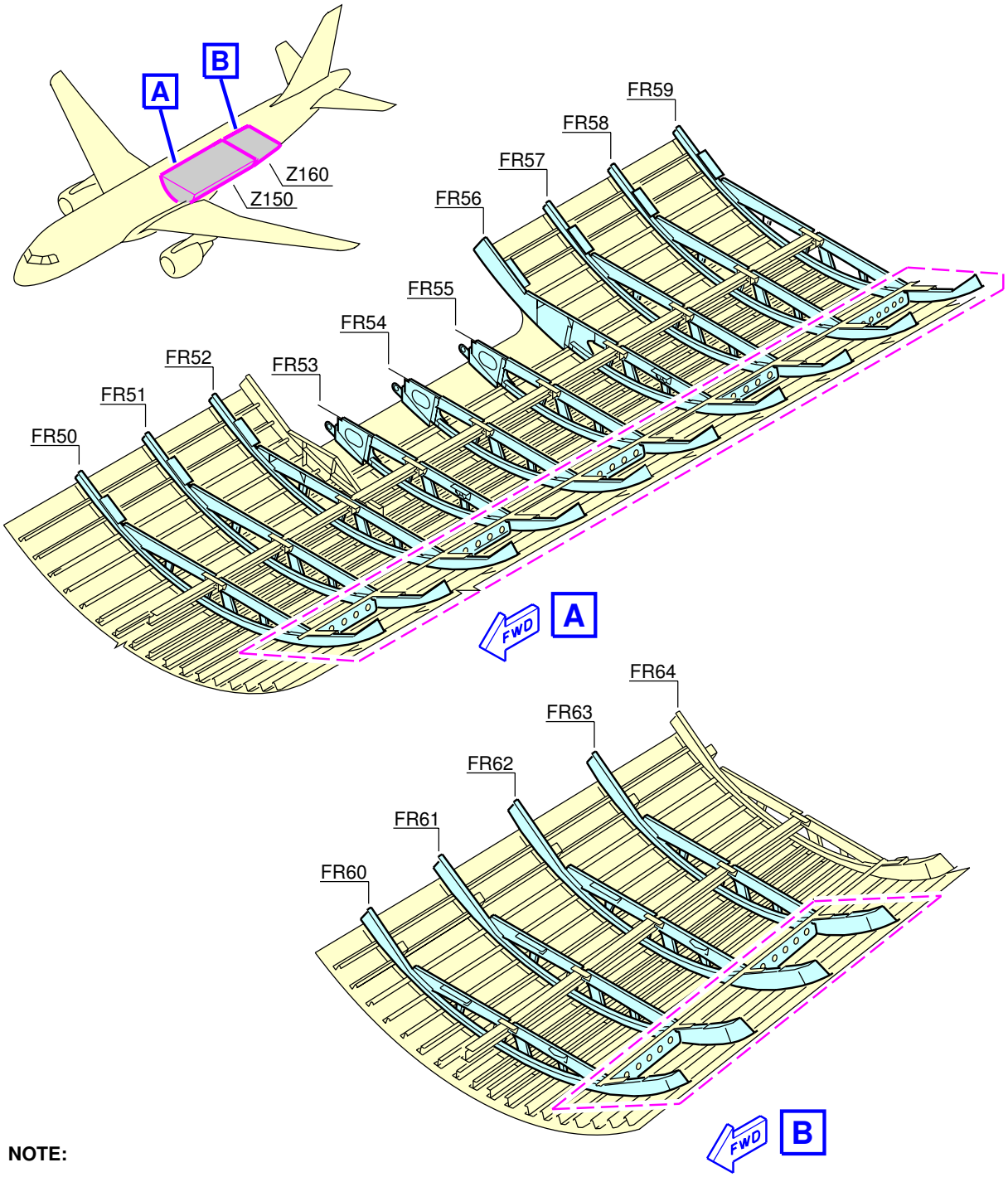
**CONF ALL



NOTE:

MODIFICATION AREA

N_SB_531364_6_SAAA_01_00

Figure A-GSAAA - Sheet 01
Modification Area - FR 50 thru FR 63 - STGR 31 thru STGR 39

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MANDATORY MANDATORY MANDATORY

ATA SYSTEM: 53

TITLE: FUSELAGE - REAR FUSELAGE - REINFORCE FRAMES IN AREA OF STGR32 - STGR39 LHS SECTION 17

MODIFICATION No.: 153065K15435 153563K15481

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1. PLANNING INFORMATION

****CONF ALL**

A. EFFECTIVITY

NOTE: This modification is applicable by Service Bulletin only.

(1) Models

320-212 320-214 320-232 321-211 321-231 321-232

(2) Effectivity by MSN

0764 0870 0927 1017 1137 1150 1276 1366 1403 1412 1417 1425 1431 1436 1442
1447 1451 1455 1462 1465 1472 1481 1492 1496 1499 1517 1519 1521 1525 1531
1536 1539 1607 1629 1651 1666 1701 1704 1707 1724 1763 1794 1798 1843 1881
1921 1932 1941 1946 1950 1960 1970 2046 2060 2105 2211 2216 2234 2246 2259
2280 2284 2286 2307 2314 2336 2352 2368 2384 2386 2403 2410 2415 2476 2566
2590 2707 3164 3199 3584 3629 3633 3712 3723 3736 3740 3796 3804 3837 3858
3879 3881 3924 3928 3944 3960 3977 3989 3993 4025 4041 4044 4050 4067
4081-4082 4090 4107 4117 4123 4134 4170 4199 4296 4337 4339 4364 4388 4408
4632 4780 4795 4827 4843 4847 4850 4860 4865 4885 4893 4898 4932 4935 4940
4955 4957 4960 4966 5000 5164 5171 5175 5223 5235 5241 5244 5247 5255 5269
5282 5292 5295 5300 5317 5332 5343 5368 5374 5386 5409 5419 5422 5427 5444
5469 5475 5504 5513 5538 5568 5588 5594 5603 5644 5659 5664 5681 5684 5690
5696 5709 5728 5733 5751 5758 5763 5767 5771 5774 5779 5783 5795 5800 5803

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5834 5843 5854 5860 5865 5872 5884 5895 5899 5904 5909 5919 5922 5932
5938-5939 5946 5955 5960-5961 5966 5969 5975 5980 5983 5991 5994 6005 6016
6020 6027 6031 6035 6038 6046 6053 6056 6063 6067 6069-6070 6083 6094 6100
6108 6114 6119 6122 6130 6133 6143 6152 6156 6162 6175 6181 6185 6194 6210
6214 6222 6227 6230 6232 6236 6238 6245 6249 6252 6255-6256 6264 6268
6271-6272 6279 6285 6313-6314 6326 6334 6337 6342 6346 6351 6359 6376 6387
6389-6390 6401 6407 6420 6425 6427 6438 6443 6448 6459 6468 6472-6473 6479
6482 6490 6495 6512 6515 6520 6523 6526 6532 6537 6543 6548 6560 6569 6575
6590 6609 6613 6615 6618 6621 6625 6647 6650 6656 6663 6667 6687 6711 6723
6725 6745 6757 6761 6763 6768 6783 6790-6791 6796 6802 6809 6812 6828 6840
6853 6859 6863

(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
15T	0764
41N	3164
66X	1276
95W	4199
AAL	5834 5860 5884 5895 5904 5932 5938 5946 5955 5975 5983 5991 6020 6046 6063 6070 6094 6162 6222 6227 6238 6252 6256 6271 6272 6313 6334 6346 6401 6407 6472 6473 6482 6495 6520 6532 6621 6647 6650 6656 6667 6687 6711 6723 6745 6761 6783 6790 6802 6812 6828 6840
AAR	6768 6796
ABL	1970
ABQ	5966 6016 6067 6119
AHY	6285
ALK	1946
ART	2211 2216
ASV	5767 5774
AUA	1137 1150
AUH	2403
BEC	3199 5538
CBJ	4388 6763 6853 6863
CCA	5386 5419 5568 5664 5690 5771
CFG	1607 5969 6053 6376 6459 6590 6615
ETD	6108 6143
FIN	5758 5803 5922 5961 6083
GFA	4780 4827 4860 4865 5171 5175
GMI	1629 6005
GSW	5843
HVN	5164 5241 5247 5427 5469 5709 5994
IAW	4044 4067

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OPERATOR	MSN
JBU	2246 2259 2280 2284 2286 2307 2314 2336 2352 2368 2384 2386 2415 5783 5854 5865 5909 5960 6031 6130 6185 6245 6279 6326 6359 6390 6425 6448 6512 6560 6575 6609 6663 6725 6757 6791 6809 6859
KAC	2046
KHV	5343
KKK	1451 1950
MEA	3736 3804 3837 4296 4339 4632 5000
MJN	3723 4117 4795
MKR	1794
MON	1707 1763 1941 2105 2234
NIA	2410 2476
NVD	1366
ORF	2566
OTC	6156 6268
PKZ	6069
QAF	0927
QQE	4170 5255
RCT	1017
RWZ	1843
SAS	1798
SBI	5779 5919
SVA	4081 4090 4337 4364 4408 4955 5223
SVR	2590 2707
TAP	0870
TCX	1881 1921 2060 5603 5872 6038 6056 6114 6122 6515 6526 6548
USA	1403 1412 1417 1425 1431 1436 1442 1447 1455 1462 1465 1472 1481 1492 1496 1499 1517 1519 1521 1525 1531 1536 1539 1651 1666 1701 1704 1724 3584 3629 3633 3712 3740 3796 3858 3879 3881 3924 3928 3944 3960 3977 3989 3993 4025 4041 4050 4082 4107 4123 4134 4843 4847 4850 4885 4893 4898 4932 4935 4940 4957 4960 4966 5235 5244 5269 5282 5292 5300 5317 5332 5368 5374 5409 5422 5444 5475 5504 5513 5588 5594 5644 5659 5684 5696 5728 5751 5763 5795 5800 5899 5939 5980 6027 6035 6100 6133 6152 6175 6181 6194 6214 6230 6236 6249 6255 6264 6337 6387 6420 6427 6443 6479 6490 6523 6537 6543 6569 6613 6618 6625
VJC	5295
VKG	1932 1960 6314 6342 6351 6389 6438 6468
WOW	5681 5733 6210 6232

(4) Configuration by MSN

MSN	CONFIGURATION
0764 0927	003
0870 1137 1150	002

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MSN	CONFIGURATION
1017 1276 1366 1403 1412 1417 1425 1431 1436 1442 1447 1451 1455 1462 1465 1472 1481 1492 1496 1499 1517 1519 1521 1525 1531 1536 1539 1607 1629 1651 1666 1701 1704 1707 1724 1763 1794 1798 1843 1881	001
1921 1932 1941 1946 1950 1960 1970 2060 2105 2211 2216 2234 2410 2476 2590 2707	008
2046 2403 2566	006
2246 2259 2280 2284 2286 2307 2314 2336 2352 2368 2384 2386 2415	004
3164 3199 3723 4117 4170 4199 4388 4795 5255 5386 5419 5568 5664 5690 5771 6069 6285	007
3584 3629 3633 3712 3740 3796 3858 3879 3881 3924 3928 3944 3960 3977 3989 3993 4025 4041 4044 4050 4067 4082 4107 4123 4134 4843 4847 4850 4885 4893 4898 4932 4935 4940 4957 4960 4966 5164 5235 5241 5244 5247 5269 5282 5292 5295 5300 5317 5332 5343 5368 5374 5409 5422 5427 5444 5469 5475 5504 5513 5538 5588 5594 5603 5644 5659 5681 5684 5696 5709 5728 5733 5751 5758 5763 5767 5774 5779 5783 5795 5800 5803 5834 5843 5854 5860 5865 5872 5884 5895 5899 5904 5909 5919 5922 5932 5938 5939 5946 5955 5960 5961 5966 5969 5975 5980 5983 5991 5994 6005 6016 6020 6027 6031 6035 6038 6046 6053 6056 6063 6067 6070 6083 6094 6100 6108 6114 6119 6122 6130 6133 6143 6152 6156 6162 6175 6181 6185 6194 6210 6214 6222 6227 6230 6232 6236 6238 6245 6249 6252 6255 6256 6264 6268 6271 6272 6279 6313 6314 6326 6334 6337 6342 6346 6351 6359 6376 6387 6389 6390 6401 6407 6420 6425 6427 6438 6443 6448 6459 6468 6472 6473 6479 6482 6490 6495 6512 6515 6520 6523 6526 6532 6537 6543 6548 6560 6569 6575 6590 6609 6613 6615 6618 6621 6625 6647 6650 6656 6663 6667 6687 6711 6723 6725 6745 6757 6761 6763 6768 6783 6790 6791 6796 6802 6809 6812 6828 6840 6853 6859 6863	009
3736 3804 3837 4081 4090 4296 4337 4339 4364 4408 4632 4780 4827 4860 4865 4955 5000 5171 5175 5223	005

(5) Configuration definition

**CONF 001
Config. 001 is valid for A321 aircraft given in the effectivity of this Service Bulletin that have embodied:
- Modification No. 28652K6153
OR have accomplished:
- Service Bulletin No. A320-28-1137
AND have not embodied:
- Modification No. 25713K4481
- Modification No. 26110K4482
- Modification No. 31020K7090
- Modification No. 31213K7089
- Modification No. 35081K9951
AND have not accomplished:
- Service Bulletin No. A320-28-1118

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- Service Bulletin No. A320-28-1145
- Service Bulletin No. A320-28-1225.

**CONF 002
Config. 002 is valid for A320 aircraft given in the effectivity of this Service Bulletin that have not embodied:
- Modification No. 28652K6153
- Modification No. 25713K4481
- Modification No. 26110K4482
- Modification No. 31020K7090
- Modification No. 31213K7089
- Modification No. 35081K9951

AND have not accomplished:
- Service Bulletin No. A320-28-1137
- Service Bulletin No. A320-28-1145
- Service Bulletin No. A320-28-1225

AND have accomplished
- Service Bulletin No. A320-28-1118.

**CONF 003
Config. 003 is valid for A320 aircraft given in the effectivity of this Service Bulletin that have embodied:
- Modification No. 25713K4481
- Modification No. 26110K4482

OR have accomplished:
- Service Bulletin No. A320-28-1225

AND have not embodied:
- Modification No. 28652K6153
- Modification No. 31020K7090
- Modification No. 31213K7089
- Modification No. 35081K9951

AND have not accomplished:
- Service Bulletin No. A320-28-1118
- Service Bulletin No. A320-28-1137
- Service Bulletin No. A320-28-1145.

**CONF 004
Config. 004 is valid for A320 aircraft given in the effectivity of this Service Bulletin that have embodied:
- Modification No. 25713K4481
- Modification No. 31020K7090

AND have not embodied:
- Modification No. 26110K4482
- Modification No. 28652K6153
- Modification No. 31213K7089
- Modification No. 35081K9951

AND have not accomplished:
- Service Bulletin No. A320-28-1118
- Service Bulletin No. A320-28-1137
- Service Bulletin No. A320-28-1145
- Service Bulletin No. A320-28-1225.

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**CONF 005
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- Modification No. 31020K7090
- Modification No. 35081K9951
AND have not embodied:
- Modification No. 26110K4482
- Modification No. 28652K6153
- Modification No. 31213K7089
AND have not accomplished:
- Service Bulletin No. A320-28-1118
- Service Bulletin No. A320-28-1137
- Service Bulletin No. A320-28-1145
- Service Bulletin No. A320-28-1225.

**CONF 006
Config. 006 is valid for A320 aircraft given in the effectivity of this Service Bulletin that have embodied:
- Modification No. 25713K4481
- Modification No. 26110K4482
OR have accomplished:
- Service Bulletin No. A320-28-1145
AND have embodied:
- Modification No. 31020K7090
AND have not embodied:
- Modification No. 28652K6153
- Modification No. 31213K7089
- Modification No. 35081K9951
AND have not accomplished:
- Service Bulletin No. A320-28-1118
- Service Bulletin No. A320-28-1137
- Service Bulletin No. A320-28-1225.

**CONF 007
Config. 007 is valid for A320 aircraft given in the effectivity of this Service Bulletin that have embodied:
- Modification No. 25713K4481
- Modification No. 26110K4482
- Modification No. 31020K7090
- Modification No. 35081K9951
AND have not embodied:
- Modification No. 28652K6153
- Modification No. 31213K7089
AND have not accomplished:
- Service Bulletin No. A320-28-1118
- Service Bulletin No. A320-28-1137
- Service Bulletin No. A320-28-1145
- Service Bulletin No. A320-28-1225.

**CONF 008
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- Modification No. 28652K6153
OR have accomplished:
- Service Bulletin No. A320-28-1137
AND have embodied:
- Modification No. 31213K7089
AND have not embodied:
- Modification No. 25713K4481
- Modification No. 26110K4482
- Modification No. 31020K7090
- Modification No. 35081K9951
AND have not accomplished:
- Service Bulletin No. A320-28-1118
- Service Bulletin No. A320-28-1145
- Service Bulletin No. A320-28-1225.

**CONF 009
Config. 009 is valid for A321 aircraft given in the effectivity of this Service Bulletin that have embodied:
- Modification No. 28652K6153
- Modification No. 31213K7089
- Modification No. 35081K9951
AND have not embodied:
- Modification No. 25713K4481
- Modification No. 26110K4482
- Modification No. 31020K7090
AND have not accomplished:
- Service Bulletin No. A320-28-1118
- Service Bulletin No. A320-28-1137
- Service Bulletin No. A320-28-1145
- Service Bulletin No. A320-28-1225.

(6) Material Effectivity

**CONF 001

MATERIAL	QTY PER A/C	SEE NOTES
Kit 531364D01R05	1	
Consumable CMLD01	1	
Standard tool TOOLD01	1	
Standard tool TOOLD02	1	

**CONF 002

MATERIAL	QTY PER A/C	SEE NOTES
Kit 531364D02R04	1	
Consumable CMLD01	1	
Standard tool TOOLD01	1	
Standard tool TOOLD02	1	

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**CONF 003

MATERIAL	QTY PER A/C	SEE NOTES
Kit 531364D03R03	1	
Consumable CMLD01	1	
Standard tool TOOLD01	1	
Standard tool TOOLD02	1	

**CONF 004

MATERIAL	QTY PER A/C	SEE NOTES
Kit 531364D04R04	1	
Consumable CMLD01	1	
Standard tool TOOLD01	1	
Standard tool TOOLD02	1	

**CONF 005

MATERIAL	QTY PER A/C	SEE NOTES
Kit 531364D05R05	1	
Consumable CMLD01	1	
Standard tool TOOLD01	1	
Standard tool TOOLD02	1	

**CONF 006

MATERIAL	QTY PER A/C	SEE NOTES
Kit 531364D06R06	1	
Consumable CMLD01	1	
Standard tool TOOLD01	1	
Standard tool TOOLD02	1	

**CONF 007

MATERIAL	QTY PER A/C	SEE NOTES
Kit 531364D07R06	1	
Consumable CMLD01	1	
Standard tool TOOLD01	1	
Standard tool TOOLD02	1	

**CONF 008

MATERIAL	QTY PER A/C	SEE NOTES
Kit 531364D08R04	1	
Consumable CMLD01	1	
Standard tool TOOLD01	1	
Standard tool TOOLD02	1	

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**CONF 009

MATERIAL	QTY PER A/C	SEE NOTES
Kit 531364D09R04	1	
Consumable CMLD01	1	
Standard tool TOOLD01	1	
Standard tool TOOLD02	1	

**CONF ALL

B. CONCURRENT REQUIREMENTS

None

C. REASON

(1) History

As a result of fatigue tests for the A320 aircraft, shear webs and some frame clips must be replaced in the aft lower fuselage.

(2) Objective/Action

This Service Bulletin gives the procedure to replace the existing shear webs and several frame clips. For each replaced frame clip one additional support angle is added for the structure support between frame and related stringer. Additionally one tack hole and one tooling hole in each frame is cold expanded to increase the fatigue life of the frames.

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 department for further instructions.

(3) Advantages

The accomplishment of this Service Bulletin cancels the inspection requirements of Service Bulletin No. A320-53-1257.

(4) Operational/Maintenance Consequences

The Operational/Maintenance Consequences of this Service Bulletin are covered by the update of the affected publications detailed in 'PLANNING INFORMATION'.

D. DESCRIPTION

To accomplish this Service Bulletin it is necessary to :

**CONF 001

Task 531364-831-848-001: Modification

(1) Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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(2) Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63

(3) Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH

(4) Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH

(5) Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH

(6) Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH

(7) Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH

(8) Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH

(9) Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH

(10) Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH

(11) Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH

(12) Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH

(13) Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH

(14) Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH

(15) Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH

(16) Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH

(17) Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

(18) Install new Surface Protection on Frame 50 thru Frame 63

****CONF 002**

Task 531364-831-848-001: Modification

(1) Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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(2) Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63

(3) Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH

(4) Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH

(5) Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH

(6) Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH

(7) Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH

(8) Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH

(9) Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH

(10) Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH

(11) Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH

(12) Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH

(13) Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH

(14) Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH

(15) Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH

(16) Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH

(17) Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

(18) Install new Surface Protection on Frame 50 thru Frame 63

****CONF 003**

Task 531364-831-848-001: Modification

(1) Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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(2) Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63

(3) Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH

(4) Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH

(5) Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH

(6) Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH

(7) Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH

(8) Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH

(9) Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH

(10) Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH

(11) Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH

(12) Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH

(13) Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH

(14) Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH

(15) Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH

(16) Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH

(17) Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

(18) Install new Surface Protection on Frame 50 thru Frame 63

****CONF 004**

Task 531364-831-848-001: Modification

(1) Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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(2) Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63

(3) Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH

(4) Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH

(5) Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH

(6) Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH

(7) Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH

(8) Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH

(9) Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH

(10) Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH

(11) Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH

(12) Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH

(13) Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH

(14) Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH

(15) Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH

(16) Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH

(17) Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

(18) Install new Surface Protection on Frame 50 thru Frame 63

****CONF 005**

Task 531364-831-848-001: Modification

(1) Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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(2) Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63

(3) Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH

(4) Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH

(5) Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH

(6) Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH

(7) Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH

(8) Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH

(9) Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH

(10) Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH

(11) Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH

(12) Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH

(13) Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH

(14) Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH

(15) Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH

(16) Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH

(17) Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

(18) Install new Surface Protection on Frame 50 thru Frame 63

****CONF 006**

Task 531364-831-848-001: Modification

(1) Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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(2) Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63

(3) Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH

(4) Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH

(5) Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH

(6) Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH

(7) Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH

(8) Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH

(9) Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH

(10) Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH

(11) Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH

(12) Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH

(13) Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH

(14) Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH

(15) Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH

(16) Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH

(17) Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

(18) Install new Surface Protection on Frame 50 thru Frame 63

****CONF 007**

Task 531364-831-848-001: Modification

(1) Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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(2) Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63

(3) Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH

(4) Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH

(5) Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH

(6) Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH

(7) Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH

(8) Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH

(9) Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH

(10) Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH

(11) Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH

(12) Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH

(13) Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH

(14) Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH

(15) Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH

(16) Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH

(17) Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

(18) Install new Surface Protection on Frame 50 thru Frame 63

****CONF 008**

Task 531364-831-848-001: Modification

(1) Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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(2) Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63

(3) Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH

(4) Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH

(5) Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH

(6) Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH

(7) Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH

(8) Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH

(9) Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH

(10) Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH

(11) Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH

(12) Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH

(13) Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH

(14) Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH

(15) Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH

(16) Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH

(17) Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

(18) Install new Surface Protection on Frame 50 thru Frame 63

****CONF 009**

Task 531364-831-848-001: Modification

(1) Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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(2) Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63

(3) Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH

(4) Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH

(5) Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH

(6) Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH

(7) Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH

(8) Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH

(9) Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH

(10) Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH

(11) Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH

(12) Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH

(13) Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH

(14) Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH

(15) Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH

(16) Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH

(17) Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

(18) Install new Surface Protection on Frame 50 thru Frame 63

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**CONF ALL

E. COMPLIANCE

(1) Classification

MANDATORY: Service Bulletin must be accomplished.

(2) Accomplishment Timescale

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

F. APPROVAL

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

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

G. MANPOWER

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

**CONF 001

Task 531364-831-848-001: Modification	
Get Access	19.00
On Aircraft	
Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63	4.50
Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63	5.00
Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH	15.25

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Task 531364-831-848-001: Modification	
Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH	15.25
Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63	6.50
Install new Surface Protection on Frame 50 thru Frame 63	3.00
Close-Up	22.50
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

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

****CONF 002**

Task 531364-831-848-001: Modification	
Get Access	19.00
On Aircraft	
Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63	4.50
Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63	5.00
Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH	15.25

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Task 531364-831-848-001: Modification	
Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH	15.25
Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63	6.50
Install new Surface Protection on Frame 50 thru Frame 63	3.00
Close-Up	22.50
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

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

****CONF 003**

Task 531364-831-848-001: Modification	
Get Access	19.00
On Aircraft	
Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63	4.50
Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63	5.00
Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH	15.25

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Task 531364-831-848-001: Modification	
Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH	15.25
Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63	6.50
Install new Surface Protection on Frame 50 thru Frame 63	3.00
Close-Up	22.50
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

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

****CONF 004**

Task 531364-831-848-001: Modification	
Get Access	19.00
On Aircraft	
Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63	4.50
Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63	5.00
Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH	15.25

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Task 531364-831-848-001: Modification	
Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH	15.25
Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63	6.50
Install new Surface Protection on Frame 50 thru Frame 63	3.00
Close-Up	22.50
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

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

****CONF 005**

Task 531364-831-848-001: Modification	
Get Access	19.00
On Aircraft	
Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63	4.50
Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63	5.00
Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH	15.25

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Task 531364-831-848-001: Modification	
Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH	15.25
Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63	6.50
Install new Surface Protection on Frame 50 thru Frame 63	3.00
Close-Up	22.50
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

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

****CONF 006**

Task 531364-831-848-001: Modification	
Get Access	19.00
On Aircraft	
Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63	4.50
Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63	5.00

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Task 531364-831-848-001: Modification	
Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH	15.25
Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63	6.50
Install new Surface Protection on Frame 50 thru Frame 63	3.00
Close-Up	22.50
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

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

****CONF 007**

Task 531364-831-848-001: Modification	
Get Access	19.00
On Aircraft	
Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63	4.50

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Task 531364-831-848-001: Modification	
Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63	5.00
Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH	15.25
Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63	6.50
Install new Surface Protection on Frame 50 thru Frame 63	3.00
Close-Up	22.50
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

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

****CONF 008**

Task 531364-831-848-001: Modification	
Get Access	19.00
On Aircraft	

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Task 531364-831-848-001: Modification	
Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63	4.50
Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63	5.00
Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH	15.25
Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63	6.50
Install new Surface Protection on Frame 50 thru Frame 63	3.00
Close-Up	22.50
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

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

****CONF 009**

Task 531364-831-848-001: Modification	
Get Access	19.00

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Task 531364-831-848-001: Modification	
On Aircraft	
Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63	4.50
Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63	5.00
Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH	15.25
Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH	15.25
Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63	6.50
Install new Surface Protection on Frame 50 thru Frame 63	3.00
Close-Up	22.50
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

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

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**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	+2.4 KG	(+5.3 LB)
Effect on Balance	+80.3 KGM	(+580.8 LB.FT)

**CONF 002

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	+2.4 KG	(+5.3 LB)
Effect on Balance	+62.6 KGM	(+452.8 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).

Manufacturers Empty Weight	+2.5 KG	(+5.5 LB)
Effect on Balance	+65.2 KGM	(+471.6 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).

Manufacturers Empty Weight	+2.5 KG	(+5.5 LB)
Effect on Balance	+66.1 KGM	(+478.1 LB.FT)

**CONF 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).

Manufacturers Empty Weight	+2.9 KG	(+6.4 LB)
Effect on Balance	+77.9 KGM	(+563.5 LB.FT)

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**CONF 006

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	+2.6 KG	(+5.7 LB)
Effect on Balance	+69.7 KGM	(+504.1 LB.FT)

**CONF 007

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	+3.0 KG	(+6.6 LB)
Effect on Balance	+80.6 KGM	(+583.0 LB.FT)

**CONF 008

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	+2.5 KG	(+5.5 LB)
Effect on Balance	+84.4 KGM	(+610.5 LB.FT)

**CONF 009

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	+3.0 KG	(+6.6 LB)
Effect on Balance	+99.7 KGM	(+721.1 LB.FT)

**CONF ALL

I. ELECTRICAL LOAD DATA

Not Changed

J. REFERENCES

**CONF 001

Aircraft Maintenance Manual (AMM)	06-20-00 12-34-24 25-52-22 25-55-17 52-30-00 53-42-17	06-31-53 21-20-00 25-52-44 25-80-00 53-35-13	06-41-53 24-41-00 25-55-12 28-11-27 53-42-14
Consumable Material List (CML)			

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Elec. Std. Practices Manual (ESPM)	20-55-00
In Service Information (ISI)	ISI 51.48.00001
Non Destructive Test Manual (NTM)	51-10-01
Service Bulletin (SB)	A320-53-1257
Standards Manual (SM)	
Structural Repair Manual (SRM)	51-21-00 51-23-12 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-48-00 51-75-12 51-76-00 51-78-00 53-41-14
Weight and Balance Manual (WBM)	

****CONF 002**

Aircraft Maintenance Manual (AMM)	06-20-00 06-31-53 06-41-53 12-34-24 21-20-00 24-41-00 25-52-22 25-52-44 25-55-12 25-55-17 25-80-00 28-11-27 52-30-00 53-35-13 53-42-14 53-42-17
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
Service Bulletin (SB)	A320-53-1257
Standards Manual (SM)	
Structural Repair Manual (SRM)	51-21-00 51-23-12 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-48-00 51-75-12 51-76-00 51-78-00 53-41-14
Weight and Balance Manual (WBM)	

****CONF 003**

Aircraft Maintenance Manual (AMM)	06-20-00 06-31-53 06-41-53 12-34-24 21-20-00 24-41-00 25-52-22 25-52-44 25-55-12 25-55-17 25-80-00 28-11-27 52-30-00 53-35-13 53-42-14 53-42-17
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
Service Bulletin (SB)	A320-53-1257
Standards Manual (SM)	
Structural Repair Manual (SRM)	51-21-00 51-23-12 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-48-00 51-75-12 51-76-00 51-78-00 53-41-14
Weight and Balance Manual (WBM)	

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**CONF 004

Aircraft Maintenance Manual (AMM)	06-20-00 12-34-24 25-52-22 25-55-17 52-30-00 53-42-17	06-31-53 21-20-00 25-52-44 25-80-00 53-35-13	06-41-53 24-41-00 25-55-12 28-11-27 53-42-14
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		
Service Bulletin (SB)	A320-53-1257		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-21-00 51-40-00 51-44-00 51-76-00	51-23-12 51-42-00 51-48-00 51-78-00	51-24-00 51-43-00 51-75-12 53-41-14
Weight and Balance Manual (WBM)			

**CONF 005

Aircraft Maintenance Manual (AMM)	06-20-00 12-34-24 25-52-22 25-55-17 52-30-00 53-42-17	06-31-53 21-20-00 25-52-44 25-80-00 53-35-13	06-41-53 24-41-00 25-55-12 28-11-27 53-42-14
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		
Service Bulletin (SB)	A320-53-1257		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-21-00 51-40-00 51-44-00 51-76-00	51-23-12 51-42-00 51-48-00 51-78-00	51-24-00 51-43-00 51-75-12 53-41-14
Weight and Balance Manual (WBM)			

**CONF 006

Aircraft Maintenance Manual (AMM)	06-20-00 12-34-24 25-52-22 25-55-17 52-30-00 53-42-17	06-31-53 21-20-00 25-52-44 25-80-00 53-35-13	06-41-53 24-41-00 25-55-12 28-11-27 53-42-14
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		
Service Bulletin (SB)	A320-53-1257		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-21-00 51-40-00 51-44-00 51-76-00	51-23-12 51-42-00 51-48-00 51-78-00	51-24-00 51-43-00 51-75-12 53-41-14
Weight and Balance Manual (WBM)			

****CONF 007**

Aircraft Maintenance Manual (AMM)	06-20-00 12-34-24 25-52-22 25-55-17 52-30-00 53-42-17	06-31-53 21-20-00 25-52-44 25-80-00 53-35-13	06-41-53 24-41-00 25-55-12 28-11-27 53-42-14
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		
Service Bulletin (SB)	A320-53-1257		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-21-00 51-40-00 51-44-00 51-76-00	51-23-12 51-42-00 51-48-00 51-78-00	51-24-00 51-43-00 51-75-12 53-41-14
Weight and Balance Manual (WBM)			

****CONF 008**

Aircraft Maintenance Manual (AMM)	06-20-00 12-34-24 25-52-22 25-55-17 52-30-00 53-42-17	06-31-53 21-20-00 25-52-44 25-80-00 53-35-13	06-41-53 24-41-00 25-55-12 28-11-27 53-42-14
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		
Service Bulletin (SB)	A320-53-1257		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-21-00 51-40-00 51-44-00 51-76-00	51-23-12 51-42-00 51-48-00 51-78-00	51-24-00 51-43-00 51-75-12 53-41-14
Weight and Balance Manual (WBM)			

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**CONF 009

Aircraft Maintenance Manual (AMM)	06-20-00 12-34-24 25-52-22 25-55-17 52-30-00 53-42-17	06-31-53 21-20-00 25-52-44 25-80-00 53-35-13	06-41-53 24-41-00 25-55-12 28-11-27 53-42-14
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		
Service Bulletin (SB)	A320-53-1257		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-21-00 51-40-00 51-44-00 51-76-00	51-23-12 51-42-00 51-48-00 51-78-00	51-24-00 51-43-00 51-75-12 53-41-14
Weight and Balance Manual (WBM)			

**CONF ALL

K. PUBLICATION AFFECTED

Maintenance Planning Document (MPD)	531257-01-1	
Structural Repair Manual (SRM)	53-41-12	53-41-89

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

NOTE:

For operators embodying Service Bulletin A320-53-1364 as a concurrent requirement of Service Bulletin A320-02-1001 (ESG 'Extended Service Goal' package):

The AIRBUS material is included in the commercial offer of the Letter Agreement, and as such will be supplied by AIRBUS Upgrade Services. To facilitate the material reception, Airline Customers are requested to send a Customer Purchase Order to:

Kit 531364D01R05 Kit 531364D02R04 Kit 531364D03R03 Kit 531364D04R04 Kit 531364D05R05 Kit 531364D06R06 Kit 531364D07R06 Kit 531364D08R04 Kit 531364D09R04	AIRBUS Upgrade Services Attn. Sales Manager

NOTE:

For operators embodying Service Bulletin A320-53-1364 as a stand-alone Service Bulletin (outside the ESG 'Extended Service Goal' package):

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 531364D01R05 Kit 531364D02R04 Kit 531364D03R03 Kit 531364D04R04 Kit 531364D05R05 Kit 531364D06R06 Kit 531364D07R06 Kit 531364D08R04 Kit 531364D09R04	AIRBUS Material, Logistics and Suppliers ATP II B Hein-Sass-Weg 24 D-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 51660

(2) Price and Availability

Kit 531364D01R05	
Cost	9,500.00 USD
Availability	300 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 AIRBUS Spares portal or through a request for quotation to airbus.kit@airbus.com.

Kit 531364D02R04	
Cost	11,000.00 USD
Availability	300 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 AIRBUS Spares portal or through a request for quotation to airbus.kit@airbus.com.

Kit 531364D03R03	
Cost	11,500.00 USD
Availability	300 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 AIRBUS Spares portal or through a request for quotation to airbus.kit@airbus.com.

Kit 531364D04R04	
Cost	13,500.00 USD
Availability	300 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 AIRBUS Spares portal or through a request for quotation to airbus.kit@airbus.com.

Kit 531364D05R05	
Cost	14,000.00 USD
Availability	300 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 AIRBUS Spares portal or through a request for quotation to airbus.kit@airbus.com.

Kit 531364D06R06	
Cost	14,500.00 USD
Availability	300 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 AIRBUS Spares portal or through a request for quotation to airbus.kit@airbus.com.

Kit 531364D07R06	
Cost	15,000.00 USD
Availability	300 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 AIRBUS Spares portal or through a request for quotation to airbus.kit@airbus.com.

Kit 531364D08R04	
Cost	12,500.00 USD
Availability	300 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 AIRBUS Spares portal or through a request for quotation to airbus.kit@airbus.com.

Kit 531364D09R04	
Cost	13,000.00 USD
Availability	300 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 AIRBUS Spares portal or through a request for quotation to airbus.kit@airbus.com.

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B. INDUSTRY SUPPORT INFORMATION

For operators embodying Service Bulletin A320-53-1364 as a stand-alone Service Bulletin (outside the ESG 'Extended Service Goal' package), as a special policy applied to this Service Bulletin, AIRBUS will provide a 15% reduction to the applicable kits sales prices given in the paragraph 'Price and Availability' for orders placed before May 31/23.

C. LIST OF COMPONENTS

Kit 531364D01R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	E5347001120000	7	ANGLE				
2	E5347001120200	6	ANGLE				
4	E5347001024400	2	WEB				
6	E5347001023600	1	WEB				
8	E5347001027400	1	WEB				
10	E5347001023400	1	WEB				
12	E5347001020800	1	WEB				
14	E5347001021000	1	WEB				
16	E5347001120400	1	ANGLE				
18	E5347001021200	1	WEB				
20	E5347001123800	1	ANGLE				
22	E5347001021400	1	WEB				
24	E5347001120600	1	ANGLE				
26	E5347001120800	1	ANGLE				
28	E5347001021600	1	WEB				
30	E5347001121000	1	ANGLE				
32	E5347001121200	1	ANGLE				
34	E5347001021800	1	WEB				
38	E5347001121600	1	ANGLE				
40	E5347001121800	1	ANGLE				
42	E5347001022000	1	WEB				
44	E5347001122000	1	ANGLE				
46	E5347001122200	1	ANGLE				
48	E5347001122400	1	ANGLE				
50	E5347001022200	1	WEB				
52	E5347001122600	1	ANGLE				
54	E5347001122800	1	ANGLE				
56	E5347001123000	1	ANGLE				
58	E5347001123200	1	ANGLE				
60	E5347001022400	1	WEB				
62	E5347001123400	1	ANGLE				
64	E5347001123600	2	ANGLE				
65	E5347001420200	1	ANGLE				
66	E5347001420000	1	ANGLE				
363	EN6115K3-3	61	BOLT				
364	EN6115K3-4	41	BOLT				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
365	EN6115K3-5	27	BOLT				
373	EN6115K3A3	2	BOLT				
374	EN6115K3A4	10	BOLT				
375	EN6115K3A5	2	BOLT				
463	EN6114K3-3	11	BOLT				
544	EN6069D4-04	14	RIVET				
555	EN6069D5-05	18	RIVET				
556	EN6069D5-06	12	RIVET				
567	EN6069D6-07	220	RIVET				
655	EN6081D5-05	39	RIVET				
656	EN6081D5-06	396	RIVET				
657	EN6081D5-07	98	RIVET				
666	EN6081D6-06	147	RIVET				
667	EN6081D6-07	90	RIVET				
668	EN6081D6-08	197	RIVET				(1)
669	EN6081D6-09	82	RIVET				(2)
670	EN6081D7-10	4	RIVET				
678	EN6081D7-08	6	RIVET				
763	DAN5-6-3X	4	PIN				
764	DAN5-6-4X	105	PIN				
765	DAN5-6-5X	55	PIN				
766	DAN5-6-6X	25	PIN				
767	DAN5-6-7X	4	PIN				
768	DAN5-6-8X	5	PIN				
806	NSA5075-6	248	COLLAR				
807	DAN11-6X	208	COLLAR				
808	ASNA2528-3	140	NUT				
863	DAN6-6-3	125	PIN				
864	DAN6-6-4	10	PIN				
865	DAN6-6-5	16	PIN				
866	DAN6-6-6	6	PIN				
875	DAN6-6-5X	4	PIN				
876	DAN6-6-6X	3	PIN				
877	DAN6-6-7X	3	PIN				
908	ASNA2528-3A	14	NUT				
963	DAN5-6-3	53	PIN				
964	DAN5-6-4	27	PIN				
965	DAN5-6-5	11	PIN				

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

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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Kit 531364D02R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	E5347001120000	7	ANGLE				
2	E5347001120200	6	ANGLE				
4	E5347001024400	2	WEB				
6	E5347001023600	1	WEB				
8	E5347001027400	1	WEB				
10	E5347001023400	1	WEB				
12	E5347001020800	1	WEB				
14	E5347001021000	1	WEB				
16	E5347001120400	1	ANGLE				
18	E5347001021200	1	WEB				
20	E5347001123800	1	ANGLE				
22	E5347001021400	1	WEB				
24	E5347001120600	1	ANGLE				
26	E5347001120800	1	ANGLE				
28	E5347001021600	1	WEB				
30	E5347001121000	1	ANGLE				
32	E5347001121200	1	ANGLE				
34	E5347001021800	1	WEB				
38	E5347001121600	1	ANGLE				
40	E5347001121800	1	ANGLE				
42	E5347001022000	1	WEB				
44	E5347001122000	1	ANGLE				
46	E5347001122200	1	ANGLE				
48	E5347001122400	1	ANGLE				
50	E5347001022200	1	WEB				
52	E5347001122600	1	ANGLE				
54	E5347001122800	1	ANGLE				
56	E5347001123000	1	ANGLE				
58	E5347001123200	1	ANGLE				
60	E5347001022400	1	WEB				
62	E5347001123400	1	ANGLE				
64	E5347001123600	2	ANGLE				
65	E5347001420200	2	ANGLE				
66	E5347001420000	2	ANGLE				
68	E5347001420400	1	ANGLE				
80	E5347001420600	1	ANGLE				
82	E5347001420800	1	ANGLE				
84	E5347001421000	1	ANGLE				
363	EN6115K3-3	61	BOLT				
364	EN6115K3-4	41	BOLT				
365	EN6115K3-5	27	BOLT				
373	EN6115K3A3	2	BOLT				
374	EN6115K3A4	10	BOLT				
375	EN6115K3A5	2	BOLT				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
463	EN6114K3-3	9	BOLT				
544	EN6069D4-04	4	RIVET				
545	EN6069D4-05	52	RIVET				
555	EN6069D5-05	18	RIVET				
556	EN6069D5-06	12	RIVET				
567	EN6069D6-07	216	RIVET				
568	EN6069D6-08	2	RIVET				
655	EN6081D5-05	15	RIVET				
656	EN6081D5-06	452	RIVET				
657	EN6081D5-07	111	RIVET				
666	EN6081D6-06	150	RIVET				
667	EN6081D6-07	90	RIVET				
668	EN6081D6-08	229	RIVET				(1)
669	EN6081D6-09	80	RIVET				(2)
670	EN6081D7-10	4	RIVET				
678	EN6081D7-08	6	RIVET				
763	DAN5-6-3X	6	PIN				
764	DAN5-6-4X	101	PIN				
765	DAN5-6-5X	56	PIN				
766	DAN5-6-6X	26	PIN				
767	DAN5-6-7X	4	PIN				
768	DAN5-6-8X	4	PIN				
784	DAN5-6-4Y	4	PIN				
785	DAN5-6-5Y	11	PIN				
786	DAN5-6-6Y	10	PIN				
806	NSA5075-6	199	COLLAR				
807	DAN11-6X	192	COLLAR				
808	ASNA2528-3	138	NUT				
809	DAN11-6Y	34	COLLAR				
863	DAN6-6-3	76	PIN				
864	DAN6-6-4	8	PIN				
865	DAN6-6-5	16	PIN				
866	DAN6-6-6	6	PIN				
885	DAN6-6-5Y	4	PIN				
886	DAN6-6-6Y	3	PIN				
887	DAN6-6-7Y	3	PIN				
908	ASNA2528-3A	14	NUT				
963	DAN5-6-3	55	PIN				
964	DAN5-6-4	27	PIN				
965	DAN5-6-5	11	PIN				

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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NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

Kit 531364D03R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	E5347001120000	7	ANGLE				
2	E5347001120200	6	ANGLE				
4	E5347001024400	2	WEB				
6	E5347001024600	1	WEB				
8	E5347001027400	1	WEB				
10	E5347001025000	1	WEB				
12	E5347001020800	1	WEB				
14	E5347001021000	1	WEB				
16	E5347001120400	1	ANGLE				
18	E5347001021200	1	WEB				
20	E5347001123800	1	ANGLE				
22	E5347001021400	1	WEB				
24	E5347001120600	1	ANGLE				
26	E5347001120800	1	ANGLE				
28	E5347001021600	1	WEB				
30	E5347001121000	1	ANGLE				
32	E5347001121200	1	ANGLE				
34	E5347001021800	1	WEB				
38	E5347001121600	1	ANGLE				
40	E5347001121800	1	ANGLE				
42	E5347001022000	1	WEB				
44	E5347001122000	1	ANGLE				
46	E5347001122200	1	ANGLE				
48	E5347001122400	1	ANGLE				
50	E5347001022200	1	WEB				
52	E5347001122600	1	ANGLE				
54	E5347001122800	1	ANGLE				
56	E5347001123000	1	ANGLE				
58	E5347001123200	1	ANGLE				
60	E5347001022400	1	WEB				
62	E5347001123400	1	ANGLE				
64	E5347001123600	2	ANGLE				
65	E5347001420200	3	ANGLE				
66	E5347001420000	2	ANGLE				
67	E5347001421200	1	ANGLE				
68	E5347001421400	1	ANGLE				
80	E5347001421600	1	ANGLE				
82	E5347001421800	1	ANGLE				
84	E5347001422000	1	ANGLE				
363	EN6115K3-3	58	BOLT				
364	EN6115K3-4	26	BOLT				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
365	EN6115K3-5	30	BOLT				
373	EN6115K3A3	5	BOLT				
374	EN6115K3A4	22	BOLT				
375	EN6115K3A5	5	BOLT				
463	EN6114K3-3	8	BOLT				
544	EN6069D4-04	4	RIVET				
545	EN6069D4-05	52	RIVET				
555	EN6069D5-05	18	RIVET				
556	EN6069D5-06	12	RIVET				
567	EN6069D6-07	211	RIVET				
568	EN6069D6-08	2	RIVET				
655	EN6081D5-05	15	RIVET				
656	EN6081D5-06	452	RIVET				
657	EN6081D5-07	112	RIVET				
666	EN6081D6-06	135	RIVET				
667	EN6081D6-07	150	RIVET				
668	EN6081D6-08	179	RIVET				(1)
669	EN6081D6-09	56	RIVET				(2)
670	EN6081D7-10	4	RIVET				
678	EN6081D7-08	6	RIVET				
763	DAN5-6-3X	4	PIN				
764	DAN5-6-4X	128	PIN				
765	DAN5-6-5X	96	PIN				
766	DAN5-6-6X	30	PIN				
767	DAN5-6-7X	10	PIN				
768	DAN5-6-8X	10	PIN				
784	DAN5-6-4Y	6	PIN				
785	DAN5-6-5Y	18	PIN				
786	DAN5-6-6Y	9	PIN				
806	NSA5075-6	176	COLLAR				
807	DAN11-6X	303	COLLAR				
808	ASNA2528-3	119	NUT				
809	DAN11-6Y	43	COLLAR				
863	DAN6-6-3	55	PIN				
864	DAN6-6-4	8	PIN				
865	DAN6-6-5	16	PIN				
866	DAN6-6-6	6	PIN				
873	DAN6-6-3X	25	PIN				
885	DAN6-6-5Y	4	PIN				
886	DAN6-6-6Y	3	PIN				
887	DAN6-6-7Y	3	PIN				
908	ASNA2528-3A	32	NUT				
963	DAN5-6-3	55	PIN				
964	DAN5-6-4	25	PIN				
965	DAN5-6-5	11	PIN				

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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.

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

Kit 531364D04R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	E5347001120000	7	ANGLE				
2	E5347001120200	6	ANGLE				
4	E5347001024400	2	WEB				
6	E5347001023600	1	WEB				
8	E5347001027400	1	WEB				
10	E5347001023400	1	WEB				
12	E5347001020800	1	WEB				
14	E5347001021000	1	WEB				
16	E5347001120400	1	ANGLE				
18	E5347001021200	1	WEB				
20	E5347001123800	1	ANGLE				
22	E5347001021400	1	WEB				
24	E5347001120600	1	ANGLE				
26	E5347001120800	1	ANGLE				
28	E5347001021600	1	WEB				
30	E5347001121000	1	ANGLE				
32	E5347001121200	1	ANGLE				
34	E5347001021800	1	WEB				
36	E5347001124200	7	ANGLE				
38	E5347001121600	1	ANGLE				
40	E5347001121800	1	ANGLE				
42	E5347001022000	1	WEB				
44	E5347001122000	1	ANGLE				
46	E5347001122200	1	ANGLE				
48	E5347001122400	1	ANGLE				
50	E5347001022200	1	WEB				
52	E5347001122600	1	ANGLE				
54	E5347001122800	1	ANGLE				
56	E5347001123000	1	ANGLE				
58	E5347001123200	1	ANGLE				
60	E5347001022400	1	WEB				
62	E5347001123400	1	ANGLE				
64	E5347001123600	2	ANGLE				
65	E5347001420200	2	ANGLE				
66	E5347001420000	2	ANGLE				
68	E5347001420400	1	ANGLE				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
70	E5347001124400	1	ANGLE				
72	E5347001124600	1	ANGLE				
74	E5347001124800	1	ANGLE				
76	E5347001125000	1	ANGLE				
78	E5347001125200	1	ANGLE				
80	E5347001420600	1	ANGLE				
82	E5347001420800	1	ANGLE				
84	E5347001421000	1	ANGLE				
363	EN6115K3-3	63	BOLT				
364	EN6115K3-4	41	BOLT				
365	EN6115K3-5	24	BOLT				
373	EN6115K3A3	2	BOLT				
374	EN6115K3A4	10	BOLT				
375	EN6115K3A5	2	BOLT				
463	EN6114K3-3	11	BOLT				
544	EN6069D4-04	4	RIVET				
545	EN6069D4-05	52	RIVET				
555	EN6069D5-05	22	RIVET				
556	EN6069D5-06	21	RIVET				
567	EN6069D6-07	216	RIVET				
568	EN6069D6-08	2	RIVET				
655	EN6081D5-05	15	RIVET				
656	EN6081D5-06	452	RIVET				
657	EN6081D5-07	113	RIVET				
666	EN6081D6-06	151	RIVET				
667	EN6081D6-07	91	RIVET				
668	EN6081D6-08	231	RIVET				(1)
669	EN6081D6-09	80	RIVET				(2)
670	EN6081D7-10	4	RIVET				
678	EN6081D7-08	6	RIVET				
763	DAN5-6-3X	4	PIN				
764	DAN5-6-4X	101	PIN				
765	DAN5-6-5X	56	PIN				
766	DAN5-6-6X	23	PIN				
767	DAN5-6-7X	4	PIN				
768	DAN5-6-8X	3	PIN				
784	DAN5-6-4Y	2	PIN				
785	DAN5-6-5Y	12	PIN				
786	DAN5-6-6Y	10	PIN				
806	NSA5075-6	201	COLLAR				
807	DAN11-6X	190	COLLAR				
808	ASNA2528-3	142	NUT				
809	DAN11-6Y	34	COLLAR				
863	DAN6-6-3	80	PIN				
864	DAN6-6-4	8	PIN				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
865	DAN6-6-5	16	PIN				
866	DAN6-6-6	6	PIN				
875	DAN6-6-5X	2	PIN				
885	DAN6-6-5Y	4	PIN				
886	DAN6-6-6Y	3	PIN				
887	DAN6-6-7Y	3	PIN				
908	ASNA2528-3A	14	NUT				
963	DAN5-6-3	53	PIN				
964	DAN5-6-4	27	PIN				
965	DAN5-6-5	11	PIN				

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

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

Kit 531364D05R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	E5347001120000	8	ANGLE				
2	E5347001120200	7	ANGLE				
4	E5347001024400	2	WEB				
6	E5347001023800	1	WEB				
8	E5347001027400	1	WEB				
10	E5347001025200	1	WEB				
12	E5347001025400	1	WEB				
14	E5347001024000	1	WEB				
18	E5347001025600	1	WEB				
20	E5347001123800	1	ANGLE				
22	E5347001025800	1	WEB				
24	E5347001120600	1	ANGLE				
26	E5347001120800	1	ANGLE				
28	E5347001026000	1	WEB				
30	E5347001121000	1	ANGLE				
32	E5347001121200	1	ANGLE				
34	E5347001024200	1	WEB				
36	E5347001124200	7	ANGLE				
38	E5347001121600	1	ANGLE				
40	E5347001121800	1	ANGLE				
42	E5347001022000	1	WEB				
44	E5347001122000	1	ANGLE				
46	E5347001122200	1	ANGLE				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
48	E5347001122400	1	ANGLE				
50	E5347001022200	1	WEB				
52	E5347001122600	1	ANGLE				
54	E5347001122800	1	ANGLE				
56	E5347001123000	1	ANGLE				
58	E5347001123200	1	ANGLE				
60	E5347001022400	1	WEB				
62	E5347001123400	1	ANGLE				
64	E5347001123600	2	ANGLE				
65	E5347001420200	2	ANGLE				
66	E5347001420000	2	ANGLE				
68	E5347001420400	1	ANGLE				
70	E5347001124400	1	ANGLE				
72	E5347001124600	1	ANGLE				
74	E5347001124800	1	ANGLE				
76	E5347001125000	1	ANGLE				
78	E5347001125200	1	ANGLE				
80	E5347001420600	1	ANGLE				
82	E5347001420800	1	ANGLE				
84	E5347001421000	1	ANGLE				
86	E5347001125600	1	ANGLE				
88	E5347001125400	1	ANGLE				
363	EN6115K3-3	61	BOLT				
364	EN6115K3-4	41	BOLT				
365	EN6115K3-5	27	BOLT				
373	EN6115K3A3	1	BOLT				
374	EN6115K3A4	11	BOLT				
375	EN6115K3A5	1	BOLT				
463	EN6114K3-3	11	BOLT				
544	EN6069D4-04	4	RIVET				
545	EN6069D4-05	52	RIVET				
555	EN6069D5-05	24	RIVET				
556	EN6069D5-06	22	RIVET				
567	EN6069D6-07	216	RIVET				
568	EN6069D6-08	2	RIVET				
655	EN6081D5-05	15	RIVET				
656	EN6081D5-06	458	RIVET				
657	EN6081D5-07	119	RIVET				
666	EN6081D6-06	150	RIVET				
667	EN6081D6-07	93	RIVET				
668	EN6081D6-08	209	RIVET				(1)
669	EN6081D6-09	82	RIVET				(2)
670	EN6081D7-10	4	RIVET				
678	EN6081D7-08	6	RIVET				
763	DAN5-6-3X	4	PIN				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
764	DAN5-6-4X	96	PIN				
765	DAN5-6-5X	52	PIN				
766	DAN5-6-6X	16	PIN				
767	DAN5-6-7X	4	PIN				
768	DAN5-6-8X	6	PIN				
784	DAN5-6-4Y	1	PIN				
785	DAN5-6-5Y	10	PIN				
786	DAN5-6-6Y	4	PIN				
806	NSA5075-6	168	COLLAR				
807	DAN11-6X	180	COLLAR				
808	ASNA2528-3	132	NUT				
809	DAN11-6Y	15	COLLAR				
863	DAN6-6-3	80	PIN				
875	DAN6-6-5X	2	PIN				
908	ASNA2528-3A	14	NUT				
963	DAN5-6-3	61	PIN				
964	DAN5-6-4	21	PIN				
965	DAN5-6-5	6	PIN				

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

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

Kit 531364D06R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	E5347001120000	7	ANGLE				
2	E5347001120200	6	ANGLE				
4	E5347001024400	2	WEB				
6	E5347001024600	1	WEB				
8	E5347001029400	1	WEB				
10	E5347001025000	1	WEB				
12	E5347001020800	1	WEB				
14	E5347001021000	1	WEB				
16	E5347001120400	1	ANGLE				
18	E5347001021200	1	WEB				
20	E5347001123800	1	ANGLE				
22	E5347001021400	1	WEB				
24	E5347001120600	1	ANGLE				
26	E5347001120800	1	ANGLE				
28	E5347001021600	1	WEB				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
30	E5347001121000	1	ANGLE				
32	E5347001121200	1	ANGLE				
34	E5347001021800	1	WEB				
36	E5347001124200	7	ANGLE				
38	E5347001121600	1	ANGLE				
40	E5347001121800	1	ANGLE				
42	E5347001022000	1	WEB				
44	E5347001122000	1	ANGLE				
46	E5347001122200	1	ANGLE				
48	E5347001122400	1	ANGLE				
50	E5347001022200	1	WEB				
52	E5347001122600	1	ANGLE				
54	E5347001122800	1	ANGLE				
56	E5347001123000	1	ANGLE				
58	E5347001123200	1	ANGLE				
60	E5347001022400	1	WEB				
62	E5347001123400	1	ANGLE				
64	E5347001123600	2	ANGLE				
65	E5347001420200	3	ANGLE				
66	E5347001420000	2	ANGLE				
67	E5347001421200	1	ANGLE				
68	E5347001421400	1	ANGLE				
70	E5347001124400	1	ANGLE				
72	E5347001124600	1	ANGLE				
74	E5347001124800	1	ANGLE				
76	E5347001125000	1	ANGLE				
78	E5347001125200	1	ANGLE				
80	E5347001421600	1	ANGLE				
82	E5347001421800	1	ANGLE				
84	E5347001422000	1	ANGLE				
363	EN6115K3-3	58	BOLT				
364	EN6115K3-4	26	BOLT				
365	EN6115K3-5	27	BOLT				
373	EN6115K3A3	5	BOLT				
374	EN6115K3A4	22	BOLT				
375	EN6115K3A5	5	BOLT				
463	EN6114K3-3	9	BOLT				
544	EN6069D4-04	4	RIVET				
545	EN6069D4-05	52	RIVET				
555	EN6069D5-05	21	RIVET				
556	EN6069D5-06	21	RIVET				
567	EN6069D6-07	211	RIVET				
568	EN6069D6-08	2	RIVET				
655	EN6081D5-05	15	RIVET				
656	EN6081D5-06	444	RIVET				
657	EN6081D5-07	111	RIVET				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
666	EN6081D6-06	136	RIVET				
667	EN6081D6-07	150	RIVET				
668	EN6081D6-08	165	RIVET				(1)
669	EN6081D6-09	56	RIVET				(2)
670	EN6081D7-10	4	RIVET				
678	EN6081D7-08	6	RIVET				
763	DAN5-6-3X	4	PIN				
764	DAN5-6-4X	129	PIN				
765	DAN5-6-5X	94	PIN				
766	DAN5-6-6X	34	PIN				
767	DAN5-6-7X	10	PIN				
768	DAN5-6-8X	21	PIN				
784	DAN5-6-4Y	6	PIN				
785	DAN5-6-5Y	18	PIN				
786	DAN5-6-6Y	9	PIN				
806	NSA5075-6	176	COLLAR				
807	DAN11-6X	304	COLLAR				
808	ASNA2528-3	120	NUT				
809	DAN11-6Y	43	COLLAR				
863	DAN6-6-3	57	PIN				
864	DAN6-6-4	8	PIN				
865	DAN6-6-5	16	PIN				
866	DAN6-6-6	6	PIN				
873	DAN6-6-3X	20	PIN				
885	DAN6-6-5Y	4	PIN				
886	DAN6-6-6Y	3	PIN				
887	DAN6-6-7Y	3	PIN				
908	ASNA2528-3A	32	NUT				
963	DAN5-6-3	53	PIN				
964	DAN5-6-4	25	PIN				
965	DAN5-6-5	11	PIN				

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

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

Kit 531364D07R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	E5347001120000	8	ANGLE				
2	E5347001120200	7	ANGLE				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
4	E5347001024400	2	WEB				
6	E5347001027000	1	WEB				
8	E5347001029400	1	WEB				
10	E5347001025000	1	WEB				
12	E5347001025400	1	WEB				
14	E5347001024000	1	WEB				
18	E5347001025600	1	WEB				
20	E5347001123800	1	ANGLE				
22	E5347001025800	1	WEB				
24	E5347001120600	1	ANGLE				
26	E5347001120800	1	ANGLE				
28	E5347001026000	1	WEB				
30	E5347001121000	1	ANGLE				
32	E5347001121200	1	ANGLE				
34	E5347001024200	1	WEB				
36	E5347001124200	7	ANGLE				
38	E5347001121600	1	ANGLE				
40	E5347001121800	1	ANGLE				
42	E5347001022000	1	WEB				
44	E5347001122000	1	ANGLE				
46	E5347001122200	1	ANGLE				
48	E5347001122400	1	ANGLE				
50	E5347001022200	1	WEB				
52	E5347001122600	1	ANGLE				
54	E5347001122800	1	ANGLE				
56	E5347001123000	1	ANGLE				
58	E5347001123200	1	ANGLE				
60	E5347001022400	1	WEB				
62	E5347001123400	1	ANGLE				
64	E5347001123600	2	ANGLE				
65	E5347001420200	3	ANGLE				
66	E5347001420000	2	ANGLE				
67	E5347001421200	1	ANGLE				
68	E5347001421400	1	ANGLE				
70	E5347001124400	1	ANGLE				
72	E5347001124600	1	ANGLE				
74	E5347001124800	1	ANGLE				
76	E5347001125000	1	ANGLE				
78	E5347001125200	1	ANGLE				
80	E5347001421600	1	ANGLE				
82	E5347001421800	1	ANGLE				
84	E5347001422000	1	ANGLE				
86	E5347001125600	1	ANGLE				
88	E5347001125400	1	ANGLE				
363	EN6115K3-3	58	BOLT				
364	EN6115K3-4	26	BOLT				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
365	EN6115K3-5	27	BOLT				
373	EN6115K3A3	5	BOLT				
374	EN6115K3A4	22	BOLT				
375	EN6115K3A5	5	BOLT				
463	EN6114K3-3	9	BOLT				
544	EN6069D4-04	4	RIVET				
545	EN6069D4-05	52	RIVET				
555	EN6069D5-05	24	RIVET				
556	EN6069D5-06	22	RIVET				
567	EN6069D6-07	211	RIVET				
568	EN6069D6-08	2	RIVET				
655	EN6081D5-05	15	RIVET				
656	EN6081D5-06	460	RIVET				
657	EN6081D5-07	118	RIVET				
666	EN6081D6-06	131	RIVET				
667	EN6081D6-07	153	RIVET				
668	EN6081D6-08	174	RIVET				(1)
669	EN6081D6-09	58	RIVET				(2)
670	EN6081D7-10	4	RIVET				
678	EN6081D7-08	6	RIVET				
763	DAN5-6-3X	4	PIN				
764	DAN5-6-4X	123	PIN				
765	DAN5-6-5X	88	PIN				
766	DAN5-6-6X	30	PIN				
767	DAN5-6-7X	10	PIN				
768	DAN5-6-8X	9	PIN				
784	DAN5-6-4Y	4	PIN				
785	DAN5-6-5Y	17	PIN				
786	DAN5-6-6Y	3	PIN				
806	NSA5075-6	143	COLLAR				
807	DAN11-6X	290	COLLAR				
808	ASNA2528-3	124	NUT				
809	DAN11-6Y	24	COLLAR				
863	DAN6-6-3	57	PIN				
873	DAN6-6-3X	25	PIN				
908	ASNA2528-3A	27	NUT				
963	DAN5-6-3	61	PIN				
964	DAN5-6-4	19	PIN				
965	DAN5-6-5	6	PIN				

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

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

Kit 531364D08R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	E5347001120000	7	ANGLE				
2	E5347001120200	6	ANGLE				
4	E5347001024400	2	WEB				
6	E5347001023600	1	WEB				
8	E5347001027400	1	WEB				
10	E5347001023400	1	WEB				
12	E5347001020800	1	WEB				
14	E5347001021000	1	WEB				
16	E5347001120400	1	ANGLE				
18	E5347001021200	1	WEB				
20	E5347001123800	1	ANGLE				
22	E5347001021400	1	WEB				
24	E5347001120600	1	ANGLE				
26	E5347001120800	1	ANGLE				
28	E5347001021600	1	WEB				
30	E5347001121000	1	ANGLE				
32	E5347001121200	1	ANGLE				
34	E5347001021800	1	WEB				
36	E5347001124200	7	ANGLE				
38	E5347001121600	1	ANGLE				
40	E5347001121800	1	ANGLE				
42	E5347001022000	1	WEB				
44	E5347001122000	1	ANGLE				
46	E5347001122200	1	ANGLE				
48	E5347001122400	1	ANGLE				
50	E5347001022200	1	WEB				
52	E5347001122600	1	ANGLE				
54	E5347001122800	1	ANGLE				
56	E5347001123000	1	ANGLE				
58	E5347001123200	1	ANGLE				
60	E5347001022400	1	WEB				
62	E5347001123400	1	ANGLE				
64	E5347001123600	2	ANGLE				
65	E5347001420200	1	ANGLE				
66	E5347001420000	1	ANGLE				
70	E5347001124400	1	ANGLE				
72	E5347001124600	1	ANGLE				
74	E5347001124800	1	ANGLE				
76	E5347001125000	1	ANGLE				
78	E5347001125200	1	ANGLE				
363	EN6115K3-3	61	BOLT				
364	EN6115K3-4	41	BOLT				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
365	EN6115K3-5	27	BOLT				
373	EN6115K3A3	2	BOLT				
374	EN6115K3A4	10	BOLT				
375	EN6115K3A5	2	BOLT				
463	EN6114K3-3	11	BOLT				
544	EN6069D4-04	14	RIVET				
555	EN6069D5-05	21	RIVET				
556	EN6069D5-06	21	RIVET				
567	EN6069D6-07	214	RIVET				
655	EN6081D5-05	39	RIVET				
656	EN6081D5-06	395	RIVET				
657	EN6081D5-07	98	RIVET				
666	EN6081D6-06	148	RIVET				
667	EN6081D6-07	90	RIVET				
668	EN6081D6-08	197	RIVET				(1)
669	EN6081D6-09	82	RIVET				(2)
670	EN6081D7-10	4	RIVET				
678	EN6081D7-08	6	RIVET				
763	DAN5-6-3X	4	PIN				
764	DAN5-6-4X	105	PIN				
765	DAN5-6-5X	57	PIN				
766	DAN5-6-6X	25	PIN				
767	DAN5-6-7X	4	PIN				
768	DAN5-6-8X	5	PIN				
806	NSA5075-6	248	COLLAR				
807	DAN11-6X	209	COLLAR				
808	ASNA2528-3	140	NUT				
863	DAN6-6-3	125	PIN				
864	DAN6-6-4	10	PIN				
865	DAN6-6-5	16	PIN				
866	DAN6-6-6	6	PIN				
875	DAN6-6-5X	4	PIN				
876	DAN6-6-6X	3	PIN				
877	DAN6-6-7X	3	PIN				
908	ASNA2528-3A	14	NUT				
963	DAN5-6-3	53	PIN				
964	DAN5-6-4	27	PIN				
965	DAN5-6-5	11	PIN				

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

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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Kit 531364D09R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	E5347001120000	9	ANGLE				
2	E5347001120200	7	ANGLE				
4	E5347001024400	2	WEB				
6	E5347001023800	1	WEB				
8	E5347001027400	1	WEB				
10	E5347001025200	1	WEB				
12	E5347001025400	1	WEB				
14	E5347001024000	1	WEB				
18	E5347001025600	1	WEB				
20	E5347001123800	1	ANGLE				
22	E5347001025800	1	WEB				
24	E5347001120600	1	ANGLE				
26	E5347001120800	1	ANGLE				
28	E5347001026000	1	WEB				
30	E5347001121000	1	ANGLE				
32	E5347001121200	1	ANGLE				
34	E5347001024200	1	WEB				
36	E5347001124200	7	ANGLE				
38	E5347001121600	1	ANGLE				
40	E5347001121800	1	ANGLE				
42	E5347001022000	1	WEB				
44	E5347001122000	1	ANGLE				
46	E5347001122200	1	ANGLE				
48	E5347001122400	1	ANGLE				
50	E5347001022200	1	WEB				
52	E5347001122600	1	ANGLE				
54	E5347001122800	1	ANGLE				
56	E5347001123000	1	ANGLE				
58	E5347001123200	1	ANGLE				
60	E5347001022400	1	WEB				
62	E5347001123400	1	ANGLE				
64	E5347001123600	2	ANGLE				
65	E5347001420200	1	ANGLE				
66	E5347001420000	1	ANGLE				
70	E5347001124400	1	ANGLE				
72	E5347001124600	1	ANGLE				
74	E5347001124800	1	ANGLE				
76	E5347001125000	1	ANGLE				
78	E5347001125200	1	ANGLE				
80	E5347001125400	1	ANGLE				
82	E5347001125600	1	ANGLE				
363	EN6115K3-3	60	BOLT				
364	EN6115K3-4	41	BOLT				
365	EN6115K3-5	27	BOLT				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
373	EN6115K3A3	3	BOLT				
374	EN6115K3A4	10	BOLT				
375	EN6115K3A5	2	BOLT				
463	EN6114K3-3	11	BOLT				
544	EN6069D4-04	14	RIVET				
555	EN6069D5-05	22	RIVET				
556	EN6069D5-06	24	RIVET				
567	EN6069D6-07	216	RIVET				
655	EN6081D5-05	39	RIVET				
656	EN6081D5-06	400	RIVET				
657	EN6081D5-07	104	RIVET				
666	EN6081D6-06	148	RIVET				
667	EN6081D6-07	93	RIVET				
668	EN6081D6-08	194	RIVET				(1)
669	EN6081D6-09	82	RIVET				(2)
670	EN6081D7-10	4	RIVET				
678	EN6081D7-08	4	RIVET				
763	DAN5-6-3X	4	PIN				
764	DAN5-6-4X	99	PIN				
765	DAN5-6-5X	52	PIN				
766	DAN5-6-6X	13	PIN				
767	DAN5-6-7X	4	PIN				
768	DAN5-6-8X	5	PIN				
806	NSA5075-6	218	COLLAR				
807	DAN11-6X	165	COLLAR				
808	ASNA2528-3	142	NUT				
863	DAN6-6-3	127	PIN				
864	DAN6-6-4	2	PIN				
908	ASNA2528-3A	14	NUT				
963	DAN5-6-3	61	PIN				
964	DAN5-6-4	21	PIN				
965	DAN5-6-5	6	PIN				

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

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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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	
	Top Coat Polyurethane - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Coating - Flexible Structure	04QAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound	12ADB1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

(2) Components

NOTE: To accomplish this Service Bulletin it is necessary to use the expendable parts listed in the subsequent referenced task:

- AMM Task 28-11-27-400-001.

(3) Equipment

None

E. PARTS TO BE RE-IDENTIFIED BY OPERATOR

None

F. TOOLING

(1) Tooling - Price and Availability

(a) Procurement Addresses

Operators interested in obtaining the FTI tool kits should contact:

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

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Operators interested in obtaining WCI tool kits should contact:

Standard tool TOOLD02	West Coast Industries Inc. 14900 Whitman Ave. N SEATTLE, Washington 98133 USA Tel: (206) 3657513 Fax: (206) 3657483 Email: info@coldwork.com Europe, Middle East, Africa, India and Russia: customer@capaero.com / +33 5 61 92 04 91 (France)

(b) Price and Availability

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

or

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

(2) Tools

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

- AMM Task 28-11-27-000-001
- AMM Task 28-11-27-400-001.

Standard tool TOOLD01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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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.

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

(3) Special Tools

None

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3. ACCOMPLISHMENT INSTRUCTIONS

Task 531364-831-848-001 - Modification

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

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

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

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

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

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

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

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

NOTE: 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: This Service Bulletin contains the instructions for the on-aircraft maintenance necessary to ensure the continued airworthiness of the aircraft.

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

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

Task Associated Data

****CONF 001**

Zone	
150 160 From 150 to 160	
Manpower	
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

****CONF 002**

Zone	
150 160 From 150 to 160	
Manpower	
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

****CONF 003**

Zone	
150 160 From 150 to 160	
Manpower	
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

****CONF 004**

Zone	
150 160 From 150 to 160	
Manpower	
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

****CONF 005**

Zone
150 160 From 150 to 160

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Manpower	
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

**CONF 006

Zone	
150 160 From 150 to 160	
Manpower	
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

**CONF 007

Zone	
150 160 From 150 to 160	
Manpower	
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

**CONF 008

Zone	
150 160 From 150 to 160	
Manpower	
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

**CONF 009

Zone	
150 160 From 150 to 160	
Manpower	
TOTAL MANHOURS	274.00
ELAPSED TIME (HOURS)	236.5

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**CONF ALL

A. GENERAL

**CONF 001

(1) Subtask 531364-910-201-001 - 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
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-21-00 51-23-12 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-48-00 51-76-00 51-78-00

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

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

(c) For the Frame (FR) identification, refer to AMM 06-31-53, 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) Remove the old sealant with non-metallic scrapers and a stiff brush.

(g) Apply protective treatment in accordance with SRM 51-21-00.

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

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

(j) After drilling, remove all the burrs from the holes.

(k) Use transition fit for all hi-lok fasteners. Get fastener hole diameters and drill data in accordance with SRM 51-44-00.

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

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(m) 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.

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

(o) Cut the rivets to the necessary length.

(p) Do the cleaning process in accordance with SRM 51-78-00.

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

(r) All structural parts and fasteners must be wet installed.

(s) Get sealant data in accordance with SRM 51-76-00.

(2) Subtask 531364-839-201-001 - 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 531364-910-201-001 - 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
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-21-00 51-23-12 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-48-00 51-76-00 51-78-00

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

(c) For the Frame (FR) identification, refer to AMM 06-31-53, 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) Remove the old sealant with non-metallic scrapers and a stiff brush.

(g) Apply protective treatment in accordance with SRM 51-21-00.

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

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

(j) After drilling, remove all the burrs from the holes.

(k) Use transition fit for all hi-lok fasteners. Get fastener hole diameters and drill data in accordance with SRM 51-44-00.

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

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

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

(o) Cut the rivets to the necessary length.

(p) Do the cleaning process in accordance with SRM 51-78-00.

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

(r) All structural parts and fasteners must be wet installed.

(s) Get sealant data in accordance with SRM 51-76-00.

(2) Subtask 531364-839-201-001 - 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 003

(1) Subtask 531364-910-201-001 - 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
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-21-00 51-23-12 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-48-00 51-76-00 51-78-00

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

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

(c) For the Frame (FR) identification, refer to AMM 06-31-53, 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) Remove the old sealant with non-metallic scrapers and a stiff brush.

(g) Apply protective treatment in accordance with SRM 51-21-00.

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

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

(j) After drilling, remove all the burrs from the holes.

(k) Use transition fit for all hi-lok fasteners. Get fastener hole diameters and drill data in accordance with SRM 51-44-00.

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

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

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

(o) Cut the rivets to the necessary length.

(p) Do the cleaning process in accordance with SRM 51-78-00.

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

(r) All structural parts and fasteners must be wet installed.

(s) Get sealant data in accordance with SRM 51-76-00.

(2) Subtask 531364-839-201-001 - 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 004**

(1) Subtask 531364-910-201-001 - 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
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-21-00 51-23-12 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-48-00 51-76-00 51-78-00

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

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

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

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(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) Remove the old sealant with non-metallic scrapers and a stiff brush.

(g) Apply protective treatment in accordance with SRM 51-21-00.

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

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

(j) After drilling, remove all the burrs from the holes.

(k) Use transition fit for all hi-lok fasteners. Get fastener hole diameters and drill data in accordance with SRM 51-44-00.

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

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

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

(o) Cut the rivets to the necessary length.

(p) Do the cleaning process in accordance with SRM 51-78-00.

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

(r) All structural parts and fasteners must be wet installed.

(s) Get sealant data in accordance with SRM 51-76-00.

(2) Subtask 531364-839-201-001 - 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 531364-910-201-001 - 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
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-21-00 51-23-12 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-48-00 51-76-00 51-78-00

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

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

(c) For the Frame (FR) identification, refer to AMM 06-31-53, 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) Remove the old sealant with non-metallic scrapers and a stiff brush.

(g) Apply protective treatment in accordance with SRM 51-21-00.

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

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

(j) After drilling, remove all the burrs from the holes.

(k) Use transition fit for all hi-lok fasteners. Get fastener hole diameters and drill data in accordance with SRM 51-44-00.

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

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

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

(o) Cut the rivets to the necessary length.

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(p) Do the cleaning process in accordance with SRM 51-78-00.

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

(r) All structural parts and fasteners must be wet installed.

(s) Get sealant data in accordance with SRM 51-76-00.

(2) Subtask 531364-839-201-001 - 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 006**

(1) Subtask 531364-910-201-001 - 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
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-21-00 51-23-12 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-48-00 51-76-00 51-78-00

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

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

(c) For the Frame (FR) identification, refer to AMM 06-31-53, 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) Remove the old sealant with non-metallic scrapers and a stiff brush.

(g) Apply protective treatment in accordance with SRM 51-21-00.

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

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

(j) After drilling, remove all the burrs from the holes.

(k) Use transition fit for all hi-lok fasteners. Get fastener hole diameters and drill data in accordance with SRM 51-44-00.

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

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

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

(o) Cut the rivets to the necessary length.

(p) Do the cleaning process in accordance with SRM 51-78-00.

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

(r) All structural parts and fasteners must be wet installed.

(s) Get sealant data in accordance with SRM 51-76-00.

(2) Subtask 531364-839-201-001 - 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 007**

(1) Subtask 531364-910-201-001 - 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
Consumable Material List (CML)	

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References	
Structural Repair Manual (SRM)	51-21-00 51-23-12 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-48-00 51-76-00 51-78-00

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

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

(c) For the Frame (FR) identification, refer to AMM 06-31-53, 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) Remove the old sealant with non-metallic scrapers and a stiff brush.

(g) Apply protective treatment in accordance with SRM 51-21-00.

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

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

(j) After drilling, remove all the burrs from the holes.

(k) Use transition fit for all hi-lok fasteners. Get fastener hole diameters and drill data in accordance with SRM 51-44-00.

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

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

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

(o) Cut the rivets to the necessary length.

(p) Do the cleaning process in accordance with SRM 51-78-00.

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

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(r) All structural parts and fasteners must be wet installed.

(s) Get sealant data in accordance with SRM 51-76-00.

(2) Subtask 531364-839-201-001 - 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 008

(1) Subtask 531364-910-201-001 - 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
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-21-00 51-23-12 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-48-00 51-76-00 51-78-00

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

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

(c) For the Frame (FR) identification, refer to AMM 06-31-53, 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) Remove the old sealant with non-metallic scrapers and a stiff brush.

(g) Apply protective treatment in accordance with SRM 51-21-00.

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

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

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(j) After drilling, remove all the burrs from the holes.

(k) Use transition fit for all hi-lok fasteners. Get fastener hole diameters and drill data in accordance with SRM 51-44-00.

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

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

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

(o) Cut the rivets to the necessary length.

(p) Do the cleaning process in accordance with SRM 51-78-00.

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

(r) All structural parts and fasteners must be wet installed.

(s) Get sealant data in accordance with SRM 51-76-00.

(2) Subtask 531364-839-201-001 - 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 009**

(1) Subtask 531364-910-201-001 - 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
Consumable Material List (CML)	

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References	
Structural Repair Manual (SRM)	51-21-00 51-23-12 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-48-00 51-76-00 51-78-00

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

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

(c) For the Frame (FR) identification, refer to AMM 06-31-53, 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) Remove the old sealant with non-metallic scrapers and a stiff brush.

(g) Apply protective treatment in accordance with SRM 51-21-00.

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

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

(j) After drilling, remove all the burrs from the holes.

(k) Use transition fit for all hi-lok fasteners. Get fastener hole diameters and drill data in accordance with SRM 51-44-00.

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

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

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

(o) Cut the rivets to the necessary length.

(p) Do the cleaning process in accordance with SRM 51-78-00.

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

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(r) All structural parts and fasteners must be wet installed.

(s) Get sealant data in accordance with SRM 51-76-00.

(2) Subtask 531364-839-201-001 - 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 531364-941-201-003 - Job Set-up

Work Zones and Access Panels		
	Zone	Access/Work location
	150	
	160	

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 12-34-24-869-002 Task 21-20-00-010-001 Task 24-41-00-862-002 Task 25-52-22-000-001 Task 25-52-44-000-003 Task 25-55-12-000-003 Task 25-55-17-000-001 Task 25-80-00-000-001 Task 28-11-27-000-001 Task 53-35-13-000-001 Task 53-42-14-000-001 Task 53-42-17-000-001

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 12-34-24-869-002.

(b) Remove the Additional Center Tank No. 1 (ACT1) and Additional Center Tank No. 2 (ACT2), refer to AMM Task 28-11-27-000-001.

(c) Remove the door nets from the AFT and/or BULK cargo compartment(s), if necessary, refer to AMM Task 25-55-17-000-001.

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(d) If necessary, remove the ball mats between Frame 52 and Frame 56, refer to AMM Task 25-52-22-000-001.

(e) In the AFT and BULK cargo compartments, remove the floor panels between Frame 49 and Frame 64 on the LH side, refer to AMM Task 53-42-14-000-001 and AMM Task 53-42-17-000-001.

(f) If rear underfloor venting is fitted:

1 Remove the Sidewall Panels 151JW and 151HW, refer to AMM Task 25-55-12-000-003.

2 Remove the air-conditioning ducts between Frame 57 and Frame 58, refer to AMM Task 21-20-00-010-001.

(g) If the semi-automatic loading system is fitted:

1 Remove the YZ fixed latches LH side, refer to AMM Task 25-52-44-000-003.

(h) Remove the insulation blankets in the working area as necessary, refer to AMM Task 25-80-00-000-001.

(i) Remove the belly fairing panel 197GB, refer to AMM Task 53-35-13-000-001.

(j) De-energize the aircraft electrical circuits, refer to AMM Task 24-41-00-862-002.

**CONF 002

(1) Subtask 531364-941-201-002 - Job Set-up

Work Zones and Access Panels		
	Zone	Access/Work location
	150	
	160	

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 12-34-24-869-002 Task 21-20-00-010-001 Task 24-41-00-862-002 Task 25-52-22-000-001 Task 25-52-44-000-003 Task 25-55-12-000-003 Task 25-55-17-000-001 Task 25-80-00-000-001 Task 28-11-27-000-001 Task 53-35-13-000-001 Task 53-42-14-000-001 Task 53-42-17-000-001

NOTE: For the basic Aircraft configuration, refer to AMM Chapter "Introduction -

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Aircraft status for maintenance" in Manual Front Matter section.

(a) Make sure that the aircraft is electrically grounded, refer to AMM Task 12-34-24-869-002.

(b) Remove the Additional Center Tank (ACT), refer to AMM Task 28-11-27-000-001.

(c) Remove the door nets from the AFT and/or BULK cargo compartment(s), if necessary, refer to AMM Task 25-55-17-000-001.

(d) If necessary, remove the ball mats between Frame 52 and Frame 56, refer to AMM Task 25-52-22-000-001.

(e) In the AFT and BULK cargo compartments, remove the floor panels between Frame 49 and Frame 64 on the LH side, refer to AMM Task 53-42-14-000-001 and AMM Task 53-42-17-000-001.

(f) If rear underfloor venting is fitted:

1 Remove the Sidewall Panels 151JW and 151HW, refer to AMM Task 25-55-12-000-003.

2 Remove the air-conditioning ducts between Frame 57 and Frame 58, refer to AMM Task 21-20-00-010-001.

(g) If the semi-automatic loading system is fitted:

1 Remove the YZ fixed latches LH side, refer to AMM Task 25-52-44-000-003.

(h) Remove the insulation blankets in the working area as necessary, refer to AMM Task 25-80-00-000-001.

(i) Remove the belly fairing panel 197GB, refer to AMM Task 53-35-13-000-001.

(j) De-energize the aircraft electrical circuits, refer to AMM Task 24-41-00-862-002.

**CONF 003

(1) Subtask 531364-941-201-003 - Job Set-up

Work Zones and Access Panels		
	Zone	Access/Work location
	150	
	160	

Manpower Resources	
Skills	NON SPECIFIC

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References	
Aircraft Maintenance Manual (AMM)	Task 12-34-24-869-002 Task 21-20-00-010-001 Task 24-41-00-862-002 Task 25-52-22-000-001 Task 25-52-44-000-003 Task 25-55-12-000-003 Task 25-55-17-000-001 Task 25-80-00-000-001 Task 28-11-27-000-001 Task 53-35-13-000-001 Task 53-42-14-000-001 Task 53-42-17-000-001

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 12-34-24-869-002.

(b) Remove the Additional Center Tank No. 1 (ACT1) and Additional Center Tank No. 2 (ACT2), refer to AMM Task 28-11-27-000-001.

(c) Remove the door nets from the AFT and/or BULK cargo compartment(s), if necessary, refer to AMM Task 25-55-17-000-001.

(d) If necessary, remove the ball mats between Frame 52 and Frame 56, refer to AMM Task 25-52-22-000-001.

(e) In the AFT and BULK cargo compartments, remove the floor panels between Frame 49 and Frame 64 on the LH side, refer to AMM Task 53-42-14-000-001 and AMM Task 53-42-17-000-001.

(f) If rear underfloor venting is fitted:

1 Remove the Sidewall Panels 151JW and 151HW, refer to AMM Task 25-55-12-000-003.

2 Remove the air-conditioning ducts between Frame 57 and Frame 58, refer to AMM Task 21-20-00-010-001.

(g) If the semi-automatic loading system is fitted:

1 Remove the YZ fixed latches LH side, refer to AMM Task 25-52-44-000-003.

(h) Remove the insulation blankets in the working area as necessary, refer to AMM Task 25-80-00-000-001.

(i) Remove the belly fairing panel 197GB, refer to AMM Task 53-35-13-000-001.

(j) De-energize the aircraft electrical circuits, refer to AMM Task 24-41-00-862-002.

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**CONF 004

(1) Subtask 531364-941-201-002 - Job Set-up

Work Zones and Access Panels		
	Zone	Access/Work location
	150	
	160	

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 12-34-24-869-002 Task 21-20-00-010-001 Task 24-41-00-862-002 Task 25-52-22-000-001 Task 25-52-44-000-003 Task 25-55-12-000-003 Task 25-55-17-000-001 Task 25-80-00-000-001 Task 28-11-27-000-001 Task 53-35-13-000-001 Task 53-42-14-000-001 Task 53-42-17-000-001

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 12-34-24-869-002.

(b) Remove the Additional Center Tank (ACT), refer to AMM Task 28-11-27-000-001.

(c) Remove the door nets from the AFT and/or BULK cargo compartment(s), if necessary, refer to AMM Task 25-55-17-000-001.

(d) If necessary, remove the ball mats between Frame 52 and Frame 56, refer to AMM Task 25-52-22-000-001.

(e) In the AFT and BULK cargo compartments, remove the floor panels between Frame 49 and Frame 64 on the LH side, refer to AMM Task 53-42-14-000-001 and AMM Task 53-42-17-000-001.

(f) If rear underfloor venting is fitted:

1 Remove the Sidewall Panels 151JW and 151HW, refer to AMM Task 25-55-12-000-003.

2 Remove the air-conditioning ducts between Frame 57 and Frame 58, refer to AMM Task 21-20-00-010-001.

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(g) If the semi-automatic loading system is fitted:

1 Remove the YZ fixed latches LH side, refer to AMM Task 25-52-44-000-003.

(h) Remove the insulation blankets in the working area as necessary, refer to AMM Task 25-80-00-000-001.

(i) Remove the belly fairing panel 197GB, refer to AMM Task 53-35-13-000-001.

(j) De-energize the aircraft electrical circuits, refer to AMM Task 24-41-00-862-002.

**CONF 005

(1) Subtask 531364-941-201-002 - Job Set-up

Work Zones and Access Panels		
	Zone	Access/Work location
	150	
	160	

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 12-34-24-869-002 Task 21-20-00-010-001 Task 24-41-00-862-002 Task 25-52-22-000-001 Task 25-52-44-000-003 Task 25-55-12-000-003 Task 25-55-17-000-001 Task 25-80-00-000-001 Task 28-11-27-000-001 Task 53-35-13-000-001 Task 53-42-14-000-001 Task 53-42-17-000-001

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 12-34-24-869-002.

(b) Remove the Additional Center Tank (ACT), refer to AMM Task 28-11-27-000-001.

(c) Remove the door nets from the AFT and/or BULK cargo compartment(s), if necessary, refer to AMM Task 25-55-17-000-001.

(d) If necessary, remove the ball mats between Frame 52 and Frame 56, refer to AMM Task 25-52-22-000-001.

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(e) In the AFT and BULK cargo compartments, remove the floor panels between Frame 49 and Frame 64 on the LH side, refer to AMM Task 53-42-14-000-001 and AMM Task 53-42-17-000-001.

(f) If rear underfloor venting is fitted:

1 Remove the Sidewall Panels 151JW and 151HW, refer to AMM Task 25-55-12-000-003.

2 Remove the air-conditioning ducts between Frame 57 and Frame 58, refer to AMM Task 21-20-00-010-001.

(g) If the semi-automatic loading system is fitted:

1 Remove the YZ fixed latches LH side, refer to AMM Task 25-52-44-000-003.

(h) Remove the insulation blankets in the working area as necessary, refer to AMM Task 25-80-00-000-001.

(i) Remove the belly fairing panel 197GB, refer to AMM Task 53-35-13-000-001.

(j) De-energize the aircraft electrical circuits, refer to AMM Task 24-41-00-862-002.

**CONF 006

(1) Subtask 531364-941-201-003 - Job Set-up

Work Zones and Access Panels		
	Zone	Access/Work location
	150	
	160	

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 12-34-24-869-002 Task 21-20-00-010-001 Task 24-41-00-862-002 Task 25-52-22-000-001 Task 25-52-44-000-003 Task 25-55-12-000-003 Task 25-55-17-000-001 Task 25-80-00-000-001 Task 28-11-27-000-001 Task 53-35-13-000-001 Task 53-42-14-000-001 Task 53-42-17-000-001

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

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(a) Make sure that the aircraft is electrically grounded, refer to AMM Task 12-34-24-869-002.

(b) Remove the Additional Center Tank No. 1 (ACT1) and Additional Center Tank No. 2 (ACT2), refer to AMM Task 28-11-27-000-001.

(c) Remove the door nets from the AFT and/or BULK cargo compartment(s), if necessary, refer to AMM Task 25-55-17-000-001.

(d) If necessary, remove the ball mats between Frame 52 and Frame 56, refer to AMM Task 25-52-22-000-001.

(e) In the AFT and BULK cargo compartments, remove the floor panels between Frame 49 and Frame 64 on the LH side, refer to AMM Task 53-42-14-000-001 and AMM Task 53-42-17-000-001.

(f) If rear underfloor venting is fitted:

1 Remove the Sidewall Panels 151JW and 151HW, refer to AMM Task 25-55-12-000-003.

2 Remove the air-conditioning ducts between Frame 57 and Frame 58, refer to AMM Task 21-20-00-010-001.

(g) If the semi-automatic loading system is fitted:

1 Remove the YZ fixed latches LH side, refer to AMM Task 25-52-44-000-003.

(h) Remove the insulation blankets in the working area as necessary, refer to AMM Task 25-80-00-000-001.

(i) Remove the belly fairing panel 197GB, refer to AMM Task 53-35-13-000-001.

(j) De-energize the aircraft electrical circuits, refer to AMM Task 24-41-00-862-002.

**CONF 007

(1) Subtask 531364-941-201-003 - Job Set-up

Work Zones and Access Panels		
	Zone	Access/Work location
	150	
	160	

Manpower Resources	
Skills	NON SPECIFIC

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References	
Aircraft Maintenance Manual (AMM)	Task 12-34-24-869-002 Task 21-20-00-010-001 Task 24-41-00-862-002 Task 25-52-22-000-001 Task 25-52-44-000-003 Task 25-55-12-000-003 Task 25-55-17-000-001 Task 25-80-00-000-001 Task 28-11-27-000-001 Task 53-35-13-000-001 Task 53-42-14-000-001 Task 53-42-17-000-001

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 12-34-24-869-002.

(b) Remove the Additional Center Tank No. 1 (ACT1) and Additional Center Tank No. 2 (ACT2), refer to AMM Task 28-11-27-000-001.

(c) Remove the door nets from the AFT and/or BULK cargo compartment(s), if necessary, refer to AMM Task 25-55-17-000-001.

(d) If necessary, remove the ball mats between Frame 52 and Frame 56, refer to AMM Task 25-52-22-000-001.

(e) In the AFT and BULK cargo compartments, remove the floor panels between Frame 49 and Frame 64 on the LH side, refer to AMM Task 53-42-14-000-001 and AMM Task 53-42-17-000-001.

(f) If rear underfloor venting is fitted:

1 Remove the Sidewall Panels 151JW and 151HW, refer to AMM Task 25-55-12-000-003.

2 Remove the air-conditioning ducts between Frame 57 and Frame 58, refer to AMM Task 21-20-00-010-001.

(g) If the semi-automatic loading system is fitted:

1 Remove the YZ fixed latches LH side, refer to AMM Task 25-52-44-000-003.

(h) Remove the insulation blankets in the working area as necessary, refer to AMM Task 25-80-00-000-001.

(i) Remove the belly fairing panel 197GB, refer to AMM Task 53-35-13-000-001.

(j) De-energize the aircraft electrical circuits, refer to AMM Task 24-41-00-862-002.

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**CONF 008

(1) **Subtask 531364-941-201-003 - Job Set-up**

Work Zones and Access Panels		
	Zone	Access/Work location
	150	
	160	

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 12-34-24-869-002 Task 21-20-00-010-001 Task 24-41-00-862-002 Task 25-52-22-000-001 Task 25-52-44-000-003 Task 25-55-12-000-003 Task 25-55-17-000-001 Task 25-80-00-000-001 Task 28-11-27-000-001 Task 53-35-13-000-001 Task 53-42-14-000-001 Task 53-42-17-000-001

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 12-34-24-869-002.

(b) Remove the Additional Center Tank No. 1 (ACT1) and Additional Center Tank No. 2 (ACT2), refer to AMM Task 28-11-27-000-001.

(c) Remove the door nets from the AFT and/or BULK cargo compartment(s), if necessary, refer to AMM Task 25-55-17-000-001.

(d) If necessary, remove the ball mats between Frame 52 and Frame 56, refer to AMM Task 25-52-22-000-001.

(e) In the AFT and BULK cargo compartments, remove the floor panels between Frame 49 and Frame 64 on the LH side, refer to AMM Task 53-42-14-000-001 and AMM Task 53-42-17-000-001.

(f) If rear underfloor venting is fitted:

1 Remove the Sidewall Panels 151JW and 151HW, refer to AMM Task 25-55-12-000-003.

2 Remove the air-conditioning ducts between Frame 57 and Frame 58, refer to AMM Task 21-20-00-010-001.

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(g) If the semi-automatic loading system is fitted:

1 Remove the YZ fixed latches LH side, refer to AMM Task 25-52-44-000-003.

(h) Remove the insulation blankets in the working area as necessary, refer to AMM Task 25-80-00-000-001.

(i) Remove the belly fairing panel 197GB, refer to AMM Task 53-35-13-000-001.

(j) De-energize the aircraft electrical circuits, refer to AMM Task 24-41-00-862-002.

**CONF 009

(1) Subtask 531364-941-201-003 - Job Set-up

Work Zones and Access Panels		
	Zone	Access/Work location
	150	
	160	

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 12-34-24-869-002 Task 21-20-00-010-001 Task 24-41-00-862-002 Task 25-52-22-000-001 Task 25-52-44-000-003 Task 25-55-12-000-003 Task 25-55-17-000-001 Task 25-80-00-000-001 Task 28-11-27-000-001 Task 53-35-13-000-001 Task 53-42-14-000-001 Task 53-42-17-000-001

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 12-34-24-869-002.

(b) Remove the Additional Center Tank No. 1 (ACT1) and Additional Center Tank No. 2 (ACT2), refer to AMM Task 28-11-27-000-001.

(c) Remove the door nets from the AFT and/or BULK cargo compartment(s), if necessary, refer to AMM Task 25-55-17-000-001.

(d) If necessary, remove the ball mats between Frame 52 and Frame 56, refer to AMM Task 25-52-22-000-001.

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(e) In the AFT and BULK cargo compartments, remove the floor panels between Frame 49 and Frame 64 on the LH side, refer to AMM Task 53-42-14-000-001 and AMM Task 53-42-17-000-001.

(f) If rear underfloor venting is fitted:

1 Remove the Sidewall Panels 151JW and 151HW, refer to AMM Task 25-55-12-000-003.

2 Remove the air-conditioning ducts between Frame 57 and Frame 58, refer to AMM Task 21-20-00-010-001.

(g) If the semi-automatic loading system is fitted:

1 Remove the YZ fixed latches LH side, refer to AMM Task 25-52-44-000-003.

(h) Remove the insulation blankets in the working area as necessary, refer to AMM Task 25-80-00-000-001.

(i) Remove the belly fairing panel 197GB, refer to AMM Task 53-35-13-000-001.

(j) De-energize the aircraft electrical circuits, refer to AMM Task 24-41-00-862-002.

**CONF ALL

C. PROCEDURE

**CONF 001

(1) Subtask 531364-831-201-004 - Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 Stringer 38 LH
To	160	Work location	from Frame 60 to Frame 63 Stringer 38 LH

Manpower Resources	
Manhours	4.50
Minimum number of person	1
Subtask elapsed time	4.50
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
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	53-41-14
Fig. A-GBQAA Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

CAUTION: AIRBUS CONSIDERS IT IS TECHNICALLY ACCEPTABLE TO REWORK EVERY THIRD FRAME AT THE SAME TIME (I.E. LEAVE TWO FRAMES INTACT AND REWORK ONE) TO KEEP THE FUSELAGE STRUCTURE INTEGRITY.

(a) Remove the corner profiles.

In accordance with SRM 53-41-14 C2 Ident.-Floor Structure-Cargo Compartment.

1 Between Frame 48 thru Frame 63, at STGR 38 LH, remove the corner profiles, if necessary in accordance with SRM 53-41-14 C2 Identification - Floor Structure - Cargo Compartment.

(b) Remove the shear plates.

Refer to Fig. A-GBQAA Sheet 01 thru Fig. A-GBQAA Sheet 06.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 Between Frame 49 and Frame 50, from STGR 38 LH and from the bracket at Frame 49 and bracket, Item (140), remove:

Refer to Fig. A-GBQAA Sheet 02, View C.

1	Plate-Shear	D5347456300000	Item (139)	Retain
	with			
26	Rivet		Item (100)	Discard

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2 Between Frame 50 and Frame 51, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAA Sheet 02, View C.

1	Plate-Shear	D5347471500200	Item (117)	Retain
	with			
28	Rivet		Item (100)	Discard

3 Between Frame 52 and Frame 53, from STGR 38 LH and from the brackets, Item (116) and Item (120), remove:

Refer to Fig. A-GBQAA Sheet 03, View E.

1	Plate Assy-Shear	D5347049100000	Item (119)	Retain
1	Section-Connecting	D5347065020200	Item (135)	Retain
	with			
42	Rivet		Item (100)	Discard

4 Between Frame 54 and Frame 55, from STGR 38 LH and from the brackets, Item (121) and Item (120), remove:

Refer to Fig. A-GBQAA Sheet 04, View G.

1	Plate Assy-Shear	D5347048800000	Item (122)	Retain
	with			
28	Rivet		Item (100)	Discard

5 Between Frame 56 and Frame 57, from STGR 38 LH and from the brackets, Item (121) and Item (118), remove:

Refer to Fig. A-GBQAA Sheet 04, View J.

1	Plate Assy-Shear	D5347048900000	Item (124)	Retain
	with			
28	Rivet		Item (100)	Discard

6 Between Frame 58 and Frame 59, from STGR 38 LH and from the brackets, Item (125) and Item (127), remove:

Refer to Fig. A-GBQAA Sheet 05, View L.

1	Plate-Shear	D5347049200000	Item (126)	Retain
	or			

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1	Plate-Shear	D5347049200200	Item (126)	Retain
	with			
28	Rivet		Item (100)	Discard

7 Between Frame 60 and Frame 61, from STGR 38 LH and from the brackets, Item (128) and Item (130), remove:

Refer to Fig. A-GBQAA Sheet 05, View N.

1	Plate-Shear	D5347049300000	Item (129)	Retain
1	Section-Connecting	D5347065420000	Item (136)	Retain
	with			
45	Rivet		Item (100)	Discard

8 Between Frame 62 and Frame 63, from STGR 38 LH and from the brackets, Item (131) and Item (115), remove:

Refer to Fig. A-GBQAA Sheet 06, View Q.

1	Plate-Shear	D5347049400000	Item (123)	Retain
	with			
29	Rivet		Item (100)	Discard

(c) Clean the contact surfaces and the retained parts with:

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

(2) Subtask 531364-831-202-003 - Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 from Stringer 33 LH to Stringer 34 LH from Stringer 36 LH to Stringer 37 LH

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To	160	Work location	from Frame 60 to Frame 62 from Stringer 32 LH to Stringer 33 LH from Stringer 36 LH to Stringer 37 LH Frame 63 from Stringer 31 LH to Stringer 32 LH from Stringer 36 LH to Stringer 37 LH

Manpower Resources	
Manhours	5.00
Minimum number of person	1
Subtask elapsed time	5.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

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 Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane	04JME4	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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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.

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00
Fig. A-GBRAA Cold Expansion of Holes in Frame 50 thru Frame 63	Sheet 01 Sheet 02 Sheet 03

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

(a) Inspect the holes for cracks from Frame 50 thru Frame 55 and from Frame 57 thru Frame 59.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 33 LH and STGR 34 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(b) Cold expand the holes from Frame 50 thru Frame 55 and from Frame 57 thru Frame 59.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 33 LH and STGR 34 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1 Expendable Tooling 1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1 Capital Tooling 1

DK-A320531364-1 Durable Tooling 1

EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 02, View C.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

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

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(c) Inspect the holes for cracks at Frame 56.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 At Frame 56, between STGR 33 LH and STGR 34 LH and between STGR 35 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

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2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(d) Cold expand the holes at Frame 56.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 At Frame 56, between STGR 33 LH and STGR 34 LH and between STGR 35 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 02, View D.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

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

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3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(e) Inspect the holes for cracks from Frame 60 thru Frame 62.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

1 From Frame 60 thru Frame 62, between STGR 32 LH and STGR 33 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(f) Cold expand the holes from Frame 60 thru Frame 62.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

1 From Frame 60 thru Frame 62, between STGR 32 LH and STGR 33 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 03, View E.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

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

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(g) Inspect the holes for cracks at Frame 63.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

1 At Frame 63, between STGR 31 LH and STGR 32 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frame, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

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(h) Cold expand the holes at Frame 63.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

1 At Frame 63, between STGR 31 LH and STGR 32 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frame. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 03, View F.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(3) Subtask 531364-831-203-003 - Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 50 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D01R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
4	E5347001024400	1	WEB	
65	E5347001420200	1	ANGLE	
66	E5347001420000	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	2	RIVET	
567	EN6069D6-07	23	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
764	DAN5-6-4X	14	PIN	
765	DAN5-6-5X	15	PIN	
766	DAN5-6-6X	7	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	2	PIN	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	40	COLLAR	
808	ASNA2528-3	3	NUT	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	4	PIN	

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01

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References	
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBAAA Replacement of Webs and Angles at Frame 50	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBAAA Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 50, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
17	Rivet		Item (100)	Discard

2 From the flange of Frame 50, between STGR 35 LH and STGR 36 LH, remove:

6	Rivet		Item (100)	Discard

3 From Frame 50, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347073420000	Item (1)	Discard
	with			
18	Rivet		Item (100)	Discard

4 From Frame 50, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072820000	Item (2)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle-Support	D5347068120000	Item (102)	Retain
1	Angle	D5347470120200	Item (116)	Discard

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1	Angle	D5347470120000	Item (140)	Discard
	with			
66	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 50.

Refer to NTM 51-10-01.

Refer to Fig. A-GBAAA Sheet 02, View C.

1 On Frame 50, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 50, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBAAA Sheet 02 thru Fig. A-GBAAA Sheet 04.

1 On Frame 50, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBAAA Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

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3 Transfer drill the fastener holes from the Frame 50 to the shear web, Item 4.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAA Sheet 04.

4 Transfer drill the tack hole from the Frame 50 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

5 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBAAA Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBAAA Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAA Sheet 04.

6 On Frame 50, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

7 Clean and deburr the new fastener holes in Frame 50 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBAAA Sheet 02, View C.

a On Frame 50, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBAAA Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

b On Frame 50, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAA Sheet 02, View C.

c On Frame 50, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAA Sheet 02, View C.

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d On Frame 50, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAA Sheet 02, View C.

9 On Frame 50, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

10 Clean and deburr the cold expansion fastener holes in Frame 50 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 50, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBAAA Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

with

3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374

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1	Bolt	EN6115K3A5	Item 375
23	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
14	Pin	DAN5-6-4X	Item 764
12	Pin	DAN5-6-5X	Item 765
26	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
5	Nut	ASNA2528-3A	Item 908

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 50, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBAAA Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

13 On the Frame 50 flange, at STGR 35 LH, refer to Fig. A-GBAAA Sheet 02, View C and Fig. A-GBAAA Sheet 03, Section C-C, countersink the one fastener hole.

14 On the Frame 50 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBAAA Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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15 On the Frame 50 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBAAA Sheet 02, View C and Fig. A-GBAAA Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream the one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBAAA Sheet 02, View C and Fig. A-GBAAA Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAA Sheet 04.

17 On the Frame 50 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 50, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 50 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBAAA Sheet 02, View C and Fig. A-GBAAA Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

20 On the Frame 50 flange, at STGR 36 LH, refer to Fig. A-GBAAA Sheet 03, Section D-D, countersink the one fastener hole.

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21 On the Frame 50 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBAAA Sheet 03, Section D-D

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 50 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBAAA Sheet 02, View C and Fig. A-GBAAA Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBAAA Sheet 02, View C and Fig. A-GBAAA Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAA Sheet 04.

24 On the Frame 50 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

25 Clean and deburr the new fastener holes in the Frame 50, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 50 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBAAA Sheet 02, View C and Fig. A-GBAAA Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

27 On the Frame 50 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBAAA Sheet 02, View C and Fig. A-GBAAA Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

4	Pin	DAN5-6-6X	Item 766	
2	Pin	DAN5-6-7X	Item 767	
4	Collar	NSA5075-6	Item 806	
6	Collar	DAN11-6X	Item 807	
4	Pin	DAN5-6-3	Item 963	

28 On the Frame 50 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBAAA Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

29 Transfer drill and ream the three holes from the Frame to the angles, Item 65 and Item 66, refer to Fig. A-GBAAA Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAA Sheet 04.

30 On the Frame 50 flange, at STGR 38 LH, remove:

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

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31 Clean and deburr the new fastener holes in the Frame 50 and angles, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

32 On the Frame 50 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBAAA Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

1	Pin	DAN5-6-6X	Item 766
2	Pin	DAN5-6-8X	Item 768
3	Collar	DAN11-6X	Item 807

33 On the Frame 50 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBAAA Sheet 02, View C and Fig. A-GBAAA Sheet 03, Section F-F.

1	Angle-Support	D5347068120000	Item (102)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Pin	DAN5-6-6X	Item 766
2	Collar	DAN11-6X	Item 807

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(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(4) Subtask 531364-831-204-003 - Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 51 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D01R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
4	E5347001024400	1	WEB	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	2	RIVET	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
567	EN6069D6-07	23	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
764	DAN5-6-4X	14	PIN	
765	DAN5-6-5X	15	PIN	
766	DAN5-6-6X	6	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	3	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	40	COLLAR	
808	ASNA2528-3	3	NUT	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	4	PIN	

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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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.

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBBAA Replacement of Webs and Angles at Frame 51	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBBAA Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 51, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
17	Rivet		Item (100)	Discard

2 From the flange of Frame 51, between STGR 35 LH and STGR 36 LH, remove:

6	Rivet		Item (100)	Discard

3 From Frame 51, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347073420000	Item (1)	Discard
	with			
18	Rivet		Item (100)	Discard

4 From Frame 51, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072820000	Item (2)	Discard
1	Support	D5347032200000	Item (101)	Retain

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1	Angle-Support	D5347068120000	Item (102)	Retain
1	Angle	D5347470120000	Item (140)	Retain
	with			
66	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 51.

Refer to NTM 51-10-01.

Refer to Fig. A-GBBAA Sheet 02, View C.

1 On Frame 51, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 51, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 385, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBBAA Sheet 02 thru Fig. A-GBBAA Sheet 04.

1 On Frame 51, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBBAA Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

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2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 51 to the shear web, Item 4.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAA Sheet 04.

4 Transfer drill the tack hole from the Frame 51 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

5 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBBAA Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBBAA Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAA Sheet 04.

6 On Frame 51, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

7 Clean and deburr the new fastener holes in Frame 51 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBBAA Sheet 02, View C.

a On Frame 51, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBBAA Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

b On Frame 51, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

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FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAA Sheet 02, View C.

c On Frame 51, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAA Sheet 02, View C.

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d On Frame 51, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAA Sheet 02, View C.

9 On Frame 51, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

10 Clean and deburr the cold expansion fastener holes in Frame 51 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 51, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBBAA Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

with

3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374

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1	Bolt	EN6115K3A5	Item 375
23	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
14	Pin	DAN5-6-4X	Item 764
12	Pin	DAN5-6-5X	Item 765
26	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
5	Nut	ASNA2528-3A	Item 908

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 51, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBBAA Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

13 On the Frame 51 flange, at STGR 35 LH, refer to Fig. A-GBBAA Sheet 03, Section A-A, countersink the one fastener hole.

14 On the Frame 51 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBBAA Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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15 On the Frame 51 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBBAA Sheet 02, View C and Fig. A-GBBAA Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBBAA Sheet 02, View C and Fig. A-GBBAA Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAA Sheet 04.

17 On the Frame 51 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 51, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 51 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBBAA Sheet 02, View C and Fig. A-GBBAA Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

20 On the Frame 51 flange, at STGR 36 LH, refer to Fig. A-GBBAA Sheet 03, Section B-B, countersink the one fastener hole.

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21 On the Frame 51 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBBAA Sheet 03, Section B-B.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 51 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBBAA Sheet 02, View C and Fig. A-GBBAA Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBBAA Sheet 02, View C and Fig. A-GBBAA Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAA Sheet 04.

24 On the Frame 51 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

25 Clean and deburr the new fastener holes in the Frame 51, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 51 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBBAA Sheet 02, View C and Fig. A-GBBAA Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

27 On the Frame 51 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBBAA Sheet 02, View C and Fig. A-GBBAA Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Pin	DAN5-6-6X	Item 766
2	Pin	DAN5-6-7X	Item 767
4	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
4	Pin	DAN5-6-3	Item 963

28 On the Frame 51 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBBAA Sheet 02, View C.

1	Angle	D5347470120000	Item (140)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

3	Pin	DAN5-6-8X	Item 768
3	Collar	DAN11-6X	Item 807

29 On the Frame 51 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBBAA Sheet 02, View C and Fig. A-GBBAA Sheet 03, Section D-D.

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1	Angle-Support	D5347068120000	Item (102)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
2	Pin	DAN5-6-6X	Item 766	
2	Collar	DAN11-6X	Item 807	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(5) Subtask 531364-831-205-003 - Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 52 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D01R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
6	E5347001023600	1	WEB	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	2	RIVET	
567	EN6069D6-07	25	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	4	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	2	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	9	PIN	
765	DAN5-6-5X	1	PIN	
766	DAN5-6-6X	6	PIN	
806	NSA5075-6	13	COLLAR	
807	DAN11-6X	16	COLLAR	
808	ASNA2528-3	10	NUT	
863	DAN6-6-3	1	PIN	
865	DAN6-6-5	4	PIN	
866	DAN6-6-6	6	PIN	
963	DAN5-6-3	1	PIN	
964	DAN5-6-4	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBCAA Replacement of Webs and Angles at Frame 52	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBCAA Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 52, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920200	Item (3)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 52, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

8	Rivet		Item (100)	Discard

3 From Frame 52, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020000	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 52, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347077420000	Item (5)	Discard
1	Support	D5347032200400	Item (103)	Retain
1	Angle	D5347046820000	Item (116)	Retain
1	Section-Connecting	D5347065020200	Item (135)	Retain
1	Shim	D5347044920000	Item (142)	Retain
1	Shim	D5347044920600	Item (143)	Retain
	with			
65	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

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and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 52.

Refer to NTM 51-10-01.

Refer to Fig. A-GBCAA Sheet 02, Views C, D and F.

1 On Frame 52, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 52, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 52, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 52, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBCAA Sheet 02 thru Fig. A-GBCAA Sheet 04.

1 On Frame 52, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBCAA Sheet 02, View C.

1	Shear Web	E5347001023600	Item 6

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2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 52 between STGR 36 LH and 37 LH to the shear web, Item 6.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAA Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBCAA Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBCAA Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAA Sheet 04.

5 Transfer drill the tack hole from the Frame 52 to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 52, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001023600	Item 6

7 Clean and deburr the new fastener holes in Frame 52 and the shear web, Item 6, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBCAA Sheet 02, Views C, D and F.

a On Frame 52, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBCAA Sheet 02, View C.

1	Shear Web	E5347001023600	Item 6

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b On Frame 52, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAA Sheet 02, View C.

c On Frame 52, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAA Sheet 02, View C.

d On the top flange of Frame 52, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAA Sheet 02, View D.

e On the top flange of Frame 52, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAA Sheet 02, View F.

9 On Frame 52, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001023600	Item 6

10 Clean and deburr the cold expansion fastener holes in Frame 52 and the shear web, Item 6, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 52, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBCAA Sheet 02, View C.

1	Shear Web	E5347001023600	Item 6

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
25	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
16	Rivet	EN6081D6-08	Item 668
7	Pin	DAN5-6-4X	Item 764
1	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
1	Pin	DAN5-6-3	Item 963

use

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 52, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBCAA Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 52, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBCAA Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

14 On the Frame 52 flange, at STGR 35 LH, refer to Fig. A-GBCAA Sheet 03, Section B-B, countersink the one fastener hole.

15 On the Frame 52 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBCAA Sheet 03, Section B-B.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 52 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBCAA Sheet 02, View C and Fig. A-GBCAA Sheet 03, Section B-B.

1	Angle	E5347001120000	Item 1

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17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBCAA Sheet 02, View C and Fig. A-GBCAA Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAA Sheet 04.

18 On the Frame 52 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 52, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 52 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBCAA Sheet 02, View C and Fig. A-GBCAA Sheet 03, Section B-B.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

21 On the Frame 52 flange, at STGR 36 LH, refer to Fig. A-GBCAA Sheet 03, Section C-C, countersink the one fastener hole.

22 On the Frame 52 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBCAA Sheet 03, Section C-C.

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1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 52 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBCAA Sheet 02, View C and Fig. A-GBCAA Sheet 03, Section C-C.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBCAA Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAA Sheet 04.

25 On the Frame 52 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 52, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 52 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBCAA Sheet 02, View C and Fig. A-GBCAA Sheet 03, Section C-C.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657

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2	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-4	Item 964	
1	Collar	NSA5075-6	Item 806	

28 On the Frame 52 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBCAA Sheet 02, View C and Fig. A-GBCAA Sheet 03, Section D-D.

1	Support	D5347032200400	Item (103)	Retained at removal
1	Section-Connecting	D5347065020200	Item (135)	Retained at removal
1	Shim	D5347044920000	Item (142)	Retained at removal
1	Shim	D5347044920600	Item (143)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

6	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-4X	Item 764
6	Pin	DAN5-6-6X	Item 766
7	Collar	DAN11-6X	Item 807
10	Collar	NSA5075-6	Item 806
4	Pin	DAN6-6-5	Item 865
6	Pin	DAN6-6-6	Item 866

29 On the aft side of the Frame 52 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBCAA Sheet 02, View C.

1	Angle	D5347046820000	Item (116)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-4X	Item 764
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(6) Subtask 531364-831-206-003 - Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 53 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D01R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
8	E5347001027400	1	WEB	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
556	EN6069D5-06	2	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	2	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	1	PIN	
806	NSA5075-6	18	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	9	NUT	
863	DAN6-6-3	10	PIN	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	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	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

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NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBDAA Replacement of Webs and Angles at Frame 53	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBDAA Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

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1 From Frame 53, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the flange of Frame 53, between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 53, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020000	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 53, between STGR 36 LH and STGR 39 LH, remove:

1	Shear web	D5347078320000	Item (6)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle-Support	D5347068120000	Item (102)	Retain
1	Angle	D5347046820400	Item (120)	Retain
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 53.

Refer to NTM 51-10-01.

Refer to Fig. A-GBDAA Sheet 02, View C.

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1 On Frame 53, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 53, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBDAA Sheet 02 thru Fig. A-GBDAA Sheet 04.

1 On Frame 53, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBDAA Sheet 02, View C.

1	Shear Web	E5347001027400	Item 8

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 53 between STGR 36 LH and 37 LH to the shear web, Item 8.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAA Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBDAA Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBDAA Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAA Sheet 04.

5 Transfer drill the tack hole from the Frame 53 to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 53, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001027400	Item 8

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7 Clean and deburr the new fastener holes in Frame 53 and the shear web, Item 8, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBDAA Sheet 02, View C.

a On Frame 53, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBDAA Sheet 02, View C.

1	Shear Web	E5347001027400	Item 8

b On Frame 53, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAA Sheet 02, View C.

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c On Frame 53, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAA Sheet 02, View C.

9 On Frame 53, between STGR 34 LH and STGR 39 LH, wet install:

1	Shear Web	E5347001027400	Item 8

10 Clean and deburr the cold expansion fastener holes in Frame 53 and the shear web, Item 8, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 53, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBDAA Sheet 02, View C.

1	Shear Web	E5347001027400	Item 8

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364

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15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
13	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863
1	Pin	DAN5-6-3	Item 963
2	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 53, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBDAA Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the Frame 53 flange, at STGR 35 LH, refer to Fig. A-GBDAA Sheet 03, Section A-A, countersink the one fastener hole.

14 On the Frame 53 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBDAA Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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15 On the Frame 53 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBDAA Sheet 02, View C and Fig. A-GBDAA Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBDAA Sheet 02, View C and Fig. A-GBDAA Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAA Sheet 04.

17 On the Frame 53 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 53, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 53 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBDAA Sheet 02, View C and Fig. A-GBDAA Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

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20 On the Frame 53 flange, at STGR 36 LH, refer to Fig. A-GBDAA Sheet 03, Section B-B, countersink the one fastener hole.

21 On the Frame 53 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBDAA Sheet 03, Section B-B.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 53 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBDAA Sheet 02, View C and Fig. A-GBDAA Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes in the Frame to the angle, Item 2, refer to Fig. A-GBDAA Sheet 02, View C and Fig. A-GBDAA Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAA Sheet 04.

24 On the Frame 53 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

25 Clean and deburr the new fastener holes in the Frame 53, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 53 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBDAA Sheet 02, View C and Fig. A-GBDAA Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-4	Item 964	
1	Collar	NSA5075-6	Item 806	

27 On the Frame 53 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBDAA Sheet 02, View C and Fig. A-GBDAA Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

28 On the Frame 53 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBDAA Sheet 02, View C.

1	Angle	D5347046820400	Item (120)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-4X	Item 764	

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1	Collar	DAN11-6X	Item 807	

29 On the Frame 53 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBDAA Sheet 02, View C and Fig. A-GBDAA Sheet 03, Section D-D.

1	Angle-Support	D5347068120000	Item (102)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-08	Item 668	
2	Rivet	EN6081D5-07	Item 657	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(7) Subtask 531364-831-207-003 - Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 54 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D01R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
10	E5347001023400	1	WEB	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	2	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	6	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	21	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	1	PIN	
806	NSA5075-6	16	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	10	NUT	
863	DAN6-6-3	12	PIN	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	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	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

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NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBEAA Replacement of Webs and Angles at Frame 54	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBEAA Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

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1 From Frame 54, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 54, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

10	Rivet		Item (100)	Discard

3 From Frame 54, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020000	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 54, between STGR 36 LH and STGR 39 LH, remove:

1	Web-shear	D5347078520000	Item (7)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle-Support	D5347068120000	Item (102)	Retain
1	Angle	D5347046820600	Item (121)	Retain
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 54.

Refer to NTM 51-10-01.

Refer to Fig. A-GBEAA Sheet 02, Views C, D and F.

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1 On Frame 54, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 54, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 54, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 54, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBEAA Sheet 02 thru Fig. A-GBEAA Sheet 04.

1 On Frame 54, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBEAA Sheet 02, View C.

1	Shear Web	E5347001023400	Item 10

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 54 between STGR 36 LH and 37 LH to the shear web, Item 10.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAA Sheet 04.

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4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBEAA Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBEAA Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAA Sheet 04.

5 Transfer drill the tack hole from the Frame 54 to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 54, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001023400	Item 10

7 Clean and deburr the new fastener holes in Frame 54 and the shear web, Item 10, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBEAA Sheet 02, Views C, D and F.

a On Frame 54, between STGR 34 LH and STGR 39 LH, put in position:

1	Shear Web	E5347001023400	Item 10

b On Frame 54, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAA Sheet 02, View C.

c On Frame 54, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAA Sheet 02, View C.

d On the top flange of Frame 54, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1 Expendable Tooling 1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1 Capital Tooling 1

DK-A320531364-1 Durable Tooling 1

EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAA Sheet 02, View D.

e On the top flange of Frame 54, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1 Capital Tooling 1

DK-A320531364-1 Durable Tooling 1

EK-A320531364-1 Expendable Tooling 1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1 Capital Tooling 1

DK-A320531364-1 Durable Tooling 1

EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAA Sheet 02, View F.

9 On Frame 54, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001023400	Item 10

10 Clean and deburr the cold expansion fastener holes in Frame 54 and the shear web, Item 10, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 54, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBEAA Sheet 02, View C.

1	Shear Web	E5347001023400	Item 10

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
6	Rivet	EN6081D6-06	Item 666
17	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
10	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 54, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBEAA Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 54, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBEAA Sheet 02, View D.

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1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

14 On the Frame 54 flange, at STGR 35 LH, refer to Fig. A-GBEAA Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 54 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBEAA Sheet 02, View C and Fig. A-GBEAA Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 54 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBEAA Sheet 02, View C and Fig. A-GBEAA Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBEAA Sheet 02, View C and Fig. A-GBEAA Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAA Sheet 04.

18 On the Frame 54 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 54, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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20 On the Frame 54 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBEAA Sheet 02, View C and Fig. A-GBEAA Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

21 On the Frame 54 flange, at STGR 36 LH, refer to Fig. A-GBEAA Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 54 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBEAA Sheet 03, Section B-B.

1	Rivet	EN6069D5-06	Item 556
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 54 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBEAA Sheet 02, View C and Fig. A-GBEAA Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBEAA Sheet 02, View C and Fig. A-GBEAA Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAA Sheet 04.

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25 On the Frame 54 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2	

26 Clean and deburr the new fastener holes in the Frame 54, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required	

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required	

27 On the Frame 54 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBEAA Sheet 02, View C and Fig. A-GBEAA Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

28 On the Frame 54 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBEAA Sheet 02, View C and Fig. A-GBEAA Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

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29 On the aft side of the Frame 54 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBEAA Sheet 02, View C.

1	Angle	D5347046820600	Item (121)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-4X	Item 764	
1	Collar	DAN11-6X	Item 807	

30 On the Frame 54 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBEAA Sheet 02, View C and Fig. A-GBEAA Sheet 03, Section D-D.

1	Angle-Support	D5347068120000	Item (102)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-08	Item 668	
2	Rivet	EN6081D5-07	Item 657	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required

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for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(8) Subtask 531364-831-208-003 - Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 55 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D01R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
12	E5347001020800	1	WEB	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	2	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	6	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	10	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	16	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	10	NUT	
863	DAN6-6-3	12	PIN	
963	DAN5-6-3	4	PIN	

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NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBFAA Replacement of Webs and Angles at Frame 55	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBFAA Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 55, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 55, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

10	Rivet		Item (100)	Discard

3 From Frame 55, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020000	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 55, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072120000	Item (8)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle-Support	D5347068120000	Item (102)	Retain
1	Angle	D5347046820400	Item (120)	Retain
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

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Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 55.

Refer to NTM 51-10-01.

Refer to Fig. A-GBFAA Sheet 02, Views C, D and F.

1 On Frame 55, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 55, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 55, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBFAA Sheet 02 thru Fig. A-GBFAA Sheet 04.

1 On Frame 55, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBFAA Sheet 02, View C.

1	Shear Web	E5347001020800	Item 12

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

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3 Transfer drill the fastener holes from the Frame 55 between STGR 36 LH and 37 LH to the shear web, Item 12.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAA Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBFAA Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBFAA Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAA Sheet 04.

5 Transfer drill the tack hole from the Frame 55 to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 55, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001020800	Item 12

7 Clean and deburr the new fastener holes in Frame 55 and the shear web, Item 12, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBFAA Sheet 02, Views C, D and F.

a On Frame 55, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBFAA Sheet 02, View C.

1	Shear Web	E5347001020800	Item 12

b On Frame 55, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAA Sheet 02, View C.

c On Frame 55, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAA Sheet 02, View C.

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d On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAA Sheet 02, View D.

e On the top flange of Frame 55, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAA Sheet 02, View F.

9 On Frame 55, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001020800	Item 12

10 Clean and deburr the cold expansion fastener holes in Frame 55 and the shear web, Item 12, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 55, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBFAA Sheet 02, View C.

1	Shear Web	E5347001020800	Item 12

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
6	Rivet	EN6081D6-06	Item 666
17	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
10	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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12 Install 1 fastener in the flange of Frame 55, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBFAA Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBFAA Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

14 On the Frame 55 flange, at STGR 35 LH, refer to Fig. A-GBFAA Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 55 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBFAA Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 55 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBFAA Sheet 02, View C and Fig. A-GBFAA Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBFAA Sheet 02, View C and Fig. A-GBFAA Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAA Sheet 04.

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18 On the Frame 55 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 55, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 55 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBFAA Sheet 02, View C and Fig. A-GBFAA Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

21 On the Frame 55 flange, at STGR 36 LH, refer to Fig. A-GBFAA Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 55 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBFAA Sheet 03, Section B-B.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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23 On the Frame 55 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBFAA Sheet 02, View C and Fig. A-GBFAA Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBFAA Sheet 02, View C and Fig. A-GBFAA Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAA Sheet 04.

25 On the Frame 55 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 55, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 55 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBFAA Sheet 02, View C and Fig. A-GBFAA Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Rivet	EN6081D6-07	Item 667

28 On the Frame 55 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBFAA Sheet 02, View C and Fig. A-GBFAA Sheet 03, Section C-C.

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1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 55 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBFAA Sheet 02, View C.

1	Angle	D5347046820400	Item (120)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-09	Item 669	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

30 On the Frame 55 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBFAA Sheet 02, View C and Fig. A-GBFAA Sheet 03, Section D-D.

1	Angle-Support	D5347068120000	Item (102)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-08	Item 668	

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2	Rivet	EN6081D5-07	Item 657

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(9) Subtask 531364-831-209-003 - Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 56 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D01R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
14	E5347001021000	1	WEB	
16	E5347001120400	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
567	EN6069D6-07	10	RIVET	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	9	RIVET	
668	EN6081D6-08	24	RIVET	(1)
669	EN6081D6-09	10	RIVET	(2)
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	1	PIN	
806	NSA5075-6	24	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	10	NUT	
863	DAN6-6-3	17	PIN	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	2	PIN	
965	DAN5-6-5	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

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NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBGAA Replacement of Webs and Angles at Frame 56	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBGAA Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 56, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347078720000	Item (9)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 56, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 34 LH and STGR 36 LH, remove:

12	Rivet		Item (100)	Discard

3 From Frame 56, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347078820000	Item (10)	Discard
	with			

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14	Rivet		Item (100)	Discard

4 From Frame 56, between STGR 36 LH and STGR 39 LH, remove:

1	Shear web	D5347078620000	Item (11)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle-Support	D5347068120000	Item (102)	Retain
1	Angle	D5347046820600	Item (121)	Retain
1	Support	D5347068520100	Item (134)	Retain
	with			
64	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 56.

Refer to NTM 51-10-01.

Refer to Fig. A-GBGAA Sheet 02, Views C and D.

1 On Frame 56, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 56, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM

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51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBGAA Sheet 02 thru Fig. A-GBGAA Sheet 04.

1 On Frame 56, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBGAA Sheet 02, View C.

1	Shear Web	E5347001021000	Item 14

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 56 between STGR 36 LH and 37 LH to the shear web, Item 14.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAA Sheet 04.

4 Drill the additional 6 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBGAA Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBGAA Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAA Sheet 04.

5 Transfer drill the tack hole from the Frame 56 to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 56, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021000	Item 14

7 Clean and deburr the new fastener holes in Frame 56 and the shear web, Item 14, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBGAA Sheet 02, Views C and D.

a On Frame 56, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBGAA Sheet 02, View C.

1	Shear Web	E5347001021000	Item 14

b On Frame 56, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAA Sheet 02, View C.

c On Frame 56, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAA Sheet 02, View C.

d On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAA Sheet 02, View D.

9 On Frame 56, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021000	Item 14

10 Clean and deburr the cold expansion fastener holes in Frame 56 and the shear web, Item 14, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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	Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 56, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBGAA Sheet 02, View C.

1	Shear Web	E5347001021000	Item 14
	with		
3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
10	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
9	Rivet	EN6081D6-06	Item 666
19	Rivet	EN6081D6-08	Item 668
7	Pin	DAN5-6-4X	Item 764
17	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
15	Pin	DAN6-6-3	Item 863
2	Pin	DAN5-6-4	Item 964
	use		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 56, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBGAA Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

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13 On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBGAA Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

14 On the Frame 56 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBGAA Sheet 02, View C and Fig. A-GBGAA Sheet 03, Section A-A.

1	Angle	E5347001120400	Item 16

15 Transfer drill and ream the holes from the Frame 56 and from STGR 35 LH to the angle, Item 16, refer to Fig. A-GBGAA Sheet 02, View C and Fig. A-GBGAA Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAA Sheet 04.

16 On the Frame 56 flange, at STGR 35 LH, remove:

1	Angle	E5347001120400	Item 16

17 Clean and deburr the new fastener holes in the Frame 56, STGR 35 LH and angle, Item 16, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

18 On the Frame 56 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBGAA Sheet 02, View C and Fig. A-GBGAA Sheet 03, Section A-A.

1	Angle	E5347001120400	Item 16

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656	
2	Rivet	EN6081D6-09	Item 669	
1	Collar	NSA5075-6	Item 806	
1	Pin	DAN5-6-5	Item 965	

19 On the Frame 56 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBGAA Sheet 02, View C and Fig. A-GBGAA Sheet 03, Section B-B.

1	Support	D5347068520100	Item (134)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D6-08	Item 668	

20 On the Frame 56 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBGAA Sheet 02, View C and Fig. A-GBGAA Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

21 On the aft side of the Frame 56 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBGAA Sheet 02, View C.

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1	Angle	D5347046820600	Item (121)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-09	Item 669	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

22 On the Frame 56 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBGAA Sheet 02, View C and Fig. A-GBGAA Sheet 03, Section D-D.

1	Angle-Support	D5347068120000	Item (102)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-08	Item 668	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		

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Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(10) Subtask 531364-831-210-003 - Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 57 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D01R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
18	E5347001021200	1	WEB	
20	E5347001123800	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	1	RIVET	
668	EN6081D6-08	17	RIVET	(1)
669	EN6081D6-09	10	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	19	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	10	NUT	
863	DAN6-6-3	11	PIN	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	

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NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBHAA Replacement of Webs and Angles at Frame 57	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBHAA Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 57, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347081820000	Item (12)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 57, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

8	Rivet		Item (100)	Discard

3 From Frame 57, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347081720000	Item (13)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 57, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347081620000	Item (14)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle-Support	D5347068120000	Item (102)	Retain
1	Angle	D5347046820200	Item (118)	Retain
	with			
57	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

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Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 57.

Refer to NTM 51-10-01.

Refer to Fig. A-GBHAA Sheet 02, Views C and D.

1 On Frame 57, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 57, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBHAA Sheet 02 thru Fig. A-GBHAA Sheet 04.

1 On Frame 57, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBHAA Sheet 02, View C.

1	Shear Web	E5347001021200	Item 18

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 57 between STGR 36 LH and 37 LH to the shear web, Item 18.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAA Sheet 04.

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4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBHAA Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBHAA Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAA Sheet 04.

5 Transfer drill the tack hole from the Frame 57 to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 57, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021200	Item 18

7 Clean and deburr the new fastener holes in Frame 57 and the shear web, Item 18, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBHAA Sheet 02, Views C and D.

a On Frame 57, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBHAA Sheet 02, View C.

1	Shear Web	E5347001021200	Item 18

b On Frame 57, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAA Sheet 02, View C.

c On Frame 57, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAA Sheet 02, View C.

d On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAA Sheet 02, View D.

9 On Frame 57, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021200	Item 18

10 Clean and deburr the cold expansion fastener holes in Frame 57 and the shear web, Item 18, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 57, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBHAA Sheet 02, View C.

1	Shear Web	E5347001021200	Item 18

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764

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13	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863
1	Pin	DAN5-6-3	Item 963
2	Pin	DAN5-6-4	Item 964

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 57, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBHAA Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBHAA Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

14 On the Frame 57 flange, at STGR 35 LH, refer to Fig. A-GBHAA Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 57 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBHAA Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 57 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBHAA Sheet 02, View C and Fig. A-GBHAA Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBHAA Sheet 02, View C and Fig. A-GBHAA Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAA Sheet 04.

18 On the Frame 57 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 57, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 57 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBHAA Sheet 02, View C and Fig. A-GBHAA Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765

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1	Collar	DAN11-6X	Item 807

21 On the Frame 57 flange, at STGR 36 LH, refer to Fig. A-GBHAA Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 57 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBHAA Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 57 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBHAA Sheet 02, View C and Fig. A-GBHAA Sheet 03, Section B-B.

1	Angle	E5347001123800	Item 20

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 20, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the two holes form the Frame to the angle, Item 20, refer to Fig. A-GBHAA Sheet 02, View C and Fig. A-GBHAA Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAA Sheet 04.

25 On the Frame 57 flange, at STGR 36 LH, remove:

1	Angle	E5347001123800	Item 20

26 Clean and deburr the new fastener holes in the Frame 57, STGR 36 LH and angle, Item 20, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 57 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBHAA Sheet 02, View C and Fig. A-GBHAA Sheet 03, Section B-B.

1	Angle	E5347001123800	Item 20

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-06	Item 656	
1	Rivet	EN6081D6-07	Item 667	
1	Collar	NSA5075-6	Item 806	
1	Pin	DAN5-6-4	Item 964	

28 On the Frame 57 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBHAA Sheet 02, View C and Fig. A-GBHAA Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 57 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBHAA Sheet 02, View C.

1	Angle	D5347046820200	Item (118)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D6-09	Item 669	

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1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

30 On the Frame 57 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBHAA Sheet 02, View C and Fig. A-GBHAA Sheet 03, Section D-D.

1	Angle-Support	D5347068120000	Item (102)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-08	Item 668	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(11) Subtask 531364-831-211-003 - Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 58 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D01R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
22	E5347001021400	1	WEB	
24	E5347001120600	1	ANGLE	
26	E5347001120800	1	ANGLE	
363	EN6115K3-3	5	BOLT	
364	EN6115K3-4	3	BOLT	
374	EN6115K3A4	2	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
567	EN6069D6-07	14	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	3	RIVET	
666	EN6081D6-06	2	RIVET	
667	EN6081D6-07	4	RIVET	
668	EN6081D6-08	6	RIVET	(1)
670	EN6081D7-10	4	RIVET	
678	EN6081D7-08	6	RIVET	
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	20	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	9	NUT	
863	DAN6-6-3	9	PIN	
908	ASNA2528-3A	2	NUT	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	5	PIN	
965	DAN5-6-5	2	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBJAA Replacement of Webs and Angles at Frame 58	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBJAA Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 58, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347082420000	Item (15)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 58, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 58, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347080520000	Item (16)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 58, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347083020000	Item (17)	Discard
1	Support	D5347032200600	Item (104)	Retain
1	Angle-Support	D5347069520000	Item (105)	Retain
1	Angle	D5347046820800	Item (125)	Retain
	with			
50	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 58.

Refer to NTM 51-10-01.

Refer to Fig. A-GBJAA Sheet 02, Views C and D.

1 On Frame 58, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 58, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 364 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 On the top flange of Frame 58, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBJAA Sheet 02 thru Fig. A-GBJAA Sheet 04.

1 On Frame 58, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBJAA Sheet 02, View C.

1	Shear Web	E5347001021400	Item 22

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 58 between STGR 36 LH and 37 LH to the shear web, Item 22.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAA Sheet 04.

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4 Drill the additional 10 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBJAA Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBJAA Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAA Sheet 04.

5 Transfer drill the tack hole from the Frame 58 to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 58, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021400	Item 22

7 Clean and deburr the new fastener holes in Frame 58 and the shear web, Item 22, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBJAA Sheet 02, Views C, D and F.

a On Frame 58, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBJAA Sheet 02, View C.

1	Shear Web	E5347001021400	Item 22

b On Frame 58, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAA Sheet 02, View C.

c On Frame 58, between STGR 36 LH and STGR 37 LH, cold expand the 5 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAA Sheet 02, View C.

d On Frame 58, between STGR 36 LH and STGR 37 LH, cold expand the 2 holes for the fasteners, Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAA Sheet 02, View C.

e On the top flange of Frame 58, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAA Sheet 02, View D.

f On the top flange of Frame 58, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAA Sheet 02, View F.

9 On Frame 58, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021400	Item 22

10 Clean and deburr the cold expansion fastener holes in Frame 58 and the shear web, Item 22, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 58, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBJAA Sheet 02, View C.

1	Shear Web	E5347001021400	Item 22

with

4	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
2	Bolt	EN6115K3A4	Item 374
14	Rivet	EN6069D6-07	Item 567
7	Pin	DAN5-6-4X	Item 764
8	Rivet	EN6081D5-06	Item 656

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2	Rivet	EN6081D6-06	Item 666
4	Rivet	EN6081D6-08	Item 668
6	Rivet	EN6081D7-08	Item 678
13	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
7	Nut	ASNA2528-3	Item 808
8	Pin	DAN6-6-3	Item 863
2	Nut	ASNA2528-3A	Item 908
5	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 58, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBJAA Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 58, at STGR 35 LH, install:

Refer to Fig. A-GBJAA Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

14 On the Frame 58 flange, at STGR 35 LH, refer to Fig. A-GBJAA Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 58 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBJAA Sheet 03, Section A-A.

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1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 58 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBJAA Sheet 02, View C and Fig. A-GBJAA Sheet 03, Section A-A.

1	Angle	E5347001120600	Item 24

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 24, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 24, refer to Fig. A-GBJAA Sheet 02, View C and Fig. A-GBJAA Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAA Sheet 04.

18 On the Frame 58 flange, at STGR 35 LH, remove:

1	Angle	E5347001120600	Item 24

19 Clean and deburr the new fastener holes in the Frame 58, STGR 35 LH and angle, Item 24, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 58 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBJAA Sheet 02, View C and Fig. A-GBJAA Sheet 03, Section A-A.

1	Angle	E5347001120600	Item 24

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656

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1	Pin	DAN5-6-5X	Item 765
2	Collar	NSA5075-6	Item 806
1	Collar	DAN11-6X	Item 807
2	Pin	DAN5-6-5	Item 965

21 On the Frame 58 flange, at STGR 36 LH, refer to Fig. A-GBJAA Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 58 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBJAA Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 58 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBJAA Sheet 02, View C and Fig. A-GBJAA Sheet 03, Section B-B.

1	Angle	E5347001120800	Item 26

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 26, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH to the angle, Item 26, refer to Fig. A-GBJAA Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAA Sheet 04.

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 26, to the Frame 58 flange, at STGR 36 LH, then transfer drill and ream the two holes from the Frame to the angle, Item 26, refer to Fig. A-GBJAA Sheet 03, View E.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAA Sheet 04.

26 On the Frame 58 flange, at STGR 36 LH, remove:

1	Angle	E5347001120800	Item 26

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27 Clean and deburr the new fastener holes in the Frame 58, STGR 36 LH and angle, Item 26, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 58 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBJAA Sheet 02, View C and Fig. A-GBJAA Sheet 03, Section B-B.

1	Angle	E5347001120800	Item 26

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

29 On the Frame 58 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBJAA Sheet 02, View C and Fig. A-GBJAA Sheet 03, Section C-C.

1	Support	D5347032200600	Item (104)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Rivet	EN6081D7-10	Item 670
4	Collar	NSA5075-6	Item 806
4	Pin	DAN5-6-3	Item 963

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30 On the aft side of the Frame 58 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBJAA Sheet 02, View C.

1	Angle	D5347046820800	Item (125)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

31 On the Frame 58 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBJAA Sheet 02, View C and Fig. A-GBJAA Sheet 03, Section D-D.

1	Angle-Support	D5347069520000	Item (105)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required

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for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(12) Subtask 531364-831-212-003 - Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 59 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D01R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
28	E5347001021600	1	WEB	
30	E5347001121000	1	ANGLE	
32	E5347001121200	1	ANGLE	
363	EN6115K3-3	5	BOLT	
364	EN6115K3-4	2	BOLT	
365	EN6115K3-5	3	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	20	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	20	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	9	RIVET	(1)
669	EN6081D6-09	3	RIVET	(2)
764	DAN5-6-4X	3	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	21	COLLAR	
807	DAN11-6X	5	COLLAR	
808	ASNA2528-3	11	NUT	
863	DAN6-6-3	8	PIN	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	6	PIN	
965	DAN5-6-5	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01

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References	
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBKAA Replacement of Webs and Angles at Frame 59	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBKAA Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 59, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347089120000	Item (18)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 59, at STGR 35 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

5	Rivet		Item (100)	Discard

3 From Frame 59, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347089020000	Item (19)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 59, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347088920000	Item (20)	Discard
1	Support	D5347032201000	Item (106)	Retain
1	Angle	D5347046821000	Item (127)	Retain
1	Angle-Support	D5347068820000	Item (107)	Retain
	with			

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59	Rivet	Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 59.

Refer to NTM 51-10-01.

Refer to Fig. A-GBKAA Sheet 02, Views C and D.

1 On Frame 59, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 59, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 7 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 59, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBKAA Sheet 02 thru Fig. A-GBKAA Sheet 04.

1 On Frame 59, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBKAA Sheet 02, View C.

1	Shear Web	E5347001021600	Item 28

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2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 59 to the shear web, Item 28.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAA Sheet 04.

4 Drill the additional 17 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBKAA Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBKAA Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAA Sheet 04.

5 Transfer drill the tack hole from the Frame 59 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 59, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021600	Item 28

7 Clean and deburr the new fastener holes in Frame 59 and the shear web, Item 28, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBKAA Sheet 02, Views C and D.

a On Frame 59, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBKAA Sheet 02, View C.

1	Shear Web	E5347001021600	Item 28

b On Frame 59, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

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FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAA Sheet 02, View C.

c On Frame 59, between STGR 36 LH and STGR 37 LH, cold expand the 7 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAA Sheet 02, View C.

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d On the top flange of Frame 59, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAA Sheet 02, View D.

9 On Frame 59, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021600	Item 28

10 Clean and deburr the cold expansion fastener holes in Frame 59 and the shear web, Item 28, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 59, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBKAA Sheet 02, View C.

1	Shear Web	E5347001021600	Item 28

with

4	Bolt	EN6115K3-3	Item 363
2	Bolt	EN6115K3-4	Item 364

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15	Rivet	EN6069D6-07	Item 567
16	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D6-06	Item 666
5	Rivet	EN6081D6-08	Item 668
3	Pin	DAN5-6-4X	Item 764
14	Collar	NSA5075-6	Item 806
3	Collar	DAN11-6X	Item 807
6	Nut	ASNA2528-3	Item 808
8	Pin	DAN6-6-3	Item 863
6	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 59, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBKAA Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 59, at STGR 35 LH, install:

Refer to Fig. A-GBKAA Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

14 On the Frame 59 flange, at STGR 35 LH, refer to Fig. A-GBKAA Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 59 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBKAA Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 59 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBKAA Sheet 02, View C and Fig. A-GBKAA Sheet 03, Section A-A.

1	Angle	E5347001121000	Item 30

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 30, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 30, refer to Fig. A-GBKAA Sheet 02, View C and Fig. A-GBKAA Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAA Sheet 04.

18 On the Frame 59 flange, at STGR 35 LH, remove:

1	Angle	E5347001121000	Item 30

19 Clean and deburr the new fastener holes in the Frame 59, STGR 35 LH and angle, Item 30, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 59 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBKAA Sheet 02, View C and Fig. A-GBKAA Sheet 03, Section A-A.

1	Angle	E5347001121000	Item 30

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Collar	NSA5075-6	Item 806

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3	Pin	DAN5-6-5	Item 965

21 On the Frame 59 flange, at STGR 36 LH, refer to Fig. A-GBKAA Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 59 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBKAA Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 59 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBKAA Sheet 02, View C and Fig. A-GBKAA Sheet 03, Section B-B.

1	Angle	E5347001121200	Item 32

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 32, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 32, refer to Fig. A-GBKAA Sheet 02, View C and Fig. A-GBKAA Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAA Sheet 04.

25 On the Frame 59 flange, at STGR 36 LH, remove:

1	Angle	E5347001121200	Item 32

26 Clean and deburr the new fastener holes in the Frame 59, STGR 36 LH and angle, Item 32, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 59 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBKAA Sheet 02, View C and Fig. A-GBKAA Sheet 03, Section B-B.

1	Angle	E5347001121200	Item 32

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	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D6-07	Item 667	
	28 On the Frame 59 flange, at STGR 37 LH, wet install:			
	Refer to Fig. A-GBKAA Sheet 02, View C and Fig. A-GBKAA Sheet 03, Section C-C.			
1	Support	D5347032201000	Item (106)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Bolt	EN6115K3-5	Item 365	
3	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
3	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	
	29 On the Frame 59 flange, at STGR 38 LH, wet install:			
	Refer to Fig. A-GBKAA Sheet 02, View C.			
1	Angle	D5347046821000	Item (127)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-08	Item 668	

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1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

30 On the Frame 59 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBKAA Sheet 02, View C and Fig. A-GBKAA Sheet 03, Section D-D.

1	Angle-Support	D5347068820000	Item (107)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

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(13) Subtask 531364-831-213-003 - Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 60 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D01R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
34	E5347001021800	1	WEB	
38	E5347001121600	1	ANGLE	
40	E5347001121800	1	ANGLE	
363	EN6115K3-3	5	BOLT	
365	EN6115K3-5	8	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
567	EN6069D6-07	8	RIVET	
656	EN6081D5-06	41	RIVET	
666	EN6081D6-06	25	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	4	RIVET	(2)
764	DAN5-6-4X	4	PIN	
765	DAN5-6-5X	1	PIN	
806	NSA5075-6	31	COLLAR	
807	DAN11-6X	5	COLLAR	
808	ASNA2528-3	14	NUT	
863	DAN6-6-3	12	PIN	
864	DAN6-6-4	5	PIN	
865	DAN6-6-5	5	PIN	
963	DAN5-6-3	1	PIN	
964	DAN5-6-4	4	PIN	
965	DAN5-6-5	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBLAA Replacement of Webs and Angles at Frame 60	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBLAA Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 60, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347085020000	Item (21)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 60, at STGR 35 LH and from the frame flange between STGR 34 LH and STGR 35 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 60, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347085120000	Item (22)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 60, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347093120000	Item (23)	Discard
1	Support	D5347032201200	Item (108)	Retain
1	Angle	D5347046821200	Item (128)	Retain
1	Section-Connecting	D5347065420400	Item (136)	Retain
1	Shim	D5347044920000	Item (142)	Retain
1	Shim	D5347044920600	Item (143)	Retain
	with			
77	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

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and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 60.

Refer to NTM 51-10-01.

Refer to Fig. A-GBLAA Sheet 02, Views C and D.

1 On Frame 60, at STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 60, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 60, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBLAA Sheet 02 thru Fig. A-GBLAA Sheet 04.

1 On Frame 60, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBLAA Sheet 02, View C.

1	Shear Web	E5347001021800	Item 34

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 60 to the shear web, Item 34.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAA Sheet 04.

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4 Drill the additional 38 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBLAA Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBLAA Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAA Sheet 04.

5 Transfer drill the tack hole from the Frame 60 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 60, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021800	Item 34

7 Clean and deburr the new fastener holes in Frame 60 and the shear web, Item 34, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBLAA Sheet 02, Views C and D.

a On Frame 60, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBLAA Sheet 02, View C.

1	Shear Web	E5347001021800	Item 34

b On Frame 60, at STGR 35 LH, cold expand the 4 holes for the fasteners, Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAA Sheet 02, View C.

c On Frame 60, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAA Sheet 02, View C.

d On the top flange of Frame 60, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAA Sheet 02, View D.

9 On Frame 60, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021800	Item 34

10 Clean and deburr the cold expansion fastener holes in Frame 60 and the shear web, Item 34, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 60, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBLAA Sheet 02, View C.

1	Shear Web	E5347001021800	Item 34

with

5	Bolt	EN6115K3-3	Item 363
8	Rivet	EN6069D6-07	Item 567
37	Rivet	EN6081D5-06	Item 656
25	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
4	Pin	DAN5-6-4X	Item 764
12	Collar	NSA5075-6	Item 806
4	Collar	DAN11-6X	Item 807

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5	Nut	ASNA2528-3	Item 808
12	Pin	DAN6-6-3	Item 863

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 On the top flange of Frame 60, at STGR 35 LH, install:

Refer to Fig. A-GBLAA Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

13 On the Frame 60 flange, at STGR 35 LH, refer to Fig. A-GBLAA Sheet 03, Section B-B, countersink the one fastener hole.

14 On the Frame 60 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBLAA Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 60 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBLAA Sheet 02, View C and Fig. A-GBLAA Sheet 03, Section B-B.

1	Angle	E5347001121600	Item 38

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 38, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH to the angle, Item 38, refer to Fig. A-GBLAA Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAA Sheet 04.

17 On the Frame 60 flange, at STGR 35 LH, remove:

1	Angle	E5347001121600	Item 38

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18 Clean and deburr the new fastener holes in the STGR 35 LH and angle, Item 38, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 60 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBLAA Sheet 02, View C and Fig. A-GBLAA Sheet 03, Section B-B.

1	Angle	E5347001121600	Item 38

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
2	Rivet	EN6081D5-06	Item 656
4	Nut	ASNA2528-3	Item 808

20 On the Frame 60 flange, at STGR 36 LH, refer to Fig. A-GBLAA Sheet 03, Section C-C, countersink the one fastener hole.

21 On the Frame 60 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBLAA Sheet 03, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 60 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBLAA Sheet 02, View C and Fig. A-GBLAA Sheet 03, Section C-C.

1	Angle	E5347001121800	Item 40

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23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 40, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 40, refer to Fig. A-GBLAA Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAA Sheet 04.

24 On the Frame 60 flange, at STGR 36 LH, remove:

1	Angle	E5347001121800	Item 40

25 Clean and deburr the new fastener holes in the Frame 60, STGR 36 LH and angle, Item 40, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 60 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBLAA Sheet 02, View C and Fig. A-GBLAA Sheet 03, Section C-C.

1	Angle	E5347001121800	Item 40

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D6-07	Item 667

27 On the Frame 60 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBLAA Sheet 02, View C and Fig. A-GBLAA Sheet 03, Section D-D.

1	Support	D5347032201200	Item (108)	Retained at removal
1	Section-Connecting	D5347065420400	Item (136)	Retained at removal

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1	Shim	D5347044920000	Item (142)	Retained at removal
1	Shim	D5347044920600	Item (143)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	
19	Collar	NSA5075-6	Item 806	
4	Nut	ASNA2528-3	Item 808	
5	Pin	DAN6-6-4	Item 864	
5	Pin	DAN6-6-5	Item 865	
1	Pin	DAN5-6-3	Item 963	
4	Pin	DAN5-6-4	Item 964	
4	Pin	DAN5-6-5	Item 965	

28 On the aft side of the Frame 60 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBLAA Sheet 02, View C.

1	Angle	D5347046821200	Item (128)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

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(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(14) Subtask 531364-831-214-003 - Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 61 from Stringer 33 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D01R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
42	E5347001022000	1	WEB	
44	E5347001122000	1	ANGLE	
46	E5347001122200	1	ANGLE	
48	E5347001122400	1	ANGLE	
363	EN6115K3-3	6	BOLT	
364	EN6115K3-4	3	BOLT	
365	EN6115K3-5	4	BOLT	
463	EN6114K3-3	1	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
555	EN6069D5-05	3	RIVET	
567	EN6069D6-07	20	RIVET	
656	EN6081D5-06	36	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	22	RIVET	
667	EN6081D6-07	10	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	6	RIVET	(2)
763	DAN5-6-3X	4	PIN	
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	13	COLLAR	
808	ASNA2528-3	14	NUT	
863	DAN6-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

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NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBMAA Replacement of Webs and Angles at Frame 61	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBMAA Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 61, between STGR 33 LH and STGR 34 LH, remove:

1	Clip	D5347091620200	Item (24)	Discard
	with			
12	Rivet		Item (100)	Discard
	or			
13	Rivet		Item (100)	Discard

NOTE: Depending on installation on aircraft.

2 From Frame 61, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347090620000	Item (25)	Discard
	with			

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13	Rivet		Item (100)	Discard

3 From the top flange of Frame 61, between STGR 34 LH and STGR 35 LH and from the frame flange between STGR 34 LH and STGR 35 LH, remove:

11	Rivet		Item (100)	Discard

4 From Frame 61, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347090720000	Item (26)	Discard
	with			
13	Rivet		Item (100)	Discard

5 From Frame 61, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347090820000	Item (27)	Discard
1	Support	D5347032201600	Item (109)	Retain
1	Angle-Support	D5347069620000	Item (110)	Retain
1	Angle	D5347046821400	Item (130)	Retain
	with			
65	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 61.

Refer to NTM 51-10-01.

Refer to Fig. A-GBMAA Sheet 02, Views C and E.

1 On Frame 61, at STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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2 On Frame 61, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 61, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBMAA Sheet 02 thru Fig. A-GBMAA Sheet 04.

1 On Frame 61, between STGR 33 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBMAA Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 61 to the shear web, Item 42.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAA Sheet 04.

4 Drill the additional 31 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBMAA Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBMAA Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAA Sheet 04.

5 Transfer drill the tack hole from the Frame 61 between STGR 36 LH and STGR 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 61, between STGR 33 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022000	Item 42

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7 Clean and deburr the new fastener holes in Frame 61 and the shear web, Item 42, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBMAA Sheet 02, Views C and E.

a On Frame 61, between STGR 33 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBMAA Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

b On Frame 61, at STGR 35 LH, cold expand the 4 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAA Sheet 02, View C.

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c On Frame 61, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAA Sheet 02, View C.

d On the top flange of Frame 61, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAA Sheet 02, View E.

9 On Frame 61, between STGR 33 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022000	Item 42

10 Clean and deburr the cold expansion fastener holes in Frame 61 and the shear web, Item 42, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 61, between STGR 33 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBMAA Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

with

5	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
20	Rivet	EN6069D6-07	Item 567
28	Rivet	EN6081D5-06	Item 656
22	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
4	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
4	Pin	DAN6-6-3	Item 863

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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12 Install 1 fastener in the flange of Frame 61, between STGR 34 LH and STGR 35 LH:

Refer to Fig. A-GBMAA Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 61, at STGR 35 LH, install:

Refer to Fig. A-GBMAA Sheet 02, View E.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

14 On the Frame 61 flange, at STGR 34 LH, refer to Fig. A-GBMAA Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 61 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBMAA Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 61 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBMAA Sheet 02, View C and Fig. A-GBMAA Sheet 03, Section A-A.

1	Angle	E5347001122000	Item 44

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 44, to the STGR 34 LH, then transfer drill and ream the other hole in STGR 34 LH and the three holes from the Frame to the angle, Item 44, refer to Fig. A-GBMAA Sheet 02, View C and Fig. A-GBMAA Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAA Sheet 04.

18 On the Frame 61 flange, at STGR 34 LH, remove:

1	Angle	E5347001122000	Item 44

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19 Clean and deburr the new fastener holes in the Frame 61, STGR 34 LH and angle, Item 44, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 61 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBMAA Sheet 02, View C and Fig. A-GBMAA Sheet 03, Section A-A.

1	Angle	E5347001122000	Item 44

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

If necessary, close the rivet hole in the frame flange at STGR 34 LH with:

1	Rivet	EN6081D6-06	Item 666

NOTE: Depending on installation on aircraft.

21 On the Frame 61 flange, at STGR 35 LH, refer to Fig. A-GBMAA Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 61 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBMAA Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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23 On the Frame 61 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBMAA Sheet 02, View C and Fig. A-GBMAA Sheet 03, Section B-B.

1	Angle	E5347001122200	Item 46

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 46, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the four hole from the Frame to the angle, Item 46, refer to Fig. A-GBMAA Sheet 02, View C and Fig. A-GBMAA Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAA Sheet 04.

25 On the Frame 61 flange, at STGR 35 LH, remove:

1	Angle	E5347001122200	Item 46

26 Clean and deburr the new fastener holes in the Frame 61, STGR 35 LH and angle, Item 46, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 61 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBMAA Sheet 02, View C and Fig. A-GBMAA Sheet 03, Section B-B.

1	Angle	E5347001122200	Item 46

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
4	Rivet	EN6081D6-07	Item 667

28 On the Frame 61 flange, at STGR 36 LH, refer to Fig. A-GBMAA Sheet 03, Section C-C, countersink the one fastener hole.

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29 On the Frame 61 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBMAA Sheet 03, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

30 On the Frame 61 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBMAA Sheet 02, View C and Fig. A-GBMAA Sheet 03, Section C-C.

1	Angle	E5347001122400	Item 48

31 Transfer drill and ream one new hole from the pilot hole of the angle, Item 48, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 48, refer to Fig. A-GBMAA Sheet 02, View C and Fig. A-GBMAA Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAA Sheet 04.

32 On the Frame 61 flange, at STGR 36 LH, remove:

1	Angle	E5347001122400	Item 48

33 Clean and deburr the new fastener holes in the Frame 61, STGR 36 LH and angle, Item 48, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

34 On the Frame 61 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBMAA Sheet 02, View C and Fig. A-GBMAA Sheet 03, Section C-C.

1	Angle	E5347001122400	Item 48

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656	
2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

35 On the Frame 61 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBMAA Sheet 02, View C and Fig. A-GBMAA Sheet 03, Section D-D.

1	Support	D5347032201600	Item (109)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
4	Rivet	EN6081D6-09	Item 669
4	Pin	DAN5-6-3X	Item 763
4	Collar	DAN11-6X	Item 807
4	Nut	ASNA2528-3	Item 808

36 On the Frame 61 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBMAA Sheet 02, View C.

1	Angle	D5347046821400	Item (130)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

3	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

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37 On the Frame 61 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBMAA Sheet 02, View C and Fig. A-GBMAA Sheet 03, Section E-E.

1	Angle-Support	D5347069620000	Item (110)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(15) Subtask 531364-831-215-003 - Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 62 from Stringer 32 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D01R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
50	E5347001022200	1	WEB	
52	E5347001122600	1	ANGLE	
54	E5347001122800	1	ANGLE	
56	E5347001123000	1	ANGLE	
58	E5347001123200	1	ANGLE	
363	EN6115K3-3	6	BOLT	
364	EN6115K3-4	3	BOLT	
365	EN6115K3-5	4	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	4	RIVET	
567	EN6069D6-07	12	RIVET	
656	EN6081D5-06	45	RIVET	
657	EN6081D5-07	7	RIVET	
666	EN6081D6-06	20	RIVET	
667	EN6081D6-07	7	RIVET	
668	EN6081D6-08	16	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	5	PIN	
765	DAN5-6-5X	3	PIN	
806	NSA5075-6	26	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	14	NUT	
863	DAN6-6-3	16	PIN	
864	DAN6-6-4	1	PIN	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	
965	DAN5-6-5	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBNAA Replacement of Webs and Angles at Frame 62	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBNAA Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 62, between STGR 32 LH and STGR 33 LH, remove:

1	Clip	D5347093420200	Item (28)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From Frame 62, between STGR 33 LH and STGR 34 LH, remove:

1	Clip	D5347084020000	Item (29)	Discard
	with			
13	Rivet		Item (100)	Discard

3 From Frame 62, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347084120000	Item (30)	Discard
	with			
11	Rivet		Item (100)	Discard

4 From the top flange of Frame 62, at STGR 34 LH and from the frame flange between STGR 32 LH and STGR 35 LH, remove:

13	Rivet		Item (100)	Discard

5 From Frame 62, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347084220000	Item (31)	Discard
	with			
11	Rivet		Item (100)	Discard

6 From Frame 62, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347084820000	Item (32)	Discard
1	Support	D5347032201800	Item (111)	Retain
1	Angle	D5347046821600	Item (131)	Retain

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1	Angle-Support	D5347069720000	Item (112)	Retain
	with			
58	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 62.

Refer to NTM 51-10-01.

Refer to Fig. A-GBNAA Sheet 02, Views C and Fig. A-GBNAA Sheet 03, View F.

1 On Frame 62, between STGR 34 LH and STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 62, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBNAA Sheet 02 thru Fig. A-GBNAA Sheet 06.

1 On Frame 62, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBNAA Sheet 02, View C.

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1	Shear Web	E5347001022200	Item 50

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 62 to the shear web, Item 50.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAA Sheet 06.

4 On Frame 62, between STGR 34 LH and STGR 37 LH, drill the additional 42 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBNAA Sheet 03, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBNAA Sheet 03.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAA Sheet 06.

5 On Frame 62, between STGR 38 LH and STGR 39 LH, drill the additional rivet hole to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBNAA Sheet 03, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBNAA Sheet 03.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAA Sheet 06.

6 Transfer drill the tack hole from the Frame 62 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

7 On Frame 62, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022200	Item 50

8 Clean and deburr the new fastener holes in Frame 62 and shear web, Item 50, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

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Refer to Fig. A-GBNAA Sheet 02, Views C and Fig. A-GBNAA Sheet 03, View F.

a On Frame 62, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBNAA Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

b On Frame 62, between STGR 34 LH and STGR 35 LH, cold expand the 4 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAA Sheet 02, View C.

c On Frame 62, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAA Sheet 02, View C.

d On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAA Sheet 03, View F.

10 On Frame 62, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022200	Item 50

11 Clean and deburr the cold expansion fastener holes in Frame 62 and shear web, Item 50, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 62, between STGR 32 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBNAA Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50
	with		
5	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
12	Rivet	EN6069D6-07	Item 567
1	Pin	DAN6-6-4	Item 864
35	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D5-07	Item 657
20	Rivet	EN6081D6-06	Item 666
13	Rivet	EN6081D6-08	Item 668
5	Pin	DAN5-6-4X	Item 764
21	Collar	NSA5075-6	Item 806
5	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
16	Pin	DAN6-6-3	Item 863
1	Pin	DAN5-6-3	Item 963
3	Pin	DAN5-6-4	Item 964
	use		
Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

13 Install 1 fastener in the flange of Frame 62, between STGR 34 LH and STGR 35 LH:

Refer to Fig. A-GBNAA Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363

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1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBNAA Sheet 03, View F.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

15 On the Frame 62 flange, at STGR 33 LH, refer to Fig. A-GBNAA Sheet 04, Section A-A, countersink the one fastener hole.

16 On the Frame 62 flange, at STGR 33 LH, close the rivet hole in STGR 33 LH with:

Refer to Fig. A-GBNAA Sheet 04, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 62 flange, at STGR 33 LH, put in position:

Refer to Fig. A-GBNAA Sheet 02, View C and Fig. A-GBNAA Sheet 04, Section A-A.

1	Angle	E5347001122600	Item 52

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 52, to the STGR 33 LH, then transfer drill and ream the other hole from STGR 33 LH and the three holes from the Frame to the angle, Item 52, refer to Fig. A-GBNAA Sheet 02, View C and Fig. A-GBNAA Sheet 04, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAA Sheet 06.

19 On the Frame 62 flange, at STGR 33 LH, remove:

1	Angle	E5347001122600	Item 52

20 Clean and deburr the new fastener holes in the Frame 62, STGR 33 LH and angle, Item 52, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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	Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 62 flange, at STGR 33 LH, wet install:

Refer to Fig. A-GBNAA Sheet 02, View C and Fig. A-GBNAA Sheet 04, Section A-A.

1	Angle	E5347001122600	Item 52
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Collar	NSA5075-6	Item 806
1	Pin	DAN5-6-5	Item 965

22 On the Frame 62 flange, at STGR 34 LH, refer to Fig. A-GBNAA Sheet 04, Section B-B, countersink the one fastener hole.

23 On the Frame 62 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBNAA Sheet 04, Section B-B.

1	Rivet	EN6069D5-05	Item 555
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 62 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBNAA Sheet 02, View C and Fig. A-GBNAA Sheet 04, Section B-B.

1	Angle	E5347001122800	Item 54

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25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 54, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH and the three holes from the Frame to the angle, Item 54, refer to Fig. A-GBNAA Sheet 02, View C and Fig. A-GBNAA Sheet 04, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAA Sheet 06.

26 On the Frame 62 flange, at STGR 34 LH, remove:

1	Angle	E5347001122800	Item 54

27 Clean and deburr the new fastener holes in the Frame 62, STGR 34 LH and angle, Item 54, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 62 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBNAA Sheet 02, View C and Fig. A-GBNAA Sheet 04, Section B-B.

1	Angle	E5347001122800	Item 54

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

29 On the Frame 62 flange, at STGR 34 LH, install:

Refer to Fig. A-GBNAA Sheet 02, View C.

1	Rivet	EN6081D6-07	Item 667

30 On the Frame 62 flange, at STGR 35 LH, refer to Fig. A-GBNAA Sheet 04, Section C-C, countersink the one fastener hole.

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31 On the Frame 62 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBNAA Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

32 On the Frame 62 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBNAA Sheet 02, View C and Fig. A-GBNAA Sheet 04, Section C-C.

1	Angle	E5347001123000	Item 56

33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 56, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the five holes from the Frame to the angle, Item 56, refer to Fig. A-GBNAA Sheet 02, View C and Fig. A-GBNAA Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAA Sheet 06.

34 On the Frame 62 flange, at STGR 35 LH, remove:

1	Angle	E5347001123000	Item 56

35 Clean and deburr the new fastener holes in the Frame 62, STGR 35 LH and angle, Item 56, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

36 On the Frame 62 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBNAA Sheet 02, View C and Fig. A-GBNAA Sheet 04, Section C-C.

1	Angle	E5347001123000	Item 56

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

37 On the Frame 62 flange, at STGR 36 LH, refer to Fig. A-GBNAA Sheet 04, Section D-D, countersink the one fastener hole.

38 On the Frame 62 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBNAA Sheet 04, Section D-D.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

39 On the Frame 62 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBNAA Sheet 02, View C and Fig. A-GBNAA Sheet 04, Section D-D.

1	Angle	E5347001123200	Item 58

40 Transfer drill and ream one new hole from the pilot hole of the angle, Item 58, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 58, refer to Fig. A-GBNAA Sheet 02, View C and Fig. A-GBNAA Sheet 04, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAA Sheet 06.

41 On the Frame 62 flange, at STGR 36 LH, remove:

1	Angle	E5347001123200	Item 58

42 Clean and deburr the new fastener holes in the Frame 62, STGR 36 LH and angle, Item 58, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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43 On the Frame 62 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBNAA Sheet 02, View C and Fig. A-GBNAA Sheet 04, Section D-D.

1	Angle	E5347001123200	Item 58	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	

44 On the Frame 62 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBNAA Sheet 02, View C and Fig. A-GBNAA Sheet 05, Section E-E.

1	Support	D5347032201800	Item (111)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	

45 On the aft side of the Frame 62 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBNAA Sheet 02, View C.

1	Angle	D5347046821600	Item (131)	Retained at removal
	with			

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

46 On the Frame 62 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBNAA Sheet 02, View C and Fig. A-GBNAA Sheet 05, Section F-F.

1	Angle-Support	D5347069720000	Item (112)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
2	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		

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Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(16) Subtask 531364-831-216-003 - Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 63 from Stringer 32 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D01R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
60	E5347001022400	1	WEB	
62	E5347001123400	1	ANGLE	
64	E5347001123600	2	ANGLE	
363	EN6115K3-3	4	BOLT	
365	EN6115K3-5	8	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	3	RIVET	
567	EN6069D6-07	10	RIVET	
656	EN6081D5-06	43	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	20	RIVET	
667	EN6081D6-07	6	RIVET	
668	EN6081D6-08	12	RIVET	(1)
669	EN6081D6-09	7	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	22	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	13	NUT	
863	DAN6-6-3	13	PIN	
864	DAN6-6-4	1	PIN	
963	DAN5-6-3	8	PIN	

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NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBPAA Replacement of Webs and Angles at Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBPAA Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 63, at STGR 33 LH, remove:

1	Shim	D5347032020200	Item (132)	Retain
1	Sheet-Support	D5347109620000	Item (133)	Retain
	with			
7	Rivet		Item (100)	Discard

2 From Frame 63, between STGR 32 LH and STGR 34 LH, remove:

1	Clip	D5347082820000	Item (33)	Discard
	with			
21	Rivet		Item (100)	Discard

3 From the top flange of Frame 63, at STGR 34 LH and from the frame flange between STGR 33 LH and STGR 34 LH, remove:

5	Rivet		Item (100)	Discard

4 From Frame 63, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347079220000	Item (34)	Discard
	with			
10	Rivet		Item (100)	Discard

5 From Frame 63, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347079920000	Item (35)	Discard
	with			
11	Rivet		Item (100)	Discard

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6 From Frame 63, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347082920000	Item (36)	Discard
1	Angle-Support	D5347069820000	Item (113)	Retain
1	Support	D5347032202000	Item (114)	Retain
1	Angle	D5347046821800	Item (115)	Retain
	with			
52	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 63.

Refer to NTM 51-10-01.

Refer to Fig. A-GBPAA Sheet 02, Views C and D.

1 On Frame 63, at STGR 34 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 63, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 8 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 63, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

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(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBPAA Sheet 02 thru Fig. A-GBPAA Sheet 06.

1 On Frame 63, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBPAA Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 63 to the shear web, Item 60.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAA Sheet 06.

4 On Frame 63, between STGR 34 LH and STGR 37 LH, drill the additional 41 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBPAA Sheet 03, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBPAA Sheet 03.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAA Sheet 06.

5 Transfer drill the tack hole from the Frame 63 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 63, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022400	Item 60

7 Clean and deburr the new fastener holes in Frame 63 and the shear web, Item 60, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBPAA Sheet 02, Views C and D.

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a On Frame 63, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBPAA Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

b On Frame 63, at STGR 34 LH, cold expand the 4 holes for the fasteners, Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAA Sheet 02, View C.

c On Frame 63, between STGR 36 LH and STGR 37 LH, cold expand the 8 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAA Sheet 02, View C.

d On the top flange of Frame 63, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAA Sheet 02, View D.

9 On Frame 63, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022400	Item 60

10 Clean and deburr the cold expansion fastener holes in Frame 63 and the shear web, Item 60, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 63, between STGR 32 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBPAA Sheet 02, View C.

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1	Shear Web	E5347001022400	Item 60	
	with			
4	Bolt	EN6115K3-3	Item 363	
10	Rivet	EN6069D6-07	Item 567	
1	Pin	DAN6-6-4	Item 864	
35	Rivet	EN6081D5-06	Item 656	
20	Rivet	EN6081D6-06	Item 666	
10	Rivet	EN6081D6-08	Item 668	
6	Pin	DAN5-6-4X	Item 764	
14	Collar	NSA5075-6	Item 806	
6	Collar	DAN11-6X	Item 807	
4	Nut	ASNA2528-3	Item 808	
13	Pin	DAN6-6-3	Item 863	
	use			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

12 On the Frame 63 flange, at STGR 33 LH, wet install:

Refer to Fig. A-GBPAA Sheet 02, View C and Fig. A-GBPAA Sheet 04, Section A-A.

1	Shim	D5347032020200	Item (132)	Retained at removal
1	Sheet-Support	D5347109620000	Item (133)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	

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4	Pin	DAN5-6-3	Item 963

13 On the Frame 63 flange, at STGR 34 LH, refer to Fig. A-GBPAA Sheet 04, Section B-B, countersink the one fastener hole.

14 On the Frame 63 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBPAA Sheet 04, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 63 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBPAA Sheet 02, View C and Fig. A-GBPAA Sheet 04, Section B-B.

1	Angle	E5347001123400	Item 62

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 62, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH to the angle, Item 62, refer to Fig. A-GBPAA Sheet 04, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAA Sheet 06.

17 On the Frame 63 flange, at STGR 34 LH, remove:

1	Angle	E5347001123400	Item 62

18 Clean and deburr the new fastener holes in the STGR 34 LH and angle, Item 62, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 63 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBPAA Sheet 02, View C and Fig. A-GBPAA Sheet 04, Section B-B.

1	Angle	E5347001123400	Item 62

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
2	Rivet	EN6081D5-06	Item 656
4	Nut	ASNA2528-3	Item 808

20 On the top flange of Frame 63, at STGR 35 LH, install:

Refer to Fig. A-GBPAA Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

21 On the Frame 63 flange, at STGR 35 LH, refer to Fig. A-GBPAA Sheet 04, Section C-C, countersink the one fastener hole.

22 On the Frame 63 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBPAA Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 63 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBPAA Sheet 02, View C and Fig. A-GBPAA Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 64, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the five holes from the Frame to the angle, Item 64, refer to Fig. A-GBPAA Sheet 02, View C and Fig. A-GBPAA Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAA Sheet 06.

25 On the Frame 63 flange, at STGR 35 LH, remove:

1	Angle	E5347001123600	Item 64

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26 Clean and deburr the new fastener holes in the Frame 63, STGR 35 LH and angle, Item 64, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 63 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBPAA Sheet 02, View C and Fig. A-GBPAA Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

28 On the Frame 63 flange, at STGR 36 LH, refer to Fig. A-GBPAA Sheet 04, Section C-C, countersink the one fastener hole.

29 On the Frame 63 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBPAA Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

30 On the Frame 63 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBPAA Sheet 02, View C and Fig. A-GBPAA Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

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31 Transfer drill and ream one new hole from the pilot hole of the angle, Item 64, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 64, refer to Fig. A-GBPAA Sheet 02, View C and Fig. A-GBPAA Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAA Sheet 06.

32 On the Frame 63 flange, at STGR 36 LH, remove:

1	Angle	E5347001123600	Item 64	

33 Clean and deburr the new fastener holes in the Frame 63, STGR 36 LH and angle, Item 64, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

34 On the Frame 63 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBPAA Sheet 02, View C and Fig. A-GBPAA Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

35 On the Frame 63 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBPAA Sheet 02, View C and Fig. A-GBPAA Sheet 05, Section D-D.

1	Support	D5347032202000	Item (114)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	

36 On the Frame 63 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBPAA Sheet 02, View C.

1	Angle	D5347046821800	Item (115)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

37 On the Frame 63 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBPAA Sheet 02, View C and Fig. A-GBPAA Sheet 05, Section E-E.

1	Angle-Support	D5347069820000	Item (113)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	

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2	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(17) Subtask 531364-831-217-003 - Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 49 to Frame 59 Stringer 38 LH
To	160	Work location	from Frame 60 to Frame 63 Stringer 38 LH

Manpower Resources	
Manhours	6.50
Minimum number of person	2
Subtask elapsed time	6.50
Skills	AIRFRAME

Material necessary to do the job

Kit 531364D01R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
544	EN6069D4-04	14	RIVET	
655	EN6081D5-05	39	RIVET	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
656	EN6081D5-06	127	RIVET	
657	EN6081D5-07	40	RIVET	
764	DAN5-6-4X	4	PIN	
765	DAN5-6-5X	4	PIN	
766	DAN5-6-6X	6	PIN	
806	NSA5075-6	10	COLLAR	
807	DAN11-6X	24	COLLAR	
864	DAN6-6-4	3	PIN	
865	DAN6-6-5	7	PIN	
875	DAN6-6-5X	4	PIN	
876	DAN6-6-6X	3	PIN	
877	DAN6-6-7X	3	PIN	

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	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-75-12 53-41-14
Fig. A-GBQAA Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Install the shear plates.

Refer to Fig. A-GBQAA Sheet 01 thru Fig. A-GBQAA Sheet 06.

1 Between Frame 49 and Frame 50, on STGR 38 LH and bracket, Item 66, put in position:

Refer to Fig. A-GBQAA Sheet 02, View D.

1	Plate-Shear	D5347456300000	Item (139)	Retained at removal

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2 Transfer drill and ream the three holes from the shear plate, Item (139), to the bracket, Item 66, refer to Fig. A-GBQAA Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAA Sheet 06.

3 Between Frame 49 and Frame 50, on STGR 38 LH, remove:

1	Plate-Shear	D5347456300000	Item (139)	Retain

4 Clean and deburr the new fastener holes in the bracket, Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

5 Between Frame 49 and Frame 50, on STGR 38 LH and bracket, Item 66, wet install:

Refer to Fig. A-GBQAA Sheet 02, View D.

1	Plate-Shear	D5347456300000	Item (139)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

6	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D5-07	Item 657

6 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item (140), put in position:

Refer to Fig. A-GBQAA Sheet 02, View D.

1	Plate-Shear	D5347471500200	Item (117)	Retained at removal

7 Transfer drill and ream the three holes from the shear plate, Item (117), to the bracket, Item 65, refer to Fig. A-GBQAA Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAA Sheet 06.

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8 Between Frame 50 and Frame 51, on STGR 38 LH, remove:

1	Plate-Shear	D5347471500200	Item (117)	Retain

9 Clean and deburr the new fastener holes in the bracket, Item 65, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

10 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item (140), wet install:

Refer to Fig. A-GBQAA Sheet 02, View D.

1	Plate-Shear	D5347471500200	Item (117)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-04	Item 544	
6	Rivet	EN6081D5-06	Item 656	
20	Rivet	EN6081D5-07	Item 657	

11 Between Frame 52 and Frame 53, on STGR 38 LH and on the brackets, Item (116) and Item (120), wet install:

Refer to Fig. A-GBQAA Sheet 03, View F.

1	Plate Assy-Shear	D5347049100000	Item (119)	Retained at removal
1	Section-Connecting	D5347065020200	Item (135)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

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2	Rivet	EN6069D4-04	Item 544	
6	Rivet	EN6081D5-05	Item 655	
18	Rivet	EN6081D5-06	Item 656	
6	Pin	DAN5-6-6X	Item 766	
16	Collar	DAN11-6X	Item 807	
4	Pin	DAN6-6-5X	Item 875	
3	Pin	DAN6-6-6X	Item 876	
3	Pin	DAN6-6-7X	Item 877	

12 Between Frame 54 and Frame 55, on STGR 38 LH and on the brackets, Item (121) and Item (120), wet install:

Refer to Fig. A-GBQAA Sheet 04, View H.

1	Plate Assy-Shear	D5347048800000	Item (122)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-04	Item 544	
6	Rivet	EN6081D5-05	Item 655	
20	Rivet	EN6081D5-06	Item 656	

13 Between Frame 56 and Frame 57, on STGR 38 LH and on the brackets, Item (121) and Item (118), wet install:

Refer to Fig. A-GBQAA Sheet 04, View K.

1	Plate Assy-Shear	D5347048900000	Item (124)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

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2	Rivet	EN6069D4-04	Item 544	
6	Rivet	EN6081D5-05	Item 655	
20	Rivet	EN6081D5-06	Item 656	

14 Between Frame 58 and Frame 59, on STGR 38 LH and on the brackets, Item (125) and Item (127), wet install:

Refer to Fig. A-GBQAA Sheet 05, View M.

1	Plate-Shear	D5347049200000	Item (126)	Retained at removal

or

1	Plate-Shear	D5347049200200	Item (126)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-04	Item 544	
6	Rivet	EN6081D5-05	Item 655	
20	Rivet	EN6081D5-06	Item 656	

15 Between Frame 60 and Frame 61, on STGR 38 LH and on the brackets, Item (128) and Item (130), wet install:

Refer to Fig. A-GBQAA Sheet 05, View P.

1	Plate-Shear	D5347049300000	Item (129)	Retained at removal
1	Section-Connecting	D5347065420400	Item (136)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-04	Item 544	

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8	Rivet	EN6081D5-05	Item 655	
17	Rivet	EN6081D5-06	Item 656	
4	Pin	DAN5-6-4X	Item 764	
4	Pin	DAN5-6-5X	Item 765	
10	Collar	NSA5075-6	Item 806	
8	Collar	DAN11-6X	Item 807	
3	Pin	DAN6-6-4	Item 864	
7	Pin	DAN6-6-5	Item 865	

16 Between Frame 62 and Frame 63, on STGR 38 LH and on the brackets, Item (131) and Item (115), wet install:

Refer to Fig. A-GBQAA Sheet 06, View R.

1	Plate-Shear	D5347049400000	Item (123)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-04	Item 544	
7	Rivet	EN6081D5-05	Item 655	
20	Rivet	EN6081D5-06	Item 656	

(b) Install the corner profiles.

In accordance with SRM 53-41-14.

1 Between Frame 48 thru Frame 63, at STGR 38 LH, install the corner profiles, if removed in accordance with SRM 53-41-14 C2 Identification - Floor Structure - Cargo Compartment.

(c) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(18) Subtask 531364-831-218-002 - Install new Surface Protection on Frame 50 thru Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 from Stringer 31 to Stringer 39
To	160	Work location	from Frame 60 to Frame 63 from Stringer 31 to Stringer 39

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	NON SPECIFIC

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	04JME4	As required	
	Coating - Flexible Structure	04QAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound	12ADB1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12

(a) Clean the working area with:

Non Aqueous Cleaner - General	08BAA9	As required

and

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Textile - Lint Free Cotton	14SBA1	As required

(b) Apply sealant beads around the edges of all new and reinstalled structure parts with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(c) Apply to all sealant beads:

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(d) Apply to all sealant beads:

Top Coat Polyurethane	04JME4	As required

and

Coating - Flexible Structure	04QAB2	As required

(e) Install new water repellent protection on Frame 50 thru Frame 63.

1 Protect the Frame 50 thru Frame 63, STGR 31 LH thru STGR 39 LH and the re-installed shear plates with:

In accordance with SRM 51-23-12.

Corrosion Preventive Compound	12ADB1	As required

****CONF 002**

(1) Subtask 531364-831-201-006 - Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 Stringer 38 LH
To	160	Work location	from Frame 60 to Frame 63 Stringer 38 LH

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

Material necessary to do the job

Consumable CMLD01				
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)	53-41-14
Fig. A-GBQAB Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

CAUTION: AIRBUS CONSIDERS IT IS TECHNICALLY ACCEPTABLE TO REWORK EVERY THIRD FRAME AT THE SAME TIME (I.E. LEAVE TWO FRAMES INTACT AND REWORK ONE) TO KEEP THE FUSELAGE STRUCTURE INTEGRITY.

(a) Remove the corner profiles.

In accordance with SRM 53-41-14 C2 Ident.-Floor Structure-Cargo Compartment.

1 Between Frame 48 thru Frame 63, at STGR 38 LH, remove the corner profiles, if necessary in accordance with SRM 53-41-14 C2 Identification - Floor Structure - Cargo Compartment.

(b) Remove the shear plates.

Refer to Fig. A-GBQAB Sheet 01 thru Fig. A-GBQAB Sheet 06.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 Between Frame 49 and Frame 51, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAB Sheet 02, View C.

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1	Plate-Shear	D5347471500200	Item (117)	Retain
1	Plate-Shear	D5347471500000	Item (139)	Retain
	with			
56	Rivet		Item (100)	Discard

2 Between Frame 51 and Frame 53, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAB Sheet 02, View C and Fig. A-GBQAB Sheet 03, View E.

1	Plate-Shear	D5347471500800	Item (119)	Retain
1	Plate-Shear	D5347471500600	Item (137)	Retain
1	Section-Connecting	D5347065020200	Item (135)	Retain
	with			
67	Rivet		Item (100)	Discard

3 Between Frame 53 and Frame 54, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAB Sheet 03, View E.

1	Plate-Shear	D5347471501000	Item (141)	Retain
	with			
28	Rivet		Item (100)	Discard

4 Between Frame 54 and Frame 55, from STGR 38 LH and from the brackets, Item (121) and Item (120), remove:

Refer to Fig. A-GBQAB Sheet 04, View G.

1	Plate Assy-Shear	D5347048800400	Item (122)	Retain
	with			
40	Rivet		Item (100)	Discard

5 Between Frame 56 and Frame 57, from STGR 38 LH and from the brackets, Item (121) and Item (118), remove:

Refer to Fig. A-GBQAB Sheet 04, View J.

1	Plate Assy-Shear	D5347048900000	Item (124)	Retain

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with

40	Rivet		Item (100)	Discard

6 Between Frame 58 and Frame 59, from STGR 38 LH and from the brackets, Item (125) and Item (127), remove:

Refer to Fig. A-GBQAB Sheet 05, View L.

1	Plate-Shear	D5347049200200	Item (126)	Retain

with

40	Rivet		Item (100)	Discard

7 Between Frame 60 and Frame 61, from STGR 38 LH and from the brackets, Item (128) and Item (130), remove:

Refer to Fig. A-GBQAB Sheet 05, View N.

1	Plate-Shear	D5347049300000	Item (129)	Retain
1	Section-Connecting	D5347065420400	Item (136)	Retain

with

45	Rivet		Item (100)	Discard

8 Between Frame 62 and Frame 63, from STGR 38 LH and from the brackets, Item (131) and Item (115), remove:

Refer to Fig. A-GBQAB Sheet 06, View Q.

1	Plate-Shear	D5347049400000	Item (123)	Retain

with

29	Rivet		Item (100)	Discard

(c) Clean the contact surfaces and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

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(2) Subtask 531364-831-202-003 - Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 from Stringer 33 LH to Stringer 34 LH from Stringer 36 LH to Stringer 37 LH
To	160	Work location	from Frame 60 to Frame 62 from Stringer 32 LH to Stringer 33 LH from Stringer 36 LH to Stringer 37 LH Frame 63 from Stringer 31 LH to Stringer 32 LH from Stringer 36 LH to Stringer 37 LH

Manpower Resources	
Manhours	5.00
Minimum number of person	1
Subtask elapsed time	5.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

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 Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane	04JME4	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

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NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00
Fig. A-GBRAA Cold Expansion of Holes in Frame 50 thru Frame 63	Sheet 01 Sheet 02 Sheet 03

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

(a) Inspect the holes for cracks from Frame 50 thru Frame 55 and from Frame 57 thru Frame 59.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 33 LH and STGR 34 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(b) Cold expand the holes from Frame 50 thru Frame 55 and from Frame 57 thru Frame 59.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

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1 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 33 LH and STGR 34 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 02, View C.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

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(c) Inspect the holes for cracks at Frame 56.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 At Frame 56, between STGR 33 LH and STGR 34 LH and between STGR 35 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(d) Cold expand the holes at Frame 56.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 At Frame 56, between STGR 33 LH and STGR 34 LH and between STGR 35 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 02, View D.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

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2 Clean the area of the expanded holes with:

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

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(e) Inspect the holes for cracks from Frame 60 thru Frame 62.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

1 From Frame 60 thru Frame 62, between STGR 32 LH and STGR 33 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(f) Cold expand the holes from Frame 60 thru Frame 62.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

1 From Frame 60 thru Frame 62, between STGR 32 LH and STGR 33 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 03, View E.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(g) Inspect the holes for cracks at Frame 63.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

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1 At Frame 63, between STGR 31 LH and STGR 32 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frame, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(h) Cold expand the holes at Frame 63.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

1 At Frame 63, between STGR 31 LH and STGR 32 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frame. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 03, View F.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

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and

Textile - Lint Free Cotton	14SBA1	As required

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(3) Subtask 531364-831-203-006 - Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 50 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D02R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
4	E5347001024400	1	WEB	
65	E5347001420200	1	ANGLE	
66	E5347001420000	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	2	RIVET	
567	EN6069D6-07	11	RIVET	
656	EN6081D5-06	8	RIVET	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
668	EN6081D6-08	11	RIVET	(1)
764	DAN5-6-4X	15	PIN	
765	DAN5-6-5X	13	PIN	
766	DAN5-6-6X	6	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	2	PIN	
785	DAN5-6-5Y	3	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	6	COLLAR	
807	DAN11-6X	37	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	6	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

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NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBAAB Replacement of Webs and Angles at Frame 50	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBAAB Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 50, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
17	Rivet		Item (100)	Discard

2 From the flange of Frame 50, between STGR 35 LH and STGR 36 LH, remove:

6	Rivet		Item (100)	Discard

3 From Frame 50, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347073420000	Item (1)	Discard
	with			

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18	Rivet		Item (100)	Discard

4 From Frame 50, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072820000	Item (2)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347470120200	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard
1	Angle-Support	D5347068120000	Item (102)	Retain
	with			
66	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 50.

Refer to NTM 51-10-01.

Refer to Fig. A-GBAAB Sheet 02, View C.

1 On Frame 50, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374 refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 50, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

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(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBAAB Sheet 02 thru Fig. A-GBAAB Sheet 04.

1 On Frame 50, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBAAB Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 50 to the shear web, Item 4.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAB Sheet 04.

4 Transfer drill the tack hole from the Frame 50 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

5 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBAAB Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBAAB Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAB Sheet 04.

6 On Frame 50, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

7 Clean and deburr the new fastener holes in Frame 50 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBAAB Sheet 02, View C.

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a On Frame 50, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBAAB Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

b On Frame 50, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAB Sheet 02, View C.

c On Frame 50, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAB Sheet 02, View C.

d On Frame 50, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAB Sheet 02, View C.

9 On Frame 50, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

10 Clean and deburr the cold expansion fastener holes in Frame 50 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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11 At Frame 50, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBAAB Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4
	with		
3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
11	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
11	Rivet	EN6081D6-08	Item 668
15	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-5X	Item 765
3	Pin	DAN5-6-5Y	Item 785
24	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809
5	Nut	ASNA2528-3A	Item 908
	use		
Polysulfide Sealant - General Purpose Brushable		06AAA1	As required

12 On the flange of Frame 50, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBAAB Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

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13 On the Frame 50 flange, at STGR 35 LH, refer to Fig. A-GBAAB Sheet 03, Section C-C, countersink the one fastener hole.

14 On the Frame 50 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBAAB Sheet 03, Section C-C

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 50 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBAAB Sheet 02, View C and Fig. A-GBAAB Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBAAB Sheet 02, View C and Fig. A-GBAAB Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAB Sheet 04.

17 On the Frame 50 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 50, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 50 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBAAB Sheet 02, View C and Fig. A-GBAAB Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

20 On the Frame 50 flange, at STGR 36 LH, refer to Fig. A-GBAAB Sheet 03, Section D-D, counter sink the one fastener hole.

21 On the Frame 50 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBAAB Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 50 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBAAB Sheet 02, View C and Fig. A-GBAAB Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBAAB Sheet 02, View C and Fig. A-GBAAB Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAB Sheet 04.

24 On the Frame 50 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

25 Clean and deburr the new fastener holes in the Frame 50, STGR 36 LH and angle, Item 2, use:

	Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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	Non Aqueous Cleaner - General	08BAA9	As required	

26 On the Frame 50 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBAAB Sheet 02, View C and Fig. A-GBAAB Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

27 On the Frame 50 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBAAB Sheet 02, View C and Fig. A-GBAAB Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Pin	DAN5-6-6X	Item 766	
2	Pin	DAN5-6-7X	Item 767	
6	Collar	NSA5075-6	Item 806	
6	Collar	DAN11-6X	Item 807	
6	Pin	DAN5-6-3	Item 963	

28 On the Frame 50 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBAAB Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65

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1	Angle	E5347001420000	Item 66

29 Transfer drill and ream the three holes from the Frame to the angles, Item 65 and Item 66, refer to Fig. A-GBAAB Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAB Sheet 04.

30 On the Frame 50 flange, at STGR 38 LH, remove:

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

31 Clean and deburr the new fastener holes in the Frame 50 and angles, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

32 On the Frame 50 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBAAB Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-8X	Item 768
1	Pin	DAN5-6-6Y	Item 786
2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

33 On the Frame 50 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBAAB Sheet 02, View C and Fig. A-GBAAB Sheet 03, Section F-F.

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1	Angle-Support	D5347068120000	Item (102)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
2	Pin	DAN5-6-6X	Item 766	
2	Collar	DAN11-6X	Item 807	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(4) Subtask 531364-831-204-006 - Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 51 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D02R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
4	E5347001024400	1	WEB	
65	E5347001420200	1	ANGLE	
66	E5347001420000	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	2	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	4	RIVET	(2)
764	DAN5-6-4X	14	PIN	
765	DAN5-6-5X	13	PIN	
766	DAN5-6-6X	6	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	2	PIN	
785	DAN5-6-5Y	3	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	37	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBBAB Replacement of Webs and Angles at Frame 51	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBBAB Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 51, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
17	Rivet		Item (100)	Discard

2 From the flange of Frame 51, between STGR 35 LH and STGR 36 LH, remove:

6	Rivet		Item (100)	Discard

3 From Frame 51, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347073420000	Item (1)	Discard
	with			
18	Rivet		Item (100)	Discard

4 From Frame 51, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072820000	Item (2)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle-Support	D5347068120000	Item (102)	Retain
1	Angle	D5347470120200	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard
	with			
66	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

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Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 51.

Refer to NTM 51-10-01.

Refer to Fig. A-GBBAB Sheet 02, View C.

1 On Frame 51, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 51, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBBAB Sheet 02 thru Fig. A-GBBAB Sheet 04.

1 On Frame 51, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBBAB Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 51 to the shear web, Item 4.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAB Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBBAB Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBBAB Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAB

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Sheet 04.

5 Transfer drill the tack hole from the Frame 51 between STGR 36 LH and 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 51, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

7 Clean and deburr the new fastener holes in Frame 51 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBBAB Sheet 02, Views C and D.

a On Frame 51, between STGR 34 LH and STGR 39 LH, put in position:

1	Shear Web	E5347001024400	Item 4

b On Frame 51, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAB Sheet 02, View C.

c On Frame 51, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAB Sheet 02, View C.

d On Frame 51, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAB Sheet 02, View C.

9 On Frame 51, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

10 Clean and deburr the cold expansion fastener holes in Frame 51 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 51, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBBAB Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

with

3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
19	Rivet	EN6081D6-08	Item 668
4	Rivet	EN6081D6-09	Item 669
14	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-5X	Item 765
3	Pin	DAN5-6-5Y	Item 785
24	Collar	DAN11-6X	Item 807

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3	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809
5	Nut	ASNA2528-3A	Item 908

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 51, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBBAB Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

13 On the Frame 51 flange, at STGR 35 LH, refer to Fig. A-GBBAB Sheet 03, Section C-C, countersink the one fastener hole.

14 On the Frame 51 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBBAB Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 51 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBBAB Sheet 02, View C and Fig. A-GBBAB Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBBAB Sheet 02, View C and Fig. A-GBBAB Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAB Sheet 04.

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17 On the Frame 51 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 51, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 51 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBBAB Sheet 02, View C and Fig. A-GBBAB Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

20 On the Frame 51 flange, at STGR 36 LH, refer to Fig. A-GBBAB Sheet 03, Section D-D, countersink the one fastener hole.

21 On the Frame 51 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBBAB Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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22 On the Frame 51 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBBAB Sheet 02, View C and Fig. A-GBBAB Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBBAB Sheet 02, View C and Fig. A-GBBAB Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAB Sheet 04.

24 On the Frame 51 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

25 Clean and deburr the new fastener holes in the Frame 51, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 51 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBBAB Sheet 02, View C and Fig. A-GBBAB Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Rivet	EN6081D6-07	Item 667

27 On the Frame 51 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBBAB Sheet 02, View C and Fig. A-GBBAB Sheet 03, Section E-E.

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1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Pin	DAN5-6-6X	Item 766	
2	Pin	DAN5-6-7X	Item 767	
4	Collar	NSA5075-6	Item 806	
6	Collar	DAN11-6X	Item 807	
4	Pin	DAN5-6-3	Item 963	

28 On the Frame 51 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBBAB Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

29 Transfer drill and ream the three holes from the Frame to the angles, Item 65 and Item 66, refer to Fig. A-GBBAB Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAB Sheet 04.

30 On the Frame 51 flange, at STGR 38 LH, remove:

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

31 Clean and deburr the new fastener holes in the Frame 51 and angles, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required
made moist with:		
Non Aqueous Cleaner - General	08BAA9	As required

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32 On the Frame 51 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBBAB Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65	
1	Angle	E5347001420000	Item 66	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-8X	Item 768	
1	Pin	DAN5-6-6Y	Item 786	
2	Collar	DAN11-6X	Item 807	
1	Collar	DAN11-6Y	Item 809	

33 On the Frame 51 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBBAB Sheet 02, View C and Fig. A-GBBAB Sheet 03, Section F-F.

1	Angle-Support	D5347068120000	Item (102)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
2	Pin	DAN5-6-6X	Item 766	
2	Collar	DAN11-6X	Item 807	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(5) Subtask 531364-831-205-006 - Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 52 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D02R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
6	E5347001023600	1	WEB	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	2	RIVET	
567	EN6069D6-07	11	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	4	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	2	RIVET	
668	EN6081D6-08	30	RIVET	(1)

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	8	PIN	
765	DAN5-6-5X	1	PIN	
766	DAN5-6-6X	8	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	13	COLLAR	
807	DAN11-6X	17	COLLAR	
808	ASNA2528-3	10	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	1	PIN	
865	DAN6-6-5	4	PIN	
866	DAN6-6-6	6	PIN	
963	DAN5-6-3	1	PIN	
964	DAN5-6-4	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

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NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBCAB Replacement of Webs and Angles at Frame 52	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBCAB Sheet 01, View B and Sections A-A and B-B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 52, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920200	Item (3)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 52, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

8	Rivet		Item (100)	Discard

3 From Frame 52, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020000	Item (4)	Discard
	with			

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14	Rivet		Item (100)	Discard

4 From Frame 52, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347077420000	Item (5)	Discard
1	Support	D5347032200400	Item (103)	Retain
1	Angle	D5347470120200	Item (116)	Retain
1	Angle	D5347470120000	Item (140)	Retain
1	Section-Connecting	D5347065020000	Item (135)	Retain
1	Shim	D5347044920000	Item (142)	Retain
1	Shim	D5347044920600	Item (143)	Retain

with

65	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 52.

Refer to NTM 51-10-01.

Refer to Fig. A-GBCAB Sheet 02, Views C, D and F.

1 On Frame 52, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 52, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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3 On the top flange of Frame 52, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 52, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBCAB Sheet 02 thru Fig. A-GBCAB Sheet 04.

1 On Frame 52, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBCAB Sheet 02, View C.

1	Shear Web	E5347001023600	Item 6

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 52 to the shear web, Item 6.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAB Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBCAB Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBCAB Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAB Sheet 04.

5 Transfer drill the tack hole from the Frame 52 between STGR 36 LH and 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 52, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001023600	Item 6

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7 Clean and deburr the new fastener holes in Frame 52 and the shear web, Item 6, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBCAB Sheet 02, Views C, D and F.

a On Frame 52, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBCAB Sheet 02, Views C.

1	Shear Web	E5347001023600	Item 6

b On Frame 52, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAB Sheet 02, View C.

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c On Frame 52, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAB Sheet 02, View C.

d On the top flange of Frame 52, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAB Sheet 02, View D.

e On the top flange of Frame 52, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAB Sheet 02, View F.

9 On Frame 52, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001023600	Item 6

10 Clean and deburr the cold expansion fastener holes in Frame 52 and the shear web, Item 6, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 52, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBCAB Sheet 02, View C.

1	Shear Web	E5347001023600	Item 6

with

3	Bolt	EN6115K3-3	Item 363

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5	Bolt	EN6115K3-4	Item 364
11	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
30	Rivet	EN6081D6-08	Item 668
7	Pin	DAN5-6-4X	Item 764
1	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
1	Pin	DAN5-6-3	Item 963

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 52, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBCAB Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 52, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBCAB Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

14 On the Frame 52 flange, at STGR 35 LH, refer to Fig. A-GBCAB Sheet 03, Section D-D, countersink the one fastener hole.

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15 On the Frame 52 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBCAB Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 52 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBCAB Sheet 02, View C and Fig. A-GBCAB Sheet 03, Section D-D.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame 52 to the angle, Item 1, refer to Fig. A-GBCAB Sheet 02, View C and Fig. A-GBCAB Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAB Sheet 04.

18 On the Frame 52 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 52, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 52 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBCAB Sheet 02, View C and Fig. A-GBCAB Sheet 03, Section D-D.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

21 On the Frame 52 flange, at STGR 36 LH, refer to Fig. A-GBCAB Sheet 03, Section E-E, countersink the one fastener hole.

22 On the Frame 52 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBCAB Sheet 03, Section E-E.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 52 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBCAB Sheet 02, View C and Fig. A-GBCAB Sheet 03, Section E-E.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBCAB Sheet 03, Section E-E.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAB Sheet 04.

25 On the Frame 52 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 52, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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	Non Aqueous Cleaner - General	08BAA9	As required	

27 On the Frame 52 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBCAB Sheet 02, View C and Fig. A-GBCAB Sheet 03, Section E-E.

1	Angle	E5347001120200	Item 2	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-4	Item 964	
1	Collar	NSA5075-6	Item 806	

28 On the Frame 52 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBCAB Sheet 02, View C and Fig. A-GBCAB Sheet 03, Section F-F.

1	Support	D5347032200400	Item (103)	Retained at removal
1	Section-Connecting	D5347065020200	Item (135)	Retained at removal
1	Shim	D5347044920000	Item (142)	Retained at removal
1	Shim	D5347044920600	Item (143)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
1	Pin	DAN5-6-4X	Item 764	

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6	Pin	DAN5-6-6X	Item 766	
7	Collar	DAN11-6X	Item 807	
10	Collar	NSA5075-6	Item 806	
4	Pin	DAN6-6-5	Item 865	
6	Pin	DAN6-6-6	Item 866	

29 On the aft side of the Frame 52 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBCAB Sheet 02, View C and Section C-C.

1	Angle	D5347470120200	Item (116)	Retained at removal
1	Angle	D5347470120000	Item (140)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-6X	Item 766	
1	Pin	DAN5-6-6Y	Item 786	
2	Collar	DAN11-6X	Item 807	
1	Collar	DAN11-6Y	Item 809	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

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Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(6) Subtask 531364-831-206-006 - Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 53 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D02R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
8	E5347001027400	1	WEB	
68	E5347001420400	1	ANGLE	
80	E5347001420600	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
556	EN6069D5-06	2	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	4	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	2	RIVET	
668	EN6081D6-08	15	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
763	DAN5-6-3X	2	PIN	
764	DAN5-6-4X	4	PIN	
765	DAN5-6-5X	1	PIN	
766	DAN5-6-6X	4	PIN	
784	DAN5-6-4Y	2	PIN	
806	NSA5075-6	18	COLLAR	
807	DAN11-6X	11	COLLAR	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
808	ASNA2528-3	9	NUT	
809	DAN11-6Y	2	COLLAR	
863	DAN6-6-3	10	PIN	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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.

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NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	

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References	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBDAB Replacement of Webs and Angles at Frame 53	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBDAB Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 53, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the flange of Frame 53, between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 53, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020000	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 53, between STGR 36 LH and STGR 39 LH, remove:

1	Shear web	D5347078320000	Item (6)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle-Support	D5347068120000	Item (102)	Retain
1	Angle	D5347470120200	Item (116)	Discard

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1	Angle	D5347470120000	Item (140)	Discard
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 53.

Refer to NTM 51-10-01.

Refer to Fig. A-GBDAB Sheet 02, View C.

1 On Frame 53, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 53, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBDAB Sheet 02 thru Fig. A-GBDAB Sheet 04.

1 On Frame 53, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBDAB Sheet 02, View C.

8	Shear Web	E5347001027400	Item 8

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

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3 Transfer drill the fastener holes from the Frame 53 to the shear web, Item 8.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAB Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBDAB Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBDAB Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAB Sheet 04.

5 Transfer drill the tack hole from the Frame 53 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 53, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001027400	Item 8

7 Clean and deburr the new fastener holes in Frame 53 and the shear web, Item 8, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBDAB Sheet 02, View C.

a On Frame 53, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBDAB Sheet 02, View C.

1	Shear Web	E5347001027400	Item 8

b On Frame 53, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAB Sheet 02, View C.

c On Frame 53, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAB Sheet 02, View C.

9 On Frame 53, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001027400	Item 8

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10 Clean and deburr the cold expansion fastener holes in Frame 53 and the shear web, Item 8, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 53, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBDAB Sheet 02, View C.

1	Shear Web	E5347001027400	Item 8

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
2	Pin	DAN5-6-3X	Item 763
4	Pin	DAN5-6-4X	Item 764
13	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863
1	Pin	DAN5-6-3	Item 963
2	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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12 Install 1 fastener in the flange of Frame 53, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBDAB Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the Frame 53 flange, at STGR 35 LH, refer to Fig. A-GBDAB Sheet 03, Section C-C, countersink the one fastener hole.

14 On the Frame 53 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBDAB Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 53 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBDAB Sheet 02, View C and Fig. A-GBDAB Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBDAB Sheet 02, View C and Fig. A-GBDAB Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAB Sheet 04.

17 On the Frame 53 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 53, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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19 On the Frame 53 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBDAB Sheet 02, View C and Fig. A-GBDAB Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

20 On the Frame 53 flange, at STGR 36 LH, refer to Fig. A-GBDAB Sheet 03, Section D-D, countersink the one fastener hole.

21 On the Frame 53 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBDAB Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 53 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBDAB Sheet 02, View C and Fig. A-GBDAB Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBDAB Sheet 02, View C and Fig. A-GBDAB Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAB Sheet 04.

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24 On the Frame 53 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2	

25 Clean and deburr the new fastener holes in the Frame 53, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required	

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required	

26 On the Frame 53 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBDAB Sheet 02, View C and Fig. A-GBDAB Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-4	Item 964	
1	Collar	NSA5075-6	Item 806	

27 On the Frame 53 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBDAB Sheet 02, View C and Fig. A-GBDAB Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

6	Rivet	EN6081D6-09	Item 669	

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4	Collar	NSA5075-6	Item 806
4	Pin	DAN5-6-3	Item 963

28 On the Frame 53 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBDAB Sheet 02, View C and Section B-B.

1	Angle	E5347001420400	Item 68
1	Angle	E5347001420600	Item 80

29 Transfer drill and ream the three holes from the Frame to the angles, Item 68 and Item 80, refer to Fig. A-GBDAB Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAB Sheet 04.

30 On the Frame 53 flange, at STGR 38 LH, remove:

1	Angle	E5347001420400	Item 68
1	Angle	E5347001420600	Item 80

31 Clean and deburr the new fastener holes in the Frame 53 and angles, Item 68 and Item 80, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

32 On the Frame 53 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBDAB Sheet 02, View C and Section B-B.

1	Angle	E5347001420400	Item 68
1	Angle	E5347001420600	Item 80

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-6X	Item 766

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1	Pin	DAN5-6-4Y	Item 784	
1	Collar	DAN11-6Y	Item 809	
2	Collar	DAN11-6X	Item 807	

33 On the Frame 53 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBDAB Sheet 02, View C and Fig. A-GBDAB Sheet 03, Section F-F.

1	Angle-Support	D5347068120000	Item (102)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-6X	Item 766	
1	Pin	DAN5-6-4Y	Item 784	
2	Collar	DAN11-6X	Item 807	
1	Collar	DAN11-6Y	Item 809	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

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(7) Subtask 531364-831-207-006 - Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 54 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D02R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
10	E5347001023400	1	WEB	
82	E5347001420800	1	ANGLE	
84	E5347001421000	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
556	EN6069D5-06	2	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	6	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	1	PIN	
766	DAN5-6-6X	2	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	14	COLLAR	
807	DAN11-6X	10	COLLAR	
808	ASNA2528-3	9	NUT	
863	DAN6-6-3	10	PIN	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBEAB Replacement of Webs and Angles at Frame 54	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBEAB Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 54, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the flange of Frame 54, between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 54, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020000	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 54, between STGR 36 LH and STGR 39 LH, remove:

1	Web-shear	D5347078520000	Item (7)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046824000	Item (121)	Discard
1	Angle	D5347470120000	Item (140)	Discard
1	Angle-Support	D5347068120000	Item (102)	Retain
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

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Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 54.

Refer to NTM 51-10-01.

Refer to Fig. A-GBEAB Sheet 02, Views C and E.

1 On Frame 54, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 54, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 54, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBEAB Sheet 02 thru Fig. A-GBEAB Sheet 04.

1 On Frame 54, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBEAB Sheet 02, View C.

1	Shear Web	E5347001023400	Item 10

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 54 to the shear web, Item 10.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAB Sheet 04.

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4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBEAB Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBEAB Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAB Sheet 04.

5 Transfer drill the tack hole from the Frame 54 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 54, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001023400	Item 10

7 Clean and deburr the new fastener holes in Frame 54 and the Shear Web, Item 10, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBEAB Sheet 02, Views C and E.

a On Frame 54, between STGR 34 LH and STGR 39 LH, put in position:

1	Shear Web	E5347001023400	Item 10

b On Frame 54, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAB Sheet 02, View C.

c On Frame 54, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAB Sheet 02, View C.

d On the top flange of Frame 54, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAB Sheet 02, View E.

9 On Frame 54, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001023400	Item 10

10 Clean and deburr the cold expansion fastener holes in Frame 54 and the Shear Web, Item 10, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 54, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBEAB Sheet 02, View C.

1	Shear Web	E5347001023400	Item 10

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
6	Rivet	EN6081D6-06	Item 666
17	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
10	Collar	NSA5075-6	Item 806

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6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 54, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBEAB Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the Frame 54 flange, at STGR 35 LH, refer to Fig. A-GBEAB Sheet 03, Section C-C, countersink the one fastener hole.

14 On the Frame 54 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBEAB Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 54 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBEAB Sheet 02, View C and Fig. A-GBEAB Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three hole from the Frame to the angle, Item 1, refer to Fig. A-GBEAB Sheet 02, View C and Fig. A-GBEAB Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAB Sheet 04.

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17 On the Frame 54 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 54, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 54 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBEAB Sheet 02, View C and Fig. A-GBEAB Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

20 On the Frame 54 flange, at STGR 36 LH, refer to Fig. A-GBEAB Sheet 03, Section D-D, countersink the one fastener hole.

21 On the Frame 54 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBEAB Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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22 On the Frame 54 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBEAB Sheet 02, View C and Fig. A-GBEAB Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBEAB Sheet 02, View C and Fig. A-GBEAB Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAB Sheet 04.

24 On the Frame 54 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

25 Clean and deburr the new fastener holes in the Frame 54, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 54 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBEAB Sheet 02, View C and Fig. A-GBEAB Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Rivet	EN6081D6-07	Item 667

27 On the Frame 54 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBEAB Sheet 02, View C and Fig. A-GBEAB Sheet 03, Section E-E.

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1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

28 On the Frame 54 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBEAB Sheet 02, View C and Section B-B.

1	Angle	E5347001420800	Item 82
1	Angle	E5347001421000	Item 84

29 Transfer drill and ream the three holes from the Frame to the angles, Item 82 and Item 84, refer to Fig. A-GBEAB Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAB Sheet 04.

30 On the Frame 54 flange, at STGR 38 LH, remove:

1	Angle	E5347001420800	Item 82
1	Angle	E5347001421000	Item 84

31 Clean and deburr the new fastener holes in the Frame 54 and angles, Item 82 and Item 84, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

32 On the Frame 54 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBEAB Sheet 02, View C and Section B-B.

1	Angle	E5347001420800	Item 82

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1	Angle	E5347001421000	Item 84	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-6X	Item 766	
1	Pin	DAN5-6-6Y	Item 786	
3	Collar	DAN11-6X	Item 807	

33 On the Frame 54 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBEAB Sheet 02, View C and Fig. A-GBEAB Sheet 03, Section F-F.

1	Angle-Support	D5347068120000	Item (102)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-08	Item 668	
2	Rivet	EN6081D5-07	Item 657	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

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Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(8) Subtask 531364-831-208-006 - Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 55 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D02R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
12	E5347001020800	1	WEB	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	2	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	6	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	16	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	10	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	12	PIN	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01

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References	
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBFAB Replacement of Webs and Angles at Frame 55	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBFAB Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 55, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 55, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

10	Rivet		Item (100)	Discard

3 From Frame 55, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020000	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 55, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072120000	Item (8)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046823800	Item (120)	Retain
1	Angle-Support	D5347068120000	Item (102)	Retain
	with			

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56	Rivet	Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 55.

Refer to NTM 51-10-01.

Refer to Fig. A-GBFAB Sheet 02, Views C, D and F.

1 On Frame 55, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 55, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 55, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBFAB Sheet 02 thru Fig. A-GBFAB Sheet 04.

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1 On Frame 55, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBFAB Sheet 02, View C.

1	Shear Web	E5347001020800	Item 12

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 55 to the shear web, Item 12.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAB Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBFAB Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBFAB Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAB Sheet 04.

5 Transfer drill the tack hole from the Frame 55 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 55, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001020800	Item 12

7 Clean and deburr the new fastener holes in Frame 55 and the shear web, Item 12, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBFAB Sheet 02, Views C, D and F.

a On Frame 55, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBFAB Sheet 02, View C.

1	Shear Web	E5347001020800	Item 12

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b On Frame 55, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAB Sheet 02, View C.

c On Frame 55, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAB Sheet 02, View C.

d On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAB Sheet 02, View D.

e On the top flange of Frame 55, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAB Sheet 02, View F.

9 On Frame 55, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001020800	Item 12

10 Clean and deburr the cold expansion fastener holes in Frame 55 and the shear web, Item 12, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 55, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBFAB Sheet 02, View C.

1	Shear Web	E5347001020800	Item 12

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
6	Rivet	EN6081D6-06	Item 666
17	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
10	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863

use

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 55, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBFAB Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBFAB Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

14 On the Frame 55 flange, at STGR 35 LH, refer to Fig. A-GBFAB Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 55 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBFAB Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 55 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBFAB Sheet 02, View C and Fig. A-GBFAB Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

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17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBFAB Sheet 02, View C and Fig. A-GBFAB Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAB Sheet 04.

18 On the Frame 55 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 55, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 55 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBFAB Sheet 02, View C and Fig. A-GBFAB Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

21 On the Frame 55 flange, at STGR 36 LH, refer to Fig. A-GBFAB Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 55 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBFAB Sheet 03, Section B-B.

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1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 55 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBFAB Sheet 02, View C and Fig. A-GBFAB Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBFAB Sheet 02, View C and Fig. A-GBFAB Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAB Sheet 04.

25 On the Frame 55 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 55, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 55 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBFAB Sheet 02, View C and Fig. A-GBFAB Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657

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3	Rivet	EN6081D6-07	Item 667	

28 On the Frame 55 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBFAB Sheet 02, View C and Fig. A-GBFAB Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

6	Rivet	EN6081D6-09	Item 669
4	Collar	NSA5075-6	Item 806
4	Pin	DAN5-6-3	Item 963

29 On the Frame 55 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBFAB Sheet 02, View C.

1	Angle	D5347046823800	Item (120)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-5X	Item 765
1	Pin	DAN5-6-5Y	Item 785
1	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

30 On the Frame 55 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBFAB Sheet 02, View C and Fig. A-GBFAB Sheet 03, Section D-D.

1	Angle-Support	D5347068120000	Item (102)	Retained at removal

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-08	Item 668
2	Rivet	EN6081D5-07	Item 657

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(9) Subtask 531364-831-209-006 - Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 56 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D02R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
14	E5347001021000	1	WEB	
16	E5347001120400	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
567	EN6069D6-07	10	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	9	RIVET	
668	EN6081D6-08	24	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	2	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	22	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	9	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	15	PIN	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	2	PIN	
965	DAN5-6-5	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	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	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

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NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBGAB Replacement of Webs and Angles at Frame 56	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBGAB Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

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1 From Frame 56, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347078720000	Item (9)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the flange of Frame 56, between STGR 35 LH and STGR 36 LH, remove:

9	Rivet		Item (100)	Discard

3 From Frame 56, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347078820000	Item (10)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 56, between STGR 36 LH and STGR 39 LH, remove:

1	Shear web	D5347078620000	Item (11)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle-Support	D5347068120000	Item (102)	Retain
1	Angle	D5347046820600	Item (121)	Retain
1	Support	D5347068520100	Item (134)	Retain
	with			
64	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 56.

Refer to NTM 51-10-01.

Refer to Fig. A-GBGAB Sheet 02, Views C and E.

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1 On Frame 56, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 56, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 56, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBGAB Sheet 02 thru Fig. A-GBGAB Sheet 04.

1 On Frame 56, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBGAB Sheet 02, View C.

1	Shear Web	E5347001021000	Item 14

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 56 to the shear web, Item 14.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAB Sheet 04.

4 Drill the additional 6 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBGAB Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBGAB Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAB Sheet 04.

5 Transfer drill the tack hole from the Frame 56 between STGR 36 LH and 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

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6 On Frame 56, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021000	Item 14

7 Clean and deburr the new fastener holes in Frame 56 and the shear web, Item 14, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBGAB Sheet 02, Views C and E.

a On Frame 56, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBGAB Sheet 02, View C.

1	Shear Web	E5347001021000	Item 14

b On Frame 56, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAB Sheet 02, View C.

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c On Frame 56, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAB Sheet 02, View C.

d On the top flange of Frame 56, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAB Sheet 02, View E.

9 On Frame 56, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021000	Item 14

10 Clean and deburr the cold expansion fastener holes in Frame 56 and the shear web, Item 14, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 56, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBGAB Sheet 02, View C.

1	Shear Web	E5347001021000	Item 14

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
10	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
9	Rivet	EN6081D6-06	Item 666
19	Rivet	EN6081D6-08	Item 668
7	Pin	DAN5-6-4X	Item 764
17	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
15	Pin	DAN6-6-3	Item 863
2	Pin	DAN5-6-4	Item 964

use

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 56, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBGAB Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the Frame 56 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBGAB Sheet 02, View C and Fig. A-GBGAB Sheet 03, Section A-A.

1	Angle	E5347001120400	Item 16

14 Transfer drill and ream the holes from the Frame 56 and from STGR 35 LH to the angle, Item 16, refer to Fig. A-GBGAB Sheet 02, View C and Fig. A-GBGAB Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAB Sheet 04.

15 On the Frame 56 flange, at STGR 35 LH, remove:

1	Angle	E5347001120400	Item 16

16 Clean and deburr the new fastener holes in the Frame 56, STGR 35 LH and angle, Item 16, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

17 On the Frame 56 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBGAB Sheet 02, View C and Fig. A-GBGAB Sheet 03, Section A-A.

1	Angle	E5347001120400	Item 16

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656	
2	Rivet	EN6081D6-09	Item 669	
1	Collar	NSA5075-6	Item 806	
1	Pin	DAN5-6-5	Item 965	

18 On the Frame 56 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBGAB Sheet 02, View C and Fig. A-GBGAB Sheet 03, Section A-A.

1	Support	D5347068520100	Item (134)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D6-08	Item 668	

19 On the Frame 56 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBGAB Sheet 02, View C and Fig. A-GBGAB Sheet 03, Section B-B.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

20 On the aft side of the Frame 56 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBGAB Sheet 02, View C.

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1	Angle	D5347046820600	Item (121)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
1	Pin	DAN5-6-5Y	Item 785	
1	Collar	DAN11-6Y	Item 809	
2	Pin	DAN5-6-5X	Item 765	
2	Collar	DAN11-6X	Item 807	

21 On the Frame 56 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBGAB Sheet 02, View C and Fig. A-GBGAB Sheet 03, Section C-C.

1	Angle-Support	D5347068120000	Item (102)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-08	Item 668	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		

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Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(10) Subtask 531364-831-210-006 - Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 57 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D02R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
18	E5347001021200	1	WEB	
20	E5347001123800	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	1	RIVET	
668	EN6081D6-08	17	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	19	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	10	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	11	PIN	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01

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References	
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBHAB Replacement of Webs and Angles at Frame 57	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBHAB Sheet 02, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 57, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347081820000	Item (12)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 57, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

8	Rivet		Item (100)	Discard

3 From Frame 57, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347081720000	Item (13)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 57, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347081620000	Item (14)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle-Support	D5347068120000	Item (102)	Retain
1	Angle	D5347046820200	Item (118)	Retain
	with			

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57	Rivet	Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 57.

Refer to NTM 51-10-01.

Refer to Fig. A-GBHAB Sheet 02, Views C, D and F.

1 On Frame 57, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 57, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 57, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBHAB Sheet 02 thru Fig. A-GBHAB Sheet 04.

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1 On Frame 57, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBHAB Sheet 02, View C.

1	Shear Web	E5347001021200	Item 18

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 57 to the shear web, Item 18.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAB Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBHAB Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBHAB Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAB Sheet 04.

5 Transfer drill the tack hole from the Frame 57 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 57, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021200	Item 18

7 Clean and deburr the new fastener holes in Frame 57 and the shear web, Item 18, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBHAB Sheet 02, Views C, D and F.

a On Frame 57, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBHAB Sheet 02, View C.

1	Shear Web	E5347001021200	Item 18

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b On Frame 57, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAB Sheet 02, View C.

c On Frame 57, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAB Sheet 02, View C.

d On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAB Sheet 02, View D.

e On the top flange of Frame 57, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAB Sheet 02, View F.

9 On Frame 57, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021200	Item 18

10 Clean and deburr the cold expansion fastener holes in Frame 57 and the shear web, Item 18, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 57, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBHAB Sheet 02, View C.

1	Shear Web	E5347001021200	Item 18

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
13	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863
1	Pin	DAN5-6-3	Item 963
2	Pin	DAN5-6-4	Item 964

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use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 57, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBHAB Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBHAB Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

14 On the Frame 57 flange, at STGR 35 LH, refer to Fig. A-GBHAB Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 57 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBHAB Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 57 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBHAB Sheet 02, View C and Fig. A-GBHAB Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

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17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBHAB Sheet 02, View C and Fig. A-GBHAB Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAB Sheet 04.

18 On the Frame 57 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 57, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 57 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBHAB Sheet 02, View C and Fig. A-GBHAB Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

21 On the Frame 57 flange, at STGR 36 LH, refer to Fig. A-GBHAB Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 57 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBHAB Sheet 03, Section B-B.

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1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 57 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBHAB Sheet 02, View C and Fig. A-GBHAB Sheet 03, Section B-B.

1	Angle	E5347001123800	Item 20

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 20, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the two holes form the Frame to the angle, Item 20, refer to Fig. A-GBHAB Sheet 02, View C and Fig. A-GBHAB Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAB Sheet 04.

25 On the Frame 57 flange, at STGR 36 LH, remove:

1	Angle	E5347001123800	Item 20

26 Clean and deburr the new fastener holes in the Frame 57, STGR 36 LH and angle, Item 20, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 57 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBHAB Sheet 02, View C and Fig. A-GBHAB Sheet 03, Section B-B.

1	Angle	E5347001123800	Item 20

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656

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1	Rivet	EN6081D6-07	Item 667	
1	Collar	NSA5075-6	Item 806	
1	Pin	DAN5-6-4	Item 964	

28 On the Frame 57 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBHAB Sheet 02, View C and Fig. A-GBHAB Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 57 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBHAB Sheet 02, View C.

1	Angle	D5347046820200	Item (118)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
1	Pin	DAN5-6-5Y	Item 785	
1	Collar	DAN11-6Y	Item 809	
2	Pin	DAN5-6-5X	Item 765	
2	Collar	DAN11-6X	Item 807	

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30 On the Frame 57 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBHAB Sheet 02, View C and Fig. A-GBHAB Sheet 03, Section D-D.

1	Angle-Support	D5347068120000	Item (102)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-08	Item 668	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(11) Subtask 531364-831-211-006 - Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 58 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D02R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
22	E5347001021400	1	WEB	
24	E5347001120600	1	ANGLE	
26	E5347001120800	1	ANGLE	
363	EN6115K3-3	5	BOLT	
364	EN6115K3-4	3	BOLT	
374	EN6115K3A4	2	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
567	EN6069D6-07	14	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	3	RIVET	
666	EN6081D6-06	2	RIVET	
667	EN6081D6-07	4	RIVET	
668	EN6081D6-08	4	RIVET	(1)
670	EN6081D7-10	4	RIVET	
678	EN6081D7-08	6	RIVET	
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	20	COLLAR	
807	DAN11-6X	10	COLLAR	
808	ASNA2528-3	9	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	9	PIN	
908	ASNA2528-3A	2	NUT	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	5	PIN	
965	DAN5-6-5	2	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBJAB Replacement of Webs and Angles at Frame 58	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBJAB Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 58, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347082420000	Item (15)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 58, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 58, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347080520000	Item (16)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 58, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347083020000	Item (17)	Discard
1	Support	D5347032200600	Item (104)	Retain
1	Angle-Support	D5347069520000	Item (105)	Retain
1	Angle	D5347046820800	Item (125)	Retain
	with			
47	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 58.

Refer to NTM 51-10-01.

Refer to Fig. A-GBJAB Sheet 02, Views C, D and F.

1 On Frame 58, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 58, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 7 holes for the fasteners, Item 363, Item 364 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 On the top flange of Frame 58, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 58, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBJAB Sheet 02 thru Fig. A-GBJAB Sheet 04.

1 On Frame 58, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBJAB Sheet 02, View C.

1	Shear Web	E5347001021400	Item 22

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

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3 Transfer drill the fastener holes from the Frame 58 to the shear web, Item 22.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAB Sheet 04.

4 Drill the additional 10 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBJAB Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBJAB Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAB Sheet 04.

5 Transfer drill the tack hole from the Frame 58 between STGR 36 LH and STGR 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 58, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021400	Item 22

7 Clean and deburr the new fastener holes in Frame 58 and the shear web, Item 22, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBJAB Sheet 02, Views C, D and F.

a On Frame 58, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBJAB Sheet 02, View C.

1	Shear Web	E5347001021400	Item 22

b On Frame 58, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAB Sheet 02, View C.

c On Frame 58, between STGR 36 LH and STGR 37 LH, cold expand the 5 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAB Sheet 02, View C.

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d On Frame 58, between STGR 36 LH and STGR 37 LH, cold expand the 2 holes for the fasteners, Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAB Sheet 02, View C.

e On the top flange of Frame 58, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAB Sheet 02, View D.

f On the top flange of Frame 58, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAB Sheet 02, View F.

9 On Frame 58, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021400	Item 22

10 Clean and deburr the cold expansion fastener holes in Frame 58 and the shear web, Item 22, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 58, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBJAB Sheet 02, View C.

1	Shear Web	E5347001021400	Item 22

with

4	Bolt	EN6115K3-3	Item 363

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3	Bolt	EN6115K3-4	Item 364
2	Bolt	EN6115K3A4	Item 374
14	Rivet	EN6069D6-07	Item 567
7	Pin	DAN5-6-4X	Item 764
8	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-06	Item 666
4	Rivet	EN6081D6-08	Item 668
6	Rivet	EN6081D7-08	Item 678
13	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
7	Nut	ASNA2528-3	Item 808
8	Pin	DAN6-6-3	Item 863
2	Nut	ASNA2528-3A	Item 908
5	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 58, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBJAB Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 58, at STGR 35 LH, install:

Refer to Fig. A-GBJAB Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808

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1	Pin	DAN6-6-3	Item 863

14 On the Frame 58 flange, at STGR 35 LH, refer to Fig. A-GBJAB Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 58 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBJAB Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 58 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBJAB Sheet 02, View C and Fig. A-GBJAB Sheet 03, Section A-A.

1	Angle	E5347001120600	Item 24

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 24, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 24, refer to Fig. A-GBJAB Sheet 02, View C and Fig. A-GBJAB Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAB Sheet 04.

18 On the Frame 58 flange, at STGR 35 LH, remove:

1	Angle	E5347001120600	Item 24

19 Clean and deburr the new fastener holes in the Frame 58, STGR 35 LH and angle, Item 24, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 58 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBJAB Sheet 02, View C and Fig. A-GBJAB Sheet 03, Section A-A.

1	Angle	E5347001120600	Item 24

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
1	Pin	DAN5-6-5X	Item 765
2	Collar	NSA5075-6	Item 806
1	Collar	DAN11-6X	Item 807
2	Pin	DAN5-6-5	Item 965

21 On the Frame 58 flange, at STGR 36 LH, refer to Fig. A-GBJAB Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 58 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBJAB Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 58 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBJAB Sheet 02, View C and Fig. A-GBJAB Sheet 03, Section B-B.

1	Angle	E5347001120800	Item 26

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 26, to the STGR 36 LH, then transfer drill and ream the other holes from STGR 36 LH to the angle, Item 26, refer to Fig. A-GBJAB Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAB Sheet 04.

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 26, to the Frame 58 flange, at STGR 36 LH, then transfer drill and ream the other holes from the Frame to the angle, Item 26, refer to Fig. A-GBJAB Sheet 03, View E.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAB

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Sheet 04.

26 On the Frame 58 flange, at STGR 36 LH, remove:

1	Angle	E5347001120800	Item 26	

27 Clean and deburr the new fastener holes in the Frame 58, STGR 36 LH and angle, Item 26, use:

Textile - Lint Free Cotton	14SBA1	As required	

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required	

28 On the Frame 58 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBJAB Sheet 02, View C and Fig. A-GBJAB Sheet 03, Section B-B.

1	Angle	E5347001120800	Item 26	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-06	Item 656	
1	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	

29 On the Frame 58 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBJAB Sheet 02, View C and Fig. A-GBJAB Sheet 03, Section C-C.

1	Support	D5347032200600	Item (104)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

4	Rivet	EN6081D7-10	Item 670	

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4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

30 On the aft side of the Frame 58 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBJAB Sheet 02, View C.

1	Angle	D5347046820800	Item (125)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

1	Pin	DAN5-6-5Y	Item 785	
1	Collar	DAN11-6Y	Item 809	
2	Pin	DAN5-6-5X	Item 765	
2	Collar	DAN11-6X	Item 807	

31 On the Frame 58 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBJAB Sheet 02, View C and Fig. A-GBJAB Sheet 03, Section D-D.

1	Angle-Support	D5347069520000	Item (105)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(12) Subtask 531364-831-212-006 - Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 59 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D02R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
28	E5347001021600	1	WEB	
30	E5347001121000	1	ANGLE	
32	E5347001121200	1	ANGLE	
363	EN6115K3-3	5	BOLT	
364	EN6115K3-4	2	BOLT	
365	EN6115K3-5	3	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	20	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	20	RIVET	
667	EN6081D6-07	3	RIVET	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
668	EN6081D6-08	7	RIVET	(1)
669	EN6081D6-09	3	RIVET	(2)
764	DAN5-6-4X	3	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	21	COLLAR	
807	DAN11-6X	6	COLLAR	
808	ASNA2528-3	11	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	8	PIN	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	6	PIN	
965	DAN5-6-5	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

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NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBKAB Replacement of Webs and Angles at Frame 59	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBKAB Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 59, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347089120000	Item (18)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 59, at STGR 35 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

5	Rivet		Item (100)	Discard

3 From Frame 59, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347089020000	Item (19)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 59, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347088920000	Item (20)	Discard
1	Support	D5347032201000	Item (106)	Retain

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1	Angle-Support	D5347068820000	Item (107)	Retain
1	Angle	D5347046821000	Item (127)	Retain
	with			
59	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 59.

Refer to NTM 51-10-01.

Refer to Fig. A-GBKAB Sheet 02, Views C and D.

1 On Frame 59, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 59, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 7 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 59, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBKAB Sheet 02 thru Fig. A-GBKAB Sheet 04.

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1 On Frame 59, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBKAB Sheet 02, View C.

1	Shear Web	E5347001021600	Item 28

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 59 to the shear web, Item 28.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAB Sheet 04.

4 Drill the additional 17 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBKAB Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBKAB Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAB Sheet 04.

5 Transfer drill the tack hole from the Frame 59 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 59, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021600	Item 28

7 Clean and deburr the new fastener holes in Frame 59 and the shear web, Item 28, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBKAB Sheet 02, Views C and D.

a On Frame 59, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBKAB Sheet 02, View C.

1	Shear Web	E5347001021600	Item 28

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b On Frame 59, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAB Sheet 02, View C.

c On Frame 59, between STGR 36 LH and STGR 37 LH, cold expand the 7 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAB Sheet 02, View C.

d On the top flange of Frame 59, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAB Sheet 02, View D.

9 On Frame 59, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021600	Item 28

10 Clean and deburr the cold expansion fastener holes in Frame 59 and the shear web, Item 28, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 59, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBKAB Sheet 02, View C.

1	Shear Web	E5347001021600	Item 28

with

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4	Bolt	EN6115K3-3	Item 363
2	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
16	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D6-06	Item 666
5	Rivet	EN6081D6-08	Item 668
3	Pin	DAN5-6-4X	Item 764
14	Collar	NSA5075-6	Item 806
3	Collar	DAN11-6X	Item 807
6	Nut	ASNA2528-3	Item 808
8	Pin	DAN6-6-3	Item 863
6	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 59, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBKAB Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 59, at STGR 35 LH, install:

Refer to Fig. A-GBKAB Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

14 On the Frame 59 flange, at STGR 35 LH, refer to Fig. A-GBKAB Sheet 03, Section A-A, countersink the one fastener hole.

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15 On the Frame 59 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBKAB Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 59 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBKAB Sheet 02, View C and Fig. A-GBKAB Sheet 03, Section A-A.

1	Angle	E5347001121000	Item 30

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 30, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 30, refer to Fig. A-GBKAB Sheet 02, View C and Fig. A-GBKAB Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAB Sheet 04.

18 On the Frame 59 flange, at STGR 35 LH, remove:

1	Angle	E5347001121000	Item 30

19 Clean and deburr the new fastener holes in the Frame 59, STGR 35 LH and angle, Item 30, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 59 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBKAB Sheet 02, View C and Fig. A-GBKAB Sheet 03, Section A-A.

1	Angle	E5347001121000	Item 30

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656
3	Collar	NSA5075-6	Item 806
3	Pin	DAN5-6-5	Item 965

21 On the Frame 59 flange, at STGR 36 LH, refer to Fig. A-GBKAB Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 59 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBKAB Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 59 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBKAB Sheet 02, View C and Fig. A-GBKAB Sheet 03, Section B-B.

1	Angle	E5347001121200	Item 32

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 32, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 32, refer to Fig. A-GBKAB Sheet 02, View C and Fig. A-GBKAB Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAB Sheet 04.

25 On the Frame 59 flange, at STGR 36 LH, remove:

1	Angle	E5347001121200	Item 32

26 Clean and deburr the new fastener holes in the Frame 59, STGR 36 LH and angle, Item 32, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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27 On the Frame 59 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBKAB Sheet 02, View C and Fig. A-GBKAB Sheet 03, Section B-B.

1	Angle	E5347001121200	Item 32	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D6-07	Item 667	

28 On the Frame 59 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBKAB Sheet 02, View C and Fig. A-GBKAB Sheet 03, Section C-C.

1	Support	D5347032201000	Item (106)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Bolt	EN6115K3-5	Item 365	
3	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
3	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 59 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBKAB Sheet 02, View C.

1	Angle	D5347046821000	Item (127)	Retained at removal
	with			

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
1	Pin	DAN5-6-5Y	Item 785	
1	Collar	DAN11-6Y	Item 809	
2	Pin	DAN5-6-5X	Item 765	
2	Collar	DAN11-6X	Item 807	

30 On the Frame 59 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBKAB Sheet 02, View C and Fig. A-GBKAB Sheet 03, Section D-D.

1	Angle-Support	D5347068820000	Item (107)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		

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Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(13) Subtask 531364-831-213-006 - Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 60 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D02R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
34	E5347001021800	1	WEB	
38	E5347001121600	1	ANGLE	
40	E5347001121800	1	ANGLE	
363	EN6115K3-3	5	BOLT	
365	EN6115K3-5	8	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
567	EN6069D6-07	20	RIVET	
656	EN6081D5-06	41	RIVET	
666	EN6081D6-06	25	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	4	RIVET	(2)
764	DAN5-6-4X	4	PIN	
765	DAN5-6-5X	1	PIN	
806	NSA5075-6	19	COLLAR	
807	DAN11-6X	5	COLLAR	
808	ASNA2528-3	14	NUT	
864	DAN6-6-4	5	PIN	
865	DAN6-6-5	5	PIN	
963	DAN5-6-3	1	PIN	
964	DAN5-6-4	4	PIN	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
965	DAN5-6-5	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01

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References	
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBLAB Replacement of Webs and Angles at Frame 60	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBLAB Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 60, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347085020000	Item (21)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 60, at STGR 35 LH and from the frame flange between STGR 34 LH and STGR 35 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 60, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347085120000	Item (22)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 60, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347093120000	Item (23)	Discard
1	Support	D5347032201200	Item (108)	Retain
1	Angle	D5347046821200	Item (128)	Retain
1	Section-Connecting	D5347065420400	Item (136)	Retain

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1	Shim	D5347044920000	Item (142)	Retain
1	Shim	D5347044920600	Item (143)	Retain
	with			
77	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 60.

Refer to NTM 51-10-01.

Refer to Fig. A-GBLAB Sheet 02, Views C and D.

1 On Frame 60, at STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 60, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 60, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBLAB Sheet 02 thru Fig. A-GBLAB Sheet 04.

1 On Frame 60, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBLAB Sheet 02, View C.

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1	Shear Web	E5347001021800	Item 34

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 60 to the shear web, Item 34.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAB Sheet 04.

4 Drill the additional 38 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBLAB Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBLAB Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAB Sheet 04.

5 Transfer drill the tack hole from the Frame 60 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 60, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021800	Item 34

7 Clean and deburr the new fastener holes in Frame 60 and the shear web, Item 34, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBLAB Sheet 02, Views C and D.

a On Frame 60, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBLAB Sheet 02, View C.

1	Shear Web	E5347001021800	Item 34

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b On Frame 60, at STGR 35 LH, cold expand the 4 holes for the fasteners, Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAB Sheet 02, View C.

c On Frame 60, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAB Sheet 02, View C.

d On the top flange of Frame 60, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAB Sheet 02, View D.

9 On Frame 60, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021800	Item 34

10 Clean and deburr the cold expansion fastener holes in Frame 60 and the shear web, Item 34, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 60, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBLAB Sheet 02, View C.

1	Shear Web	E5347001021800	Item 34

with

5	Bolt	EN6115K3-3	Item 363

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20	Rivet	EN6069D6-07	Item 567
37	Rivet	EN6081D5-06	Item 656
25	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
4	Pin	DAN5-6-4X	Item 764
4	Collar	DAN11-6X	Item 807
5	Nut	ASNA2528-3	Item 808

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 On the top flange of Frame 60, at STGR 35 LH, install:

Refer to Fig. A-GBLAB Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

13 On the Frame 60 flange, at STGR 35 LH, refer to Fig. A-GBLAB Sheet 03, Section B-B, countersink the one fastener hole.

14 On the Frame 60 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBLAB Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 60 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBLAB Sheet 02, View C and Fig. A-GBLAB Sheet 03, Section B-B.

1	Angle	E5347001121600	Item 38

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16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 38, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH to the angle, Item 38, refer to Fig. A-GBLAB Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAB Sheet 04.

17 On the Frame 60 flange, at STGR 35 LH, remove:

1	Angle	E5347001121600	Item 38

18 Clean and deburr the new fastener holes in the STGR 35 LH and angle, Item 38, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 60 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBLAB Sheet 02, View C and Fig. A-GBLAB Sheet 03, Section B-B.

1	Angle	E5347001121600	Item 38

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
2	Rivet	EN6081D5-06	Item 656
4	Nut	ASNA2528-3	Item 808

20 On the Frame 60 flange, at STGR 36 LH, refer to Fig. A-GBLAB Sheet 03, Section C-C, countersink the one fastener hole.

21 On the Frame 60 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBLAB Sheet 03, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 60 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBLAB Sheet 02, View C and Fig. A-GBLAB Sheet 03, Section C-C.

1	Angle	E5347001121800	Item 40

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 40, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 40, refer to Fig. A-GBLAB Sheet 02, View C and Fig. A-GBLAB Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAB Sheet 04.

24 On the Frame 60 flange, at STGR 36 LH, remove:

1	Angle	E5347001121800	Item 40

25 Clean and deburr the new fastener holes in the Frame 60, STGR 36 LH and angle, Item 40, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 60 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBLAB Sheet 02, View C and Fig. A-GBLAB Sheet 03, Section C-C.

1	Angle	E5347001121800	Item 40

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D6-07	Item 667

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27 On the Frame 60 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBLAB Sheet 02, View C and Fig. A-GBLAB Sheet 03, Section D-D.

1	Support	D5347032201200	Item (108)	Retained at removal
1	Section-Connecting	D5347065420400	Item (136)	Retained at removal
1	Shim	D5347044920000	Item (142)	Retained at removal
1	Shim	D5347044920600	Item (143)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

4	Bolt	EN6115K3-5	Item 365
4	Rivet	EN6081D6-09	Item 669
19	Collar	NSA5075-6	Item 806
4	Nut	ASNA2528-3	Item 808
5	Pin	DAN6-6-4	Item 864
5	Pin	DAN6-6-5	Item 865
1	Pin	DAN5-6-3	Item 963
4	Pin	DAN5-6-4	Item 964
4	Pin	DAN5-6-5	Item 965

28 On the aft side of the Frame 60 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBLAB Sheet 02, View C.

1	Angle	D5347046821200	Item (128)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
3	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(14) Subtask 531364-831-214-006 - Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 61 from Stringer 33 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D02R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
42	E5347001022000	1	WEB	
44	E5347001122000	1	ANGLE	
46	E5347001122200	1	ANGLE	
48	E5347001122400	1	ANGLE	
363	EN6115K3-3	6	BOLT	
364	EN6115K3-4	3	BOLT	
365	EN6115K3-5	4	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	3	RIVET	
567	EN6069D6-07	24	RIVET	
656	EN6081D5-06	36	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	22	RIVET	
667	EN6081D6-07	10	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	6	RIVET	(2)
763	DAN5-6-3X	4	PIN	
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
807	DAN11-6X	13	COLLAR	
808	ASNA2528-3	14	NUT	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	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	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

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NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBMAB Replacement of Webs and Angles at Frame 61	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBMAB Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

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1 From Frame 61, between STGR 33 LH and STGR 34 LH, remove:

1	Clip	D5347091620200	Item (24)	Discard
	with			
12	Rivet		Item (100)	Discard

2 From Frame 61, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347090620000	Item (25)	Discard
	with			
13	Rivet		Item (100)	Discard

3 From the top flange of Frame 61, between STGR 34 LH and STGR 35 LH and from the frame flange between STGR 33 LH and STGR 35 LH, remove:

11	Rivet		Item (100)	Discard
	or			
12	Rivet		Item (100)	Discard

NOTE: Depending on installation on aircraft.

4 From Frame 61, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347090720000	Item (26)	Discard
	with			
13	Rivet		Item (100)	Discard

5 From Frame 61, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347090820000	Item (27)	Discard
1	Support	D5347032201600	Item (109)	Retain
1	Angle-Support	D5347069620000	Item (110)	Retain
1	Angle	D5347046821400	Item (130)	Retain
	with			
65	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

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and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 61.

Refer to NTM 51-10-01.

Refer to Fig. A-GBMAB Sheet 02, Views C and E.

1 On Frame 61, at STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 61, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 61, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBMAB Sheet 02 thru Fig. A-GBMAB Sheet 04.

1 On Frame 61, between STGR 33 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBMAB Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 61 to the shear web, Item 42.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAB Sheet 04.

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4 Drill the additional 31 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBMAB Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBMAB Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAB Sheet 04.

5 Transfer drill the tack hole from the Frame 61 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 61, between STGR 33 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022000	Item 42

7 Clean and deburr the new fastener holes in Frame 61 and the shear web, Item 42, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBMAB Sheet 02, Views C and E.

a On Frame 61, between STGR 33 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBMAB Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

b On Frame 61, at STGR 35 LH, cold expand the 4 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAB Sheet 02, View E.

c On Frame 61, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAB Sheet 02, View C.

d On the top flange of Frame 61, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAB Sheet 02, View E.

9 On Frame 61, between STGR 33 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022000	Item 42

10 Clean and deburr the cold expansion fastener holes in Frame 61 and the shear web, Item 42, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 61, between STGR 33 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBMAB Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

with

5	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
24	Rivet	EN6069D6-07	Item 567
28	Rivet	EN6081D5-06	Item 656
22	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
6	Collar	DAN11-6X	Item 807

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8	Nut	ASNA2528-3	Item 808

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 On the flange of Frame 61, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBMAB Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 61, at STGR 35 LH, install:

Refer to Fig. A-GBMAB Sheet 02, View E.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

14 On the Frame 61 flange, at STGR 34 LH, refer to Fig. A-GBMAB Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 61 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBMAB Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 61 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section A-A.

1	Angle	E5347001122000	Item 44

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 44, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH and the three holes from the Frame to the angle, Item 44, refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAB Sheet 04.

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18 On the Frame 61 flange, at STGR 34 LH, remove:

1	Angle	E5347001122000	Item 44

19 Clean and deburr the new fastener holes in the Frame 61, STGR 34 LH and angle, Item 44, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 61 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section A-A.

1	Angle	E5347001122000	Item 44

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

If necessary, close the rivet hole in the frame flange at STGR 34 LH with:

1	Rivet	EN6081D6-06	Item 666

NOTE: Depending on installation on aircraft.

21 On the Frame 61 flange, at STGR 35 LH, refer to Fig. A-GBMAB Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 61 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBMAB Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 61 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section B-B.

1	Angle	E5347001122200	Item 46

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 46, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the four holes from the Frame to the angle, Item 46, refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAB Sheet 04.

25 On the Frame 61 flange, at STGR 35 LH, remove:

1	Angle	E5347001122200	Item 46

26 Clean and deburr the new fastener holes in the Frame 61, STGR 35 LH and angle, Item 46, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 61 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section B-B.

1	Angle	E5347001122200	Item 46

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
4	Rivet	EN6081D6-07	Item 667

28 On the Frame 61 flange, at STGR 36 LH, refer to Fig. A-GBMAB Sheet 03, Section C-C, countersink the one fastener hole.

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29 On the Frame 61 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBMAB Sheet 03, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

30 On the Frame 61 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section C-C.

1	Angle	E5347001122400	Item 48

31 Transfer drill and ream one new hole from the pilot hole of the angle, Item 48, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 48, refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAB Sheet 04.

32 On the Frame 61 flange, at STGR 36 LH, remove:

1	Angle	E5347001122400	Item 48

33 Clean and deburr the new fastener holes in the Frame 61, STGR 36 LH and angle, Item 48, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

34 On the Frame 61 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section C-C.

1	Angle	E5347001122400	Item 48

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656	
2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

35 On the Frame 61 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section D-D.

1	Support	D5347032201600	Item (109)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
4	Rivet	EN6081D6-09	Item 669
4	Pin	DAN5-6-3X	Item 763
4	Collar	DAN11-6X	Item 807
4	Nut	ASNA2528-3	Item 808

36 On the Frame 61 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBMAB Sheet 02, View C.

1	Angle	D5347046821400	Item (130)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

3	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

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37 On the Frame 61 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section E-E.

1	Angle-Support	D5347069620000	Item (110)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(15) Subtask 531364-831-215-006 - Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 62 from Stringer 32 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D02R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
50	E5347001022200	1	WEB	
52	E5347001122600	1	ANGLE	
54	E5347001122800	1	ANGLE	
56	E5347001123000	1	ANGLE	
58	E5347001123200	1	ANGLE	
363	EN6115K3-3	6	BOLT	
364	EN6115K3-4	3	BOLT	
365	EN6115K3-5	4	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	4	RIVET	
567	EN6069D6-07	28	RIVET	
568	EN6069D6-08	1	RIVET	
656	EN6081D5-06	45	RIVET	
657	EN6081D5-07	7	RIVET	
666	EN6081D6-06	21	RIVET	
667	EN6081D6-07	7	RIVET	
668	EN6081D6-08	16	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	5	PIN	
765	DAN5-6-5X	3	PIN	
806	NSA5075-6	9	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	14	NUT	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	
965	DAN5-6-5	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBNAB Replacement of Webs and Angles at Frame 62	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBNAB Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 62, between STGR 32 LH and STGR 33 LH, remove:

1	Clip	D5347093420200	Item (28)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From Frame 62, between STGR 33 LH and STGR 34 LH, remove:

1	Clip	D5347084020000	Item (29)	Discard
	with			
13	Rivet		Item (100)	Discard

3 From Frame 62, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347084120000	Item (30)	Discard
	with			
11	Rivet		Item (100)	Discard

4 From the top flange of Frame 62, at STGR 34 LH and from the frame flange between STGR 32 LH and STGR 35 LH, remove:

13	Rivet		Item (100)	Discard
	or			
14	Rivet		Item (100)	Discard

NOTE: Depending on installation on aircraft.

5 From Frame 62, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347084220000	Item (31)	Discard
	with			
11	Rivet		Item (100)	Discard

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6 From Frame 62, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347084820000	Item (32)	Discard
1	Support	D5347032201800	Item (111)	Retain
1	Angle-Support	D5347069720000	Item (112)	Retain
1	Angle	D5347046821600	Item (131)	Retain
	with			
58	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 62.

Refer to NTM 51-10-01.

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 03, View F.

1 On Frame 62, between STGR 34 LH and STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 62, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

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5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBNAB Sheet 02 thru Fig. A-GBNAB Sheet 06.

1 On Frame 62, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBNAB Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 62 to the shear web, Item 50.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAB Sheet 06.

4 On Frame 62, between STGR 34 LH and STGR 37 LH, drill the additional 42 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBNAB Sheet 03, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBNAB Sheet 03.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAB Sheet 06.

5 On Frame 62, between STGR 38 LH and STGR 39 LH, drill the additional rivet hole to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBNAB Sheet 03, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBNAB Sheet 03.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAB Sheet 06.

6 Transfer drill the tack hole from the Frame 62 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

7 On Frame 62, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022200	Item 50

8 Clean and deburr the new fastener holes in Frame 62 and the shear web, Item 50, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBNAB Sheet 02, Views C and Fig. A-GBNAB Sheet 03, View F.

a On Frame 62, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBNAB Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

b On Frame 62, between STGR 34 LH and STGR 35 LH, cold expand the 4 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAB Sheet 02, View C.

c On Frame 62, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

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FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAB Sheet 02, View C.

d On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAB Sheet 03, View F.

10 On Frame 62, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022200	Item 50

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11 Clean and deburr the cold expansion fastener holes in Frame 62 and the shear web, Item 50, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 62, between STGR 32 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBNAB Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

with

5	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
28	Rivet	EN6069D6-07	Item 567
1	Rivet	EN6069D6-08	Item 568
35	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D5-07	Item 657
20	Rivet	EN6081D6-06	Item 666
13	Rivet	EN6081D6-08	Item 668
5	Pin	DAN5-6-4X	Item 764
4	Collar	NSA5075-6	Item 806
5	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
1	Pin	DAN5-6-3	Item 963
3	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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13 On theFrame 62 flange, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBNAB Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBNAB Sheet 03, View F.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

15 On the Frame 62 flange, at STGR 33 LH, refer to Fig. A-GBNAB Sheet 04, Section A-A, countersink the one fastener hole.

16 On the Frame 62 flange, at STGR 33 LH, close the rivet hole in STGR 33 LH with:

Refer to Fig. A-GBNAB Sheet 04, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 62 flange, at STGR 33 LH, put in position:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section A-A.

1	Angle	E5347001122600	Item 52

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 52, to the STGR 33 LH, then transfer drill and ream the other hole from STGR 33 LH and the three holes from the Frame to the angle, Item 52, refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAB Sheet 06.

19 On the Frame 62 flange, at STGR 33 LH, remove:

1	Angle	E5347001122600	Item 52

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20 Clean and deburr the new fastener holes in the Frame 62, STGR 33 LH and angle, Item 52, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 62 flange, at STGR 33 LH, wet install:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section A-A.

1	Angle	E5347001122600	Item 52

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Collar	NSA5075-6	Item 806
1	Pin	DAN5-6-5	Item 965

22 On the Frame 62 flange, at STGR 33 LH, if necessary, install:

Refer to Fig. A-GBNAB Sheet 02, View C.

1	Rivet	EN6081D6-06	Item 666

NOTE: Depending on installation on aircraft.

23 On the Frame 62 flange, at STGR 34 LH, refer to Fig. A-GBNAB Sheet 04, Section B-B, countersink the one fastener hole.

24 On the Frame 62 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBNAB Sheet 04, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

25 On the Frame 62 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section B-B.

1	Angle	E5347001122800	Item 54

26 Transfer drill and ream one new hole from the pilot hole of the angle, Item 54, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH and the three holes from the Frame to the angle, Item 54, refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAB Sheet 06.

27 On the Frame 62 flange, at STGR 34 LH, remove:

1	Angle	E5347001122800	Item 54

28 Clean and deburr the new fastener holes in the Frame 62, STGR 34 LH and angle, Item 54, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

29 On the Frame 62 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section B-B.

1	Angle	E5347001122800	Item 54

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765

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1	Collar	DAN11-6X	Item 807

30 On the Frame 62 flange, at STGR 34 LH, install:

Refer to Fig. A-GBNAB Sheet 02, View C.

1	Rivet	EN6081D6-07	Item 667

31 On the Frame 62 flange, at STGR 35 LH, refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section C-C, countersink the one fastener hole.

32 On the Frame 62 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBNAB Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 62 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section C-C.

1	Angle	E5347001123000	Item 56

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 56, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the five holes from the Frame to the angle, Item 56, refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAB Sheet 06.

35 On the Frame 62 flange, at STGR 35 LH, remove:

1	Angle	E5347001123000	Item 56

36 Clean and deburr the new fastener holes in the Frame 62, STGR 35 LH and angle, Item 56, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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37 On the Frame 62 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section C-C.

1	Angle	E5347001123000	Item 56
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

38 On the Frame 62 flange, at STGR 36 LH, refer to Fig. A-GBNAB Sheet 04, Section D-D, countersink the one fastener hole.

39 On the Frame 62 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBNAB Sheet 04, Section D-D.

1	Rivet	EN6069D5-05	Item 555
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

40 On the Frame 62 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section D-D.

1	Angle	E5347001123200	Item 58

41 Transfer drill and ream one new hole from the pilot hole of the angle, Item 58, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 58, refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAB Sheet 06.

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42 On the Frame 62 flange, at STGR 36 LH, remove:

1	Angle	E5347001123200	Item 58	

43 Clean and deburr the new fastener holes in the Frame 62, STGR 36 LH and angle, Item 58, use:

Textile - Lint Free Cotton	14SBA1	As required	

made moist with

Non Aqueous Cleaner - General	08BAA9	As required	

44 On the Frame 62 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section D-D.

1	Angle	E5347001123200	Item 58	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	

45 On the Frame 62 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 05, Section E-E.

1	Support	D5347032201800	Item (111)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	

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4	Collar	NSA5075-6	Item 806	
4	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	

46 On the aft side of the Frame 62 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBNAB Sheet 02, View C.

1	Angle	D5347046821600	Item (131)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

47 On the Frame 62 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 05, Section F-F.

1	Angle-Support	D5347069720000	Item (112)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
2	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

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(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(16) Subtask 531364-831-216-006 - Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 63 from Stringer 32 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D02R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
60	E5347001022400	1	WEB	
62	E5347001123400	1	ANGLE	
64	E5347001123600	2	ANGLE	
363	EN6115K3-3	4	BOLT	
365	EN6115K3-5	8	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	3	RIVET	
567	EN6069D6-07	23	RIVET	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
568	EN6069D6-08	1	RIVET	
656	EN6081D5-06	43	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	22	RIVET	
667	EN6081D6-07	6	RIVET	
668	EN6081D6-08	12	RIVET	(1)
669	EN6081D6-09	7	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	8	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	13	NUT	
963	DAN5-6-3	8	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

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NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBPAB Replacement of Webs and Angles at Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBPAB Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 63, at STGR 33 LH, remove:

1	Shim	D5347032020200	Item (132)	Retain
1	Sheet-Support	D5347109620000	Item (133)	Retain
	with			
7	Rivet		Item (100)	Discard

2 From Frame 63, between STGR 32 LH and STGR 34 LH, remove:

1	Clip	D5347082820000	Item (33)	Discard
	with			
21	Rivet		Item (100)	Discard

3 From the top flange of Frame 63, at STGR 34 LH and from the frame flange between STGR 33 LH and STGR 34 LH, remove:

5	Rivet		Item (100)	Discard

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4 From Frame 63, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347079220000	Item (34)	Discard
	with			
10	Rivet		Item (100)	Discard

5 From Frame 63, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347079920000	Item (35)	Discard
	with			
11	Rivet		Item (100)	Discard

6 From Frame 63, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347082920000	Item (36)	Discard
1	Angle-Support	D5347069820000	Item (113)	Retain
1	Support	D5347032202000	Item (114)	Retain
1	Angle	D5347046821800	Item (115)	Retain
	with			
54	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 63.

Refer to NTM 51-10-01.

Refer to Fig. A-GBPAB Sheet 02, Views C and D.

1 On Frame 63, at STGR 34 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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2 On Frame 63, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 8 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 63, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBPAB Sheet 02 thru Fig. A-GBPAB Sheet 06.

1 On Frame 63, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBPAB Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 63 to the shear web, Item 60.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAB Sheet 06.

4 On Frame 63, between STGR 34 LH and STGR 37 LH, drill the additional 41 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBPAB Sheet 03, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBPAB Sheet 03.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAB Sheet 06.

5 Transfer drill the tack hole from the Frame 63 between STGR 36 LH and STGR 37 LH, to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 63, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022400	Item 60

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7 Clean and deburr the new fastener holes in Frame 63 and the shear web, Item 60, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBPAB Sheet 02, Views C and D.

a On Frame 63, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBPAB Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

b On Frame 63, at STGR 34 LH, cold expand the 4 holes for the fasteners, Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAB Sheet 02, View C.

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c On Frame 63, between STGR 36 LH and STGR 37 LH, cold expand the 8 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAB Sheet 02, View C.

d On the top flange of Frame 63, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAB Sheet 02, View D.

9 On Frame 63, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022400	Item 60

10 Clean and deburr the new fastener holes in Frame 63 and the shear web, Item 60, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 63, between STGR 32 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBPAB Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

with

4	Bolt	EN6115K3-3	Item 363
23	Rivet	EN6069D6-07	Item 567
1	Rivet	EN6069D6-08	Item 568
35	Rivet	EN6081D5-06	Item 656
22	Rivet	EN6081D6-06	Item 666
10	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
6	Collar	DAN11-6X	Item 807
4	Nut	ASNA2528-3	Item 808

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 On the Frame 63 flange, at STGR 33 LH, wet install:

Refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 04, Section A-A.

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1	Shim	D5347032020200	Item (132)	Retained at removal
1	Sheet-Support	D5347109620000	Item (133)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

3	Rivet	EN6081D6-09	Item 669
4	Collar	NSA5075-6	Item 806
4	Pin	DAN5-6-3	Item 963

13 On the Frame 63 flange, at STGR 34 LH, refer to Fig. A-GBPAB Sheet 04, Section B-B, countersink the one fastener hole.

14 On the Frame 63 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBPAB Sheet 04, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

15 On the Frame 63 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 04, Section B-B.

1	Angle	E5347001123400	Item 62

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 62, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH to the angle, Item 62, refer to Fig. A-GBPAB Sheet 04, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAB Sheet 06.

17 On the Frame 63 flange, at STGR 34 LH, remove:

1	Angle	E5347001123400	Item 62

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18 Clean and deburr the new fastener holes in the STGR 34 LH and angle, Item 62, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 63 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 04, Section B-B.

1	Angle	E5347001123400	Item 62

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
2	Rivet	EN6081D5-06	Item 656
4	Nut	ASNA2528-3	Item 808

20 On the top flange of Frame 63, at STGR 34 LH, install:

Refer to Fig. A-GBPAB Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

21 On the Frame 63 flange, at STGR 35 LH, refer to Fig. A-GBPAB Sheet 04, Section C-C, countersink the one fastener hole.

22 On the Frame 63 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBPAB Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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23 On the Frame 63 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 64, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the five holes from the Frame to the angle, Item 64, refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAB Sheet 06.

25 On the Frame 63 flange, at STGR 35 LH, remove:

1	Angle	E5347001123600	Item 64

26 Clean and deburr the new fastener holes in the Frame 63, STGR 35 LH and angle, Item 64, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 63 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

28 On the Frame 63 flange, at STGR 36 LH, refer to Fig. A-GBPAB Sheet 04, Section C-C, countersink the one fastener hole.

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29 On the Frame 63 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBPAB Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

30 On the Frame 63 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

31 Transfer drill and ream one new hole from the pilot hole of the angle, Item 64, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 64, refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAB Sheet 06.

32 On the Frame 63 flange, at STGR 36 LH, remove:

1	Angle	E5347001123600	Item 64

33 Clean and deburr the new fastener holes in the Frame 63, STGR 36 LH and angle, Item 64, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

34 On the Frame 63 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	

35 On the Frame 63 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 05, Section D-D.

1	Support	D5347032202000	Item (114)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
4	Rivet	EN6081D6-09	Item 669
4	Collar	NSA5075-6	Item 806
4	Nut	ASNA2528-3	Item 808
4	Pin	DAN5-6-3	Item 963

36 On the Frame 63 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBPAB Sheet 02, View C.

1	Angle	D5347046821800	Item (115)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

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37 On the Frame 63 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 05, Section E-E.

1	Angle-Support	D5347069820000	Item (113)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
2	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(17) Subtask 531364-831-217-006 - Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 Stringer 38 LH

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To	160	Work location	from Frame 60 to Frame 63 Stringer 38 LH

Manpower Resources	
Manhours	6.50
Minimum number of person	2
Subtask elapsed time	6.50
Skills	AIRFRAME

Material necessary to do the job

Kit 531364D02R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
544	EN6069D4-04	4	RIVET	
545	EN6069D4-05	52	RIVET	
655	EN6081D5-05	15	RIVET	
656	EN6081D5-06	183	RIVET	
657	EN6081D5-07	55	RIVET	
764	DAN5-6-4X	4	PIN	
765	DAN5-6-5X	4	PIN	
784	DAN5-6-4Y	2	PIN	
786	DAN5-6-6Y	6	PIN	
806	NSA5075-6	10	COLLAR	
807	DAN11-6X	4	COLLAR	
809	DAN11-6Y	18	COLLAR	
864	DAN6-6-4	3	PIN	
865	DAN6-6-5	7	PIN	
885	DAN6-6-5Y	4	PIN	
886	DAN6-6-6Y	3	PIN	
887	DAN6-6-7Y	3	PIN	

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	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12 53-41-14

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References	
Fig. A-GBQAB Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Install the shear plates.

Refer to Fig. A-GBQAB Sheet 01 thru Fig. A-GBQAB Sheet 06.

1 Between Frame 49 and Frame 50, on STGR 38 LH and on the bracket, Item 66, put in position:

Refer to Fig. A-GBQAB Sheet 02, View D.

1	Plate-Shear	D5347471500000	Item (139)	Retained at removal

2 Transfer drill and ream the three holes from the shear plate, Item (139), to the bracket, Item 66, refer to Fig. A-GBQAB Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAB Sheet 06.

3 Between Frame 49 and Frame 50, on STGR 38 LH, remove:

1	Plate-Shear	D5347471500000	Item (139)	Retain

4 Between Frame 49 and Frame 50, on STGR 38 LH, clean and deburr the new fastener holes in the bracket, Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

5 Between Frame 49 and Frame 50, on STGR 38 LH and on the bracket, Item 66, wet install:

Refer to Fig. A-GBQAB Sheet 02, View D.

1	Plate-Shear	D5347471500000	Item (139)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6069D4-05	Item 545	
6	Rivet	EN6081D5-06	Item 656	
20	Rivet	EN6081D5-07	Item 657	

6 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item 66, put in position:

Refer to Fig. A-GBQAB Sheet 02, View D.

1	Plate-Shear	D5347471500200	Item (117)	Retained at removal

7 Transfer drill and ream the six holes from the shear plate, Item (117), to the brackets, Item 65 and Item 66, refer to Fig. A-GBQAB Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAB Sheet 06.

8 Between Frame 50 and Frame 51, on STGR 38 LH, remove:

1	Plate-Shear	D5347471500200	Item (117)	Retain

9 Between Frame 50 and Frame 51, on STGR 38 LH, clean and deburr the new fastener holes in the brackets, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

10 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item 66, wet install:

Refer to Fig. A-GBQAB Sheet 02, View D.

1	Plate-Shear	D5347471500200	Item (117)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545	

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6	Rivet	EN6081D5-06	Item 656	
20	Rivet	EN6081D5-07	Item 657	

11 Between Frame 51 and Frame 53, on STGR 38 LH and on the brackets, Item 65, Item (140), Item (116) and Item 68, put in position:

Refer to Fig. A-GBQAB Sheet 02, View D and Fig. A-GBQAB Sheet 03, View F.

1	Plate-Shear	D5347471500600	Item (137)	Retained at removal
1	Plate-Shear	D5347471500800	Item (119)	Retained at removal

12 Transfer drill and ream the three holes from the shear plate, Item (137), to the bracket, Item 65, refer to Fig. A-GBQAB Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAB Sheet 06.

13 Transfer drill and ream the three holes from the shear plate, Item (119), to the bracket, Item 68, refer to Fig. A-GBQAB Sheet 03, View F.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAB Sheet 06.

14 Between Frame 51 and Frame 53, on STGR 38 LH, remove:

1	Plate-Shear	D5347471500600	Item (137)	Retain
1	Plate-Shear	D5347471500800	Item (119)	Retain

15 Between Frame 51 and Frame 53, on STGR 38 LH, clean and deburr the new fastener holes in the brackets, Item 65 and Item 68, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

16 Between Frame 51 and Frame 53, on STGR 38 LH and on the brackets, Item 65, Item (140), Item (116) and Item 68, wet install:

Refer to Fig. A-GBQAB Sheet 02, View D and Fig. A-GBQAB Sheet 03, View F.

1	Plate-Shear	D5347471500600	Item (137)	Retained at removal

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1	Plate-Shear	D5347471500800	Item (119)	Retained at removal
1	Section-Connecting	D5347065020200	Item (135)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Rivet	EN6069D4-05	Item 545	
30	Rivet	EN6081D5-06	Item 656	
15	Rivet	EN6081D5-07	Item 657	
6	Pin	DAN5-6-6Y	Item 786	
2	Pin	DAN5-6-4Y	Item 784	
4	Pin	DAN6-6-5Y	Item 885	
3	Pin	DAN6-6-6Y	Item 886	
3	Pin	DAN6-6-7Y	Item 887	
18	Collar	DAN11-6Y	Item 809	

17 Between Frame 53 and Frame 54, on STGR 38 LH and on the brackets, Item 80 and Item 82, put in position:

Refer to Fig. A-GBQAB Sheet 03, View F.

1	Plate-Shear	D5347471501000	Item (141)	Retained at removal

18 Transfer drill and ream the six holes from the shear plate, Item (141), to the brackets, Item 80 and Item 82, refer to Fig. A-GBQAB Sheet 03, View F.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAB Sheet 06.

19 Between Frame 53 and Frame 54, on STGR 38 LH, remove:

1	Plate-Shear	D5347471501000	Item (141)	Retain

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20 Between Frame 53 and Frame 54, on STGR 38 LH, clean and deburr the new fastener holes in the brackets, Item 80 and Item 82, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 Between Frame 53 and Frame 54, on STGR 38 LH and on the brackets, Item 80 and Item 82, wet install:

Refer to Fig. A-GBQAB Sheet 03, View F.

1	Plate-Shear	D5347471501000	Item (141)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545
26	Rivet	EN6081D5-06	Item 656

22 Between Frame 54 and Frame 55, on STGR 38 LH and on the brackets, Item 84 and Item (120), wet install:

Refer to Fig. A-GBQAB Sheet 04, View H.

1	Plate Assy-Shear	D5347048800400	Item (122)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

14	Rivet	EN6069D4-05	Item 545
26	Rivet	EN6081D5-06	Item 656

23 Between Frame 56 and Frame 57, on STGR 38 LH and on the brackets, Item (121) and Item (118), wet install:

Refer to Fig. A-GBQAB Sheet 04, View K.

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1	Plate Assy-Shear	D5347048900000	Item (124)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
14	Rivet	EN6069D4-05	Item 545	
26	Rivet	EN6081D5-06	Item 656	

24 Between Frame 58 and Frame 59, on STGR 38 LH and on the brackets, Item (125) and Item (127), wet install:

Refer to Fig. A-GBQAB Sheet 05, View M.

1	Plate-Shear	D5347049200200	Item (126)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
14	Rivet	EN6069D4-05	Item 545	
26	Rivet	EN6081D5-06	Item 656	

25 Between Frame 60 and Frame 61, on STGR 38 LH and on the brackets, Item (128) and Item (130), wet install:

Refer to Fig. A-GBQAB Sheet 05, View P.

1	Plate-Shear	D5347049300000	Item (129)	Retained at removal
1	Section-Connecting	D5347065420400	Item (136)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6069D4-04	Item 544	

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8	Rivet	EN6081D5-05	Item 655	
17	Rivet	EN6081D5-06	Item 656	
4	Pin	DAN5-6-4X	Item 764	
4	Pin	DAN5-6-5X	Item 765	
10	Collar	NSA5075-6	Item 806	
4	Collar	DAN11-6X	Item 807	
3	Pin	DAN6-6-4	Item 864	
7	Pin	DAN6-6-5	Item 865	

26 Between Frame 62 and Frame 63, on STGR 38 LH and on the brackets, Item (131) and Item (115), wet install:

Refer to Fig. A-GBQAB Sheet 06, View R.

1	Plate-Shear	D5347049400000	Item (123)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

7	Rivet	EN6081D5-05	Item 655	
20	Rivet	EN6081D5-06	Item 656	
2	Rivet	EN6069D4-04	Item 544	

(b) Install the corner profiles.

In accordance with SRM 53-41-14.

1 Between Frame 48 thru Frame 63, at STGR 38 LH, install the corner profiles, if removed in accordance with SRM 53-41-14 C2 Identification - Floor Structure - Cargo Compartment.

(c) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(18) Subtask 531364-831-218-002 - Install new Surface Protection on Frame 50 thru Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 from Stringer 31 to Stringer 39
To	160	Work location	from Frame 60 to Frame 63 from Stringer 31 to Stringer 39

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	NON SPECIFIC

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	04JME4	As required	
	Coating - Flexible Structure	04QAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound	12ADB1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12

(a) Clean the working area with:

Non Aqueous Cleaner - General	08BAA9	As required

and

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Textile - Lint Free Cotton	14SBA1	As required

(b) Apply sealant beads around the edges of all new and reinstalled structure parts with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(c) Apply to all sealant beads:

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(d) Apply to all sealant beads:

Top Coat Polyurethane	04JME4	As required

and

Coating - Flexible Structure	04QAB2	As required

(e) Install new water repellent protection on Frame 50 thru Frame 63.

1 Protect the Frame 50 thru Frame 63, STGR 31 LH thru STGR 39 LH and the re-installed shear plates with:

In accordance with SRM 51-23-12.

Corrosion Preventive Compound	12ADB1	As required

****CONF 003**

(1) Subtask 531364-831-201-007 - Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 Stringer 38 LH
To	160	Work location	from Frame 60 to Frame 63 Stringer 38 LH

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

Material necessary to do the job

Consumable CMLD01

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)	53-41-14
Fig. A-GBQAC Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

CAUTION: AIRBUS CONSIDERS IT IS TECHNICALLY ACCEPTABLE TO REWORK EVERY THIRD FRAME AT THE SAME TIME (I.E. LEAVE TWO FRAMES INTACT AND REWORK ONE) TO KEEP THE FUSELAGE STRUCTURE INTEGRITY.

(a) Remove the corner profiles.

In accordance with SRM 53-41-14 C2 Ident.-Floor Structure-Cargo Compartment.

1 Between Frame 48 thru Frame 63, at STGR 38 LH, remove the corner profiles, if necessary in accordance with SRM 53-41-14 C2 Identification - Floor Structure - Cargo Compartment.

(b) Remove the shear plates.

Refer to Fig. A-GBQAC Sheet 01 thru Fig. A-GBQAC Sheet 06.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 Between Frame 49 and Frame 51, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAC Sheet 02, View C.

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1	Plate-Shear	D5347471500200	Item (117)	Retain
1	Plate-Shear	D5347471500000	Item (139)	Retain
	with			
56	Rivet		Item (100)	Discard

2 Between Frame 51 and Frame 53, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAC Sheet 02, View C and Fig. A-GBQAC Sheet 03, View E.

1	Plate-Shear	D5347471500800	Item (119)	Retain
1	Plate-Shear	D5347471500600	Item (137)	Retain
1	Section-Connecting	D5347065020000	Item (135)	Retain
	with			
65	Rivet		Item (100)	Discard

3 Between Frame 53 and Frame 54, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAC Sheet 03, View E.

1	Plate-Shear	D5347471501000	Item (141)	Retain
	with			
28	Rivet		Item (100)	Discard

4 Between Frame 54 and Frame 55, from STGR 38 LH and from the brackets, Item (121) and Item (120), remove:

Refer to Fig. A-GBQAC Sheet 04, View G.

1	Plate Assy-Shear	D5347048800400	Item (122)	Retain
	with			
40	Rivet		Item (100)	Discard

5 Between Frame 56 and Frame 57, from STGR 38 LH and from the brackets, Item (125) and Item (127), remove:

Refer to Fig. A-GBQAC Sheet 04, View J.

1	Plate Assy-Shear	D5347048900000	Item (124)	Retain

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with

40	Rivet		Item (100)	Discard

6 Between Frame 58 and Frame 59, from STGR 38 LH and from the brackets, Item (125) and Item (127), remove:

Refer to Fig. A-GBQAC Sheet 05, View L.

1	Plate-Shear	D5347049200200	Item (126)	Retain

with

40	Rivet		Item (100)	Discard

7 Between Frame 60 and Frame 61, from STGR 38 LH and from the brackets, Item (128) and Item (130), remove:

Refer to Fig. A-GBQAC Sheet 05, View N.

1	Plate-Shear	D5347049300000	Item (129)	Retain
1	Section-Connecting	D5347065420400	Item (136)	Retain

with

45	Rivet		Item (100)	Discard

8 Between Frame 62 and Frame 63, from STGR 38 LH and from the brackets, Item (131) and Item (115), remove:

Refer to Fig. A-GBQAC Sheet 06, View Q.

1	Plate-Shear	D5347049400000	Item (123)	Retain

with

29	Rivet		Item (100)	Discard

(c) Clean the contact surfaces and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

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(2) Subtask 531364-831-202-003 - Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 from Stringer 33 LH to Stringer 34 LH from Stringer 36 LH to Stringer 37 LH
To	160	Work location	from Frame 60 to Frame 62 from Stringer 32 LH to Stringer 33 LH from Stringer 36 LH to Stringer 37 LH Frame 63 from Stringer 31 LH to Stringer 32 LH from Stringer 36 LH to Stringer 37 LH

Manpower Resources	
Manhours	5.00
Minimum number of person	1
Subtask elapsed time	5.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

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 Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane	04JME4	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

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NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00
Fig. A-GBRAA Cold Expansion of Holes in Frame 50 thru Frame 63	Sheet 01 Sheet 02 Sheet 03

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

(a) Inspect the holes for cracks from Frame 50 thru Frame 55 and from Frame 57 thru Frame 59.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 33 LH and STGR 34 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(b) Cold expand the holes from Frame 50 thru Frame 55 and from Frame 57 thru Frame 59.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

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1 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 33 LH and STGR 34 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 02, View C.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

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(c) Inspect the holes for cracks at Frame 56.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 At Frame 56, between STGR 33 LH and STGR 34 LH and between STGR 35 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(d) Cold expand the holes at Frame 56.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 At Frame 56, between STGR 33 LH and STGR 34 LH and between STGR 35 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 02, View D.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

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2 Clean the area of the expanded holes with:

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

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(e) Inspect the holes for cracks from Frame 60 thru Frame 62.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

1 From Frame 60 thru Frame 62, between STGR 32 LH and STGR 33 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(f) Cold expand the holes from Frame 60 thru Frame 62.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

1 From Frame 60 thru Frame 62, between STGR 32 LH and STGR 33 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 03, View E.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(g) Inspect the holes for cracks at Frame 63.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

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1 At Frame 63, between STGR 31 LH and STGR 32 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frame, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(h) Cold expand the holes at Frame 63.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

1 At Frame 63, between STGR 31 LH and STGR 32 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frame. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 03, View F.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

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and

Textile - Lint Free Cotton	14SBA1	As required

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(3) Subtask 531364-831-203-007 - Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 50 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D03R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
4	E5347001024400	1	WEB	
65	E5347001420200	1	ANGLE	
66	E5347001420000	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	2	RIVET	
567	EN6069D6-07	11	RIVET	
656	EN6081D5-06	8	RIVET	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
668	EN6081D6-08	11	RIVET	(1)
764	DAN5-6-4X	14	PIN	
765	DAN5-6-5X	13	PIN	
766	DAN5-6-6X	6	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	2	PIN	
785	DAN5-6-5Y	3	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	6	COLLAR	
807	DAN11-6X	37	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	6	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

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NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBAAB Replacement of Webs and Angles at Frame 50	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBAAB Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 50, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
17	Rivet		Item (100)	Discard

2 From the top flange of Frame 50, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

8	Rivet		Item (100)	Discard

3 From Frame 50, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347073420000	Item (1)	Discard
	with			

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18	Rivet		Item (100)	Discard

4 From Frame 50, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072820000	Item (2)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347470120200	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard
1	Angle-Support	D5347068120000	Item (102)	Retain
	with			
66	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 50.

Refer to NTM 51-10-01.

Refer to Fig. A-GBAAB Sheet 02, Views C and D.

1 On Frame 50, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374 refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 50, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

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3 On the top flange of Frame 50, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 485, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBAAB Sheet 02 thru Fig. A-GBAAB Sheet 04.

1 On Frame 50, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBAAB Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 50 to the shear web, Item 4.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAB Sheet 04.

4 Transfer drill the tack hole from the Frame 50 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

5 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBAAB Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBAAB Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAB Sheet 04.

6 On Frame 50, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

7 Clean and deburr the new fastener holes in Frame 50 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBAAB Sheet 02, Views C and D.

a On Frame 50, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBAAB Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

b On Frame 50, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAB Sheet 02, View C.

c On Frame 50, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAB Sheet 02, View C.

d On Frame 50, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAB Sheet 02, View C.

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e On the top flange of Frame 50, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 485. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAB Sheet 02, View D.

9 On Frame 50, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

10 Clean and deburr the cold expansion fastener holes in Frame 50 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 50, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBAAB Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

with

3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374

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1	Bolt	EN6115K3A5	Item 375
11	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
11	Rivet	EN6081D6-08	Item 668
14	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-5X	Item 765
3	Pin	DAN5-6-5Y	Item 785
24	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809
5	Nut	ASNA2528-3A	Item 908

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 On the flange of Frame 50, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBAAB Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

13 On the Frame 50 flange, at STGR 35 LH, refer to Fig. A-GBAAB Sheet 03, Section C-C, countersink the one fastener hole.

14 On the Frame 50 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBAAB Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 50 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBAAB Sheet 02, View C and Fig. A-GBAAB Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1. refer to Fig. A-GBAAB Sheet 02, View C and Fig. A-GBAAB Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAB Sheet 04.

17 On the Frame 50 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 50, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 50 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBAAB Sheet 02, View C and Fig. A-GBAAB Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

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20 On the Frame 50 flange, at STGR 36 LH, refer to Fig. A-GBAAB Sheet 03, Section D-D, countersink the one fastener hole.

21 On the Frame 50 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBAAB Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 50 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBAAB Sheet 02, View C and Fig. A-GBAAB Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBAAB Sheet 02, View C and Fig. A-GBAAB Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAB Sheet 04.

24 On the Frame 50 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

25 Clean and deburr the new fastener holes in the Frame 50, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 50 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBAAB Sheet 02, View C and Fig. A-GBAAB Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

Close the rivet hole in STGR 36 LH with:

27 On the Frame 50 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBAAB Sheet 02, View C and Fig. A-GBAAB Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Pin	DAN5-6-6X	Item 766	
2	Pin	DAN5-6-7X	Item 767	
6	Collar	NSA5075-6	Item 806	
6	Collar	DAN11-6X	Item 807	
6	Pin	DAN5-6-3	Item 963	

28 On the Frame 50 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBAAB Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

29 Transfer drill and ream the three holes from the Frame to the angles, Item 65 and Item 66, refer to Fig. A-GBAAB Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAB Sheet 04.

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30 On the Frame 50 flange, at STGR 38 LH, remove:

1	Angle	E5347001420200	Item 65	
1	Angle	E5347001420000	Item 66	

31 Clean and deburr the new fastener holes in the Frame 50 and angles, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

32 On the Frame 50 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBAAB Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-8X	Item 768
1	Pin	DAN5-6-6Y	Item 786
2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

33 On the Frame 50 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBAAB Sheet 02, View C and Fig. A-GBAAB Sheet 03, Section F-F.

1	Angle-Support	D5347068120000	Item (102)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-07	Item 657
2	Pin	DAN5-6-6X	Item 766
2	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(4) Subtask 531364-831-204-016 - Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 51 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D03R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
2	E5347001120200	1	ANGLE	
4	E5347001024400	1	WEB	
65	E5347001420200	1	ANGLE	
66	E5347001420000	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	2	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	4	RIVET	(2)
764	DAN5-6-4X	14	PIN	
765	DAN5-6-5X	13	PIN	
766	DAN5-6-6X	6	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	2	PIN	
785	DAN5-6-5Y	3	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	37	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

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Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

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NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBBAB Replacement of Webs and Angles at Frame 51	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBBAB Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 51, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
17	Rivet		Item (100)	Discard

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2 From the top flange of Frame 51, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

8	Rivet		Item (100)	Discard

3 From Frame 51, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347073420000	Item (1)	Discard
	with			
18	Rivet		Item (100)	Discard

4 From Frame 51, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072820000	Item (2)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle-Support	D5347068120000	Item (102)	Retain
1	Angle	D5347470120200	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard
	with			
66	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 51.

Refer to NTM 51-10-01.

Refer to Fig. A-GBBAB Sheet 02, View C.

1 On Frame 51, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

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2 On Frame 51, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBBAB Sheet 02 thru Fig. A-GBBAB Sheet 04.

1 On Frame 51, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBBAB Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 51 to the shear web, Item 4.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAB Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBBAB Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBBAB Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAB Sheet 04.

5 Transfer drill the tack hole from the Frame 51 between STGR 36 LH and 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 51, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

7 Clean and deburr the new fastener holes in Frame 51 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBBAB Sheet 02, Views C and D.

a On Frame 51, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBBAB Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

b On Frame 51, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAB Sheet 02, View C.

c On Frame 51, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAB Sheet 02, View C.

d On Frame 51, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAB Sheet 02, View C.

9 On Frame 51, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

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10 Clean and deburr the cold expansion fastener holes in Frame 51 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 51, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBBAB Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

with

3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
19	Rivet	EN6081D6-08	Item 668
4	Rivet	EN6081D6-09	Item 669
14	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-5X	Item 765
3	Pin	DAN5-6-5Y	Item 785
24	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809
5	Nut	ASNA2528-3A	Item 908

use

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 51, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBBAB Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

13 On the Frame 51 flange, at STGR 35 LH, refer to Fig. A-GBBAB Sheet 03, Section C-C, countersink the one fastener hole.

14 On the Frame 51 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBBAB Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 51 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBBAB Sheet 02, View C and Fig. A-GBBAB Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBBAB Sheet 02, View C and Fig. A-GBBAB Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAB Sheet 04.

17 On the Frame 51 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 51, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 51 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBBAB Sheet 02, View C and Fig. A-GBBAB Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

20 On the Frame 51 flange, at STGR 36 LH, refer to Fig. A-GBBAB Sheet 03, Section D-D, countersink the one fastener hole.

21 On the Frame 51 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBBAB Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 51 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBBAB Sheet 02, View C and Fig. A-GBBAB Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBBAB Sheet 02, View C and Fig. A-GBBAB Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAB

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Sheet 04.

24 On the Frame 51 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2	

25 Clean and deburr the new fastener holes in the Frame 51, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required	

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required	

26 On the Frame 51 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBBAB Sheet 02, View C and Fig. A-GBBAB Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

27 On the Frame 51 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBBAB Sheet 02, View C and Fig. A-GBBAB Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

4	Pin	DAN5-6-6X	Item 766	
2	Pin	DAN5-6-7X	Item 767	

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4	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
4	Pin	DAN5-6-3	Item 963

28 On the Frame 51 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBBAB Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

29 Transfer drill and ream the three holes from the Frame to the angles, Item 65 and Item 66, refer to Fig. A-GBBAB Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAB Sheet 04.

30 On the Frame 51 flange, at STGR 38 LH, remove:

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

31 Clean and deburr the new fastener holes in the Frame 51 and angles, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

32 On the Frame 51 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBBAB Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

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2	Pin	DAN5-6-8X	Item 768	
1	Pin	DAN5-6-6Y	Item 786	
2	Collar	DAN11-6X	Item 807	
1	Collar	DAN11-6Y	Item 809	

33 On the Frame 51 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBBAB Sheet 02, View C and Fig. A-GBBAB Sheet 03, Section F-F.

1	Angle-Support	D5347068120000	Item (102)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657	
2	Pin	DAN5-6-6X	Item 766	
2	Collar	DAN11-6X	Item 807	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

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(5) Subtask 531364-831-205-007 - Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 52 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D03R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
6	E5347001024600	1	WEB	
65	E5347001420200	1	ANGLE	
67	E5347001421200	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	2	RIVET	
567	EN6069D6-07	6	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	4	RIVET	
667	EN6081D6-07	22	RIVET	
668	EN6081D6-08	14	RIVET	(1)
764	DAN5-6-4X	16	PIN	
765	DAN5-6-5X	13	PIN	
766	DAN5-6-6X	10	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	2	PIN	
785	DAN5-6-5Y	3	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	12	COLLAR	
807	DAN11-6X	48	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
865	DAN6-6-5	4	PIN	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
866	DAN6-6-6	6	PIN	
873	DAN6-6-3X	5	PIN	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	1	PIN	
964	DAN5-6-4	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01

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References	
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBCAC Replacement of Webs and Angles at Frame 52	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBCAC Sheet 01, View B and Sections A-A and B-B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 52, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920200	Item (3)	Discard
	with			
18	Rivet		Item (100)	Discard

2 From the flange of Frame 52, between STGR 35 LH and STGR 36 LH, remove:

6	Rivet		Item (100)	Discard

3 From Frame 52, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
18	Rivet		Item (100)	Discard

4 From Frame 52, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347077420000	Item (5)	Discard
1	Support	D5347032200400	Item (103)	Retain
1	Angle	D5347470120200	Item (116)	Discard
1	Section-Connecting	D5347065020200	Item (135)	Retain

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1	Angle	D5347470120000	Item (140)	Discard
1	Shim	D5347044920000	Item (142)	Retain
1	Shim	D5347044920600	Item (143)	Retain
	with			
77	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 52.

Refer to NTM 51-10-01.

Refer to Fig. A-GBCAC Sheet 02, View C.

1 On Frame 52, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 52, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBCAC Sheet 02 thru Fig. A-GBCAC Sheet 04.

1 On Frame 52, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBCAC Sheet 02, View C.

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1 Shear Web E5347001024600 Item 6

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 52 to the shear web, Item 6.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAC Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBCAC Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBCAC Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAC Sheet 04.

5 Transfer drill the tack hole from the Frame 52 between STGR 36 LH and 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 52, between STGR 34 LH and STGR 39 LH, remove:

1 Shear Web E5347001024600 Item 6

7 Clean and deburr the new fastener holes in Frame 52 and the shear web, Item 6, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBCAC Sheet 02, View C.

a On Frame 52, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBCAC Sheet 02, View C.

1 Shear Web E5347001024600 Item 6

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b On Frame 52, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAC Sheet 02, View C.

c On Frame 52, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAC Sheet 02, View C.

d On Frame 52, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAC Sheet 02, View C.

9 On Frame 52, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024600	Item 6

10 Clean and deburr the cold expansion fastener holes in Frame 52 and the shear web, Item 6, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 52, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBCAC Sheet 02, View C.

1	Shear Web	E5347001024600	Item 6

with

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3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
6	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D6-07	Item 667
14	Rivet	EN6081D6-08	Item 668
15	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-5X	Item 765
3	Pin	DAN5-6-5Y	Item 785
1	Collar	NSA5075-6	Item 806
30	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809
5	Pin	DAN6-6-3X	Item 873
5	Nut	ASNA2528-3A	Item 908
1	Pin	DAN5-6-3	Item 963

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 52, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBCAC Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

13 On the Frame 52 flange, at STGR 35 LH, refer to Fig. A-GBCAC Sheet 03, Section D-D, countersink the one fastener hole.

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14 On the Frame 52 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBCAC Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 52 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBCAC Sheet 02, View C and Fig. A-GBCAC Sheet 03, Section D-D.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBCAC Sheet 02, View C and Fig. A-GBCAC Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAC Sheet 04.

17 On the Frame 52 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 52, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 52 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBCAC Sheet 02, View C and Fig. A-GBCAC Sheet 03, Section D-D.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

20 On the Frame 52 flange, at STGR 36 LH, refer to Fig. A-GBCAC Sheet 03, Section E-E, countersink the one fastener hole.

21 On the Frame 52 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBCAC Sheet 03, Section E-E.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 52 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBCAC Sheet 02, View C and Fig. A-GBCAC Sheet 03, Section E-E.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole in STGR 36 LH and the three holes in the Frame to the angle, Item 2, refer to Fig. A-GBCAC Sheet 02, View C and Fig. A-GBCAC Sheet 03, Section E-E.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAC Sheet 04.

24 On the Frame 52 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

25 Clean and deburr the new fastener holes in the Frame 52, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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26 On the Frame 52 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBCAC Sheet 02, View C and Fig. A-GBCAC Sheet 03, Section E-E.

1	Angle	E5347001120200	Item 2	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-4	Item 964	
1	Collar	NSA5075-6	Item 806	

27 On the Frame 52 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBCAC Sheet 02, View C and Fig. A-GBCAC Sheet 03, Section F-F.

1	Support	D5347032200400	Item (103)	Retained at removal
1	Section-Connecting	D5347065020200	Item (135)	Retained at removal
1	Shim	D5347044920000	Item (142)	Retained at removal
1	Shim	D5347044920600	Item (143)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
1	Pin	DAN5-6-4X	Item 764	
10	Pin	DAN5-6-6X	Item 766	
2	Pin	DAN5-6-7X	Item 767	

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10	Collar	NSA5075-6	Item 806
13	Collar	DAN11-6X	Item 807
4	Pin	DAN6-6-5	Item 865
6	Pin	DAN6-6-6	Item 866

28 On the Frame 52 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBCAC Sheet 02, View C and Section C-C.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001421200	Item 67

29 Transfer drill and ream the three holes in the Frame to the angles, Item 65 and Item 67, refer to Fig. A-GBCAC Sheet 02, View C and Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAC Sheet 04.

30 On the Frame 52 flange, at STGR 38 LH, remove:

1	Angle	E5347001420200	Item 65
1	Angle	E5347001421200	Item 67

31 Clean and deburr the new fastener holes in the Frame 52 and angles, Item 65 and Item 67, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

32 On the Frame 52 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBCAC Sheet 02, View C and Section C-C.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001421200	Item 67

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Pin	DAN5-6-8X	Item 768
1	Pin	DAN5-6-6Y	Item 786
2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(6) Subtask 531364-831-206-007 - Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 53 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D03R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
8	E5347001027400	1	WEB	
68	E5347001421400	1	ANGLE	
80	E5347001421600	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	2	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	5	RIVET	
667	EN6081D6-07	22	RIVET	
764	DAN5-6-4X	15	PIN	
765	DAN5-6-5X	17	PIN	
766	DAN5-6-6X	2	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	2	PIN	
784	DAN5-6-4Y	2	PIN	
785	DAN5-6-5Y	2	PIN	
806	NSA5075-6	6	COLLAR	
807	DAN11-6X	48	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
873	DAN6-6-3X	10	PIN	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	1	PIN	

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBDAC Replacement of Webs and Angles at Frame 53	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBDAC Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 53, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
17	Rivet		Item (100)	Discard

2 From the flange of Frame 53, between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 53, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
18	Rivet		Item (100)	Discard

4 From Frame 53, between STGR 36 LH and STGR 39 LH, remove:

1	Shear web	D5347078320000	Item (6)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347470120200	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard
1	Angle-Support	D5347068120000	Item (102)	Retain
	with			
68	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

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Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 53.

Refer to NTM 51-10-01.

Refer to Fig. A-GBDAC Sheet 02, View C.

1 On Frame 53, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 53, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBDAC Sheet 02 thru Fig. A-GBDAC Sheet 04.

1 On Frame 53, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBDAC Sheet 02, View C.

1	Shear Web	E5347001027400	Item 8

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 53 to the shear web, Item 8.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAC Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBDAC Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBDAC Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAC Sheet 04.

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5 Transfer drill the tack hole from the Frame 53 between STGR 36 LH and 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 53, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001027400	Item 8

7 Clean and deburr the new fastener holes in Frame 53 and the shear web, Item 8, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBDAC Sheet 02, Views C and D.

a On Frame 53, between STGR 34 LH and STGR 39 LH, put in position:

1	Shear Web	E5347001027400	Item 8

b On Frame 53, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold

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expansion, refer to Fig. A-GBDAC Sheet 02, View C.

c On Frame 53, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAC Sheet 02, View C.

d On Frame 53, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAC Sheet 02, View C.

9 On Frame 53, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001027400	Item 8

10 Clean and deburr the new fastener holes in Frame 53 and the shear web, Item 8, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 53, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBDAC Sheet 02, View C.

1	Shear Web	E5347001027400	Item 8

with

3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D6-07	Item 667
15	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-5X	Item 765
2	Pin	DAN5-6-4Y	Item 784
1	Pin	DAN5-6-5Y	Item 785
1	Collar	NSA5075-6	Item 806
35	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808

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3	Collar	DAN11-6Y	Item 809
10	Pin	DAN6-6-3X	Item 873
5	Nut	ASNA2528-3A	Item 908
1	Pin	DAN5-6-3	Item 963

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 53, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBDAC Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

13 On the Frame 53 flange, at STGR 35 LH, refer to Fig. A-GBDAC Sheet 03, Section C-C, countersink the one fastener hole.

14 On the Frame 53 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBDAC Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 53 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBDAC Sheet 02, View C and Fig. A-GBDAC Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBDAC Sheet 02, View C and Fig. A-GBDAC Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAC Sheet 04.

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17 On the Frame 53 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 53, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 53 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBDAC Sheet 02, View C and Fig. A-GBDAC Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

20 On the Frame 53 flange, at STGR 36 LH, refer to Fig. A-GBDAC Sheet 03, Section D-D, countersink the one fastener hole.

21 On the Frame 53 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBDAC Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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22 On the Frame 53 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBDAC Sheet 02, View C and Fig. A-GBDAC Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBDAC Sheet 02, View C and Fig. A-GBDAC Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAC Sheet 04.

24 On the Frame 53 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

25 Clean and deburr the new fastener holes in the Frame 53, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 53 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBDAC Sheet 02, View C and Fig. A-GBDAC Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

1	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-4	Item 964
1	Collar	NSA5075-6	Item 806

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27 On the Frame 53 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBDAC Sheet 02, View C and Fig. A-GBDAC Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Pin	DAN5-6-5X	Item 765
2	Pin	DAN5-6-7X	Item 767
6	Collar	DAN11-6X	Item 807
4	Collar	NSA5075-6	Item 806
4	Pin	DAN5-6-3	Item 963

28 On the Frame 53 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBDAC Sheet 02, View C and Section B-B.

1	Angle	E5347001421400	Item 68
1	Angle	E5347001421600	Item 80

29 Transfer drill and ream the three holes from the Frame to the angles, Item 68 and Item 80, refer to Fig. A-GBDAC Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAC Sheet 04.

30 On the Frame 53 flange, at STGR 38 LH, remove:

1	Angle	E5347001421400	Item 68
1	Angle	E5347001421600	Item 80

31 Clean and deburr the new fastener holes in the Frame 53 and angles, Item 68 and Item 80, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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	Non Aqueous Cleaner - General	08BAA9	As required	

32 On the Frame 53 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBDAC Sheet 02, View C and Section B-B.

1	Angle	E5347001421400	Item 68	
1	Angle	E5347001421600	Item 80	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-8X	Item 768	
1	Pin	DAN5-6-5Y	Item 785	
1	Collar	DAN11-6Y	Item 809	
2	Collar	DAN11-6X	Item 807	

33 On the Frame 53 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBDAC Sheet 02, View C and Fig. A-GBDAC Sheet 03, Section F-F.

1	Angle-Support	D5347068120000	Item (102)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
2	Pin	DAN5-6-6X	Item 766	
2	Collar	DAN11-6X	Item 807	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(7) Subtask 531364-831-207-007 - Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 54 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D03R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
10	E5347001025000	1	WEB	
82	E5347001421800	1	ANGLE	
84	E5347001422000	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	2	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
764	DAN5-6-4X	15	PIN	
765	DAN5-6-5X	13	PIN	
766	DAN5-6-6X	6	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	2	PIN	
784	DAN5-6-4Y	2	PIN	
785	DAN5-6-5Y	2	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	48	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
873	DAN6-6-3X	10	PIN	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	4	PIN	

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

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NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBEAC Replacement of Webs and Angles at Frame 54	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBEAC Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 54, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
17	Rivet		Item (100)	Discard

2 From the flange of Frame 54, between STGR 35 LH and STGR 36 LH, remove:

3	Rivet		Item (100)	Discard

3 From Frame 54, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020000	Item (4)	Discard
	with			
18	Rivet		Item (100)	Discard

4 From Frame 54, between STGR 36 LH and STGR 39 LH, remove:

1	Web-shear	D5347078520000	Item (7)	Discard
1	Support	D5347032200000	Item (101)	Retain

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1	Angle	D5347046820600	Item (121)	Discard
1	Angle	D5347470120000	Item (140)	Discard
1	Angle-Support	D5347068120000	Item (102)	Retain
	with			
68	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 54.

Refer to NTM 51-10-01.

Refer to Fig. A-GBEAC Sheet 02, View C.

1 On Frame 54, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 54, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBEAC Sheet 02 thru Fig. A-GBEAC Sheet 04.

1 On Frame 54, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBEAC Sheet 02, View C.

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1 Shear Web E5347001025000 Item 10

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 54 to the shear web, Item 10.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAC Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBEAC Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBEAC Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAC Sheet 04.

5 Transfer drill the tack hole from the Frame 54 between STGR 36 LH and 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 54, between STGR 34 LH and STGR 39 LH, remove:

1 Shear Web E5347001025000 Item 10

7 Clean and deburr the new fastener holes in Frame 54 and the shear web, Item 10, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBEAC Sheet 02, View C.

a On Frame 54, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBEAC Sheet 02, View C.

1 Shear Web E5347001025000 Item 10

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b On Frame 54, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAC Sheet 02, View C.

c On Frame 54, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAC Sheet 02, View C.

9 On Frame 54, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025000	Item 10

10 Clean and deburr the cold expansion fastener holes in Frame 54 and the shear web, Item 10, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 54, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBEAC Sheet 02, View C.

1	Shear Web	E5347001025000	Item 10

with

3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
15	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-5X	Item 765
2	Pin	DAN5-6-4Y	Item 784
1	Pin	DAN5-6-5Y	Item 785
35	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809

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10	Pin	DAN6-6-3X	Item 873
5	Nut	ASNA2528-3A	Item 908

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 54, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBEAC Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

13 On the Frame 54 flange, at STGR 35 LH, refer to Fig. A-GBEAC Sheet 03, Section C-C, countersink the one fastener hole.

14 On the Frame 54 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBEAC Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 54 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBEAC Sheet 02, View C and Fig. A-GBEAC Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBEAC Sheet 02, View C and Fig. A-GBEAC Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAC Sheet 04.

17 On the Frame 54 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

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18 Clean and deburr the new fastener holes in the Frame 54, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 54 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBEAC Sheet 02, View C and Fig. A-GBEAC Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

20 On the Frame 54 flange, at STGR 36 LH, refer to Fig. A-GBEAC Sheet 03, Section D-D, countersink the one fastener hole.

21 On the Frame 54 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBEAC Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 54 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBEAC Sheet 02, View C and Fig. A-GBEAC Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

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23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBEAC Sheet 02, View C and Fig. A-GBEAC Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAC Sheet 04.

24 On the Frame 54 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

25 Clean and deburr the new fastener holes in the Frame 54, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 54 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBEAC Sheet 02, View C and Fig. A-GBEAC Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Rivet	EN6081D6-07	Item 667

27 On the Frame 54 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBEAC Sheet 02, View C and Fig. A-GBEAC Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

4	Pin	DAN5-6-6X	Item 766
2	Pin	DAN5-6-7X	Item 767
6	Collar	DAN11-6X	Item 807
4	Collar	NSA5075-6	Item 806
4	Pin	DAN5-6-3	Item 963

28 On the Frame 54 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBEAC Sheet 02, View C and Section B-B.

1	Angle	E5347001421800	Item 82
1	Angle	E5347001422000	Item 84

29 Transfer drill and ream the three holes from the Frame to the angles, Item 82 and Item 84, refer to Fig. A-GBEAC Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAC Sheet 04.

30 On the Frame 54 flange, at STGR 38 LH, remove:

1	Angle	E5347001421800	Item 82
1	Angle	E5347001422000	Item 84

31 Clean and deburr the new fastener holes in the Frame 54 and angles, Item 82 and Item 84, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

32 On the Frame 54 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBEAC Sheet 02, View C and Section B-B.

1	Angle	E5347001421800	Item 82
1	Angle	E5347001422000	Item 84

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-8X	Item 768	
1	Pin	DAN5-6-5Y	Item 785	
2	Collar	DAN11-6X	Item 807	
1	Collar	DAN11-6Y	Item 809	

33 On the Frame 54 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBEAC Sheet 02, View C and Fig. A-GBEAC Sheet 03, Section F-F.

1	Angle-Support	D5347068120000	Item (102)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-6X	Item 766	
2	Collar	DAN11-6X	Item 807	
2	Rivet	EN6081D5-07	Item 657	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

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Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(8) Subtask 531364-831-208-007 - Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 55 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D03R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
12	E5347001020800	1	WEB	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	2	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	6	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	16	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	10	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	12	PIN	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01

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References	
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBFAB Replacement of Webs and Angles at Frame 55	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBFAB Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 55, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 55, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

10	Rivet		Item (100)	Discard

3 From Frame 55, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 55, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072120000	Item (8)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046823800	Item (120)	Retain
1	Angle-Support	D5347068120000	Item (102)	Retain
	with			

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56	Rivet	Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 55.

Refer to NTM 51-10-01.

Refer to Fig. A-GBFAB Sheet 02, Views C, D and F.

1 On Frame 55, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 55, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 55, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBFAB Sheet 02 thru Fig. A-GBFAB Sheet 04.

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1 On Frame 55, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBFAB Sheet 02, View C.

1	Shear Web	E5347001020800	Item 12

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 55 to the shear web, Item 12.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAB Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBFAB Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBFAB Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAB Sheet 04.

5 Transfer drill the tack hole from the Frame 55 between STGR 36 LH and 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 55, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001020800	Item 12

7 Clean and deburr the new fastener holes in Frame 55 and the shear web, Item 12, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBFAB Sheet 02, Views C, D and F.

a On Frame 55, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBFAB Sheet 02, View C.

1	Shear Web	E5347001020800	Item 12

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b On Frame 55, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAB Sheet 02, View C.

c On Frame 55, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAB Sheet 02, View C.

d On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAB Sheet 02, View D.

e On the top flange of Frame 55, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAB Sheet 02, View F.

9 On Frame 55, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001020800	Item 12

10 Clean and deburr the cold expansion fastener holes in Frame 55 and the shear web, Item 12, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 55, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBFAB Sheet 02, View C.

1	Shear Web	E5347001020800	Item 12

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
6	Rivet	EN6081D6-06	Item 666
17	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
10	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863

use

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 55, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBFAB Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBFAB Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

14 On the Frame 55 flange, at STGR 35 LH, refer to Fig. A-GBFAB Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 55 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBFAB Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 55 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBFAB Sheet 02, View C and Fig. A-GBFAB Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

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17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBFAB Sheet 02, View C and Fig. A-GBFAB Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAB Sheet 04.

18 On the Frame 55 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 55, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 55 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBFAB Sheet 02, View C and Fig. A-GBFAB Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

21 On the Frame 55 flange, at STGR 36 LH, refer to Fig. A-GBFAB Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 55 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBFAB Sheet 03, Section B-B.

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1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 55 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBFAB Sheet 02, View C and Fig. A-GBFAB Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBFAB Sheet 02, View C and Fig. A-GBFAB Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAB Sheet 04.

25 On the Frame 55 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener hole in the Frame 55, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 55 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBFAB Sheet 02, View C and Fig. A-GBFAB Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657

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3	Rivet	EN6081D6-07	Item 667	

28 On the Frame 55 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBFAB Sheet 02, View C and Fig. A-GBFAB Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

6	Rivet	EN6081D6-09	Item 669
4	Collar	NSA5075-6	Item 806
4	Pin	DAN5-6-3	Item 963

29 On the Frame 55 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBFAB Sheet 02, View C.

1	Angle	D5347046823800	Item (120)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

1	Pin	DAN5-6-5Y	Item 785
2	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6Y	Item 809
2	Collar	DAN11-6X	Item 807

30 On the Frame 55 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBFAB Sheet 02, View C and Fig. A-GBFAB Sheet 03, Section D-D.

1	Angle-Support	D5347068120000	Item (102)	Retained at removal

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-08	Item 668
2	Rivet	EN6081D5-07	Item 657

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(9) Subtask 531364-831-209-007 - Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 56 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D03R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
14	E5347001021000	1	WEB	
16	E5347001120400	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
567	EN6069D6-07	10	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	9	RIVET	
668	EN6081D6-08	24	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	2	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	22	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	9	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	15	PIN	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	2	PIN	
965	DAN5-6-5	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	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	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

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NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBGAB Replacement of Webs and Angles at Frame 56	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBGAB Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

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1 From Frame 56, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347078720000	Item (9)	Discard
	with			
15	Rivet		Item (100)	Discard

2 From the flange of Frame 56, between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 56, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347078820000	Item (10)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 56, between STGR 36 LH and STGR 39 LH, remove:

1	Shear web	D5347078620000	Item (11)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046820600	Item (121)	Retain
1	Support	D5347068520100	Item (134)	Retain
1	Angle-Support	D5347068120000	Item (102)	Retain
	with			
64	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 56.

Refer to NTM 51-10-01.

Refer to Fig. A-GBGAB Sheet 02, Views C and D.

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1 On Frame 56, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 56, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 56, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBGAB Sheet 02 thru Fig. A-GBGAB Sheet 04.

1 On Frame 56, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBGAB Sheet 02, View C.

1	Shear Web	E5347001021000	Item 14

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 56 to the shear web, Item 14.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAB Sheet 04.

4 Drill the additional 6 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBGAB Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBGAB Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAB Sheet 04.

5 Transfer drill the tack hole from the Frame 56 between STGR 36 LH and 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

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6 On Frame 56, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021000	Item 14

7 Clean and deburr the new fastener holes in Frame 56 and the shear web, Item 14, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBGAB Sheet 02, Views C, D and F.

a On Frame 56, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBGAB Sheet 02, View C.

1	Shear Web	E5347001021000	Item 14

b On Frame 56, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAB Sheet 02, View C.

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c On Frame 56, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAB Sheet 02, View C.

d On the top flange of Frame 56, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAB Sheet 02, View E.

9 On Frame 56, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021000	Item 14

10 Clean and deburr the cold expansion fastener holes in Frame 56 and the shear web, Item 14, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 56, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBGAB Sheet 02, View C.

1	Shear Web	E5347001021000	Item 14

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
10	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
9	Rivet	EN6081D6-06	Item 666
19	Rivet	EN6081D6-08	Item 668
7	Pin	DAN5-6-4X	Item 764
17	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
15	Pin	DAN6-6-3	Item 863
2	Pin	DAN5-6-4	Item 964

use

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 56, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBGAB Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the Frame 56 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBGAB Sheet 02, View C and Fig. A-GBGAB Sheet 03, Section A-A.

1	Angle	E5347001120400	Item 16

14 Transfer drill and ream the holes from the Frame 56 and from STGR 35 LH to the angle, Item 16, refer to Fig. A-GBGAB Sheet 02, View C and Fig. A-GBGAB Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAB Sheet 04.

15 On the Frame 56 flange, at STGR 35 LH, remove:

1	Angle	E5347001120400	Item 16

16 Clean and deburr the new fastener holes in the Frame 56, STGR 35 LH and angle, Item 16, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

17 On the Frame 56 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBGAB Sheet 02, View C and Fig. A-GBGAB Sheet 03, Section A-A.

1	Angle	E5347001120400	Item 16

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656	
2	Rivet	EN6081D6-09	Item 669	
1	Pin	DAN5-6-5	Item 965	
1	Collar	NSA5075-6	Item 806	

18 On the Frame 56 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBGAB Sheet 02, View C and Fig. A-GBGAB Sheet 03, Section A-A.

1	Support	D5347068520100	Item (134)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

3	Rivet	EN6081D6-08	Item 668	
2	Rivet	EN6081D5-06	Item 656	

19 On the Frame 56 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBGAB Sheet 02, View C and Fig. A-GBGAB Sheet 03, Section B-B.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

20 On the aft side of the Frame 56 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBGAB Sheet 02, View C.

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1	Angle	D5347046820600	Item (121)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-5X	Item 765	
2	Collar	DAN11-6X	Item 807	
1	Pin	DAN5-6-5Y	Item 785	
1	Collar	DAN11-6Y	Item 809	

21 On the Frame 56 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBGAB Sheet 02, View C and Fig. A-GBGAB Sheet 03, Section C-C.

1	Angle-Support	D5347068120000	Item (102)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-08	Item 668	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		

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Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(10) Subtask 531364-831-210-007 - Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 57 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D03R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
18	E5347001021200	1	WEB	
20	E5347001123800	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	1	RIVET	
668	EN6081D6-08	17	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	19	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	10	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	11	PIN	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01

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References	
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBHAB Replacement of Webs and Angles at Frame 57	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBHAB Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 57, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347081820000	Item (12)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 57, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

8	Rivet		Item (100)	Discard

3 From Frame 57, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347081720000	Item (13)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 57, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347081620000	Item (14)	Discard
1	Angle-Support	D5347068120000	Item (102)	Retain
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046820200	Item (118)	Retain
	with			

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57	Rivet	Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 57.

Refer to NTM 51-10-01.

Refer to Fig. A-GBHAB Sheet 02, Views C, D and F.

1 On Frame 57, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 57, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 57, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBHAB Sheet 02 thru Fig. A-GBHAB Sheet 04.

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1 On Frame 57, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBHAB Sheet 02, View C.

1	Shear Web	E5347001021200	Item 18

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 57 to the shear web, Item 18.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAB Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBHAB Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBHAB Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAB Sheet 04.

5 Transfer drill the tack hole from the Frame 57 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 57, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021200	Item 18

7 Clean and deburr the new fastener holes in Frame 57 and the shear web, Item 18, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBHAB Sheet 02, Views C, D and F.

a On Frame 57, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBHAB Sheet 02, View C.

1	Shear Web	E5347001021200	Item 18

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b On Frame 57, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAB Sheet 02, View C.

c On Frame 57, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAB Sheet 02, View C.

d On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAB Sheet 02, View D.

e On the top flange of Frame 57, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAB Sheet 02, View F.

9 On Frame 57, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021200	Item 18

10 Clean and deburr the cold expansion fastener holes in Frame 57 and the shear web, Item 18, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 57, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBHAB Sheet 02, View C.

1	Shear Web	E5347001021200	Item 18

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
13	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863
1	Pin	DAN5-6-3	Item 963
2	Pin	DAN5-6-4	Item 964

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use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 57, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBHAB Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBHAB Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

14 On the Frame 57 flange, at STGR 35 LH, refer to Fig. A-GBHAB Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 57 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBHAB Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 57 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBHAB Sheet 02, View C and Fig. A-GBHAB Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

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17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBHAB Sheet 02, View C and Fig. A-GBHAB Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAB Sheet 04.

18 On the Frame 57 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 57, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 57 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBHAB Sheet 02, View C and Fig. A-GBHAB Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

21 On the Frame 57 flange, at STGR 36 LH, refer to Fig. A-GBHAB Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 57 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBHAB Sheet 03, Section B-B.

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1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 57 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBHAB Sheet 02, View C and Fig. A-GBHAB Sheet 03, Section B-B.

1	Angle	E5347001123800	Item 20

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 20, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the two holes from the Frame to the angle, Item 20, refer to Fig. A-GBHAB Sheet 02, View C and Fig. A-GBHAB Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAB Sheet 04.

25 On the Frame 57 flange, at STGR 36 LH, remove:

1	Angle	E5347001123800	Item 20

26 Clean and deburr the new fastener holes in the Frame 57, STGR 36 LH and angle, Item 20, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 57 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBHAB Sheet 02, View C and Fig. A-GBHAB Sheet 03, Section B-B.

1	Angle	E5347001123800	Item 20

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656

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1	Rivet	EN6081D6-07	Item 667	
1	Collar	NSA5075-6	Item 806	
1	Pin	DAN5-6-4	Item 964	

28 On the Frame 57 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBHAB Sheet 02, View C and Fig. A-GBHAB Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 57 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBHAB Sheet 02, View C.

1	Angle	D5347046820200	Item (118)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-5X	Item 765	
1	Pin	DAN5-6-5Y	Item 785	
2	Collar	DAN11-6X	Item 807	
1	Collar	DAN11-6Y	Item 809	

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30 On the Frame 57 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBHAB Sheet 02, View C and Fig. A-GBHAB Sheet 03, Section D-D.

1	Angle-Support	D5347068120000	Item (102)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-08	Item 668	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(11) Subtask 531364-831-211-007 - Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 58 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D03R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
22	E5347001021400	1	WEB	
24	E5347001120600	1	ANGLE	
26	E5347001120800	1	ANGLE	
363	EN6115K3-3	5	BOLT	
364	EN6115K3-4	3	BOLT	
374	EN6115K3A4	2	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
567	EN6069D6-07	14	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	3	RIVET	
666	EN6081D6-06	2	RIVET	
667	EN6081D6-07	4	RIVET	
668	EN6081D6-08	4	RIVET	(1)
670	EN6081D7-10	4	RIVET	
678	EN6081D7-08	6	RIVET	
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	20	COLLAR	
807	DAN11-6X	10	COLLAR	
808	ASNA2528-3	9	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	9	PIN	
908	ASNA2528-3A	2	NUT	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	5	PIN	
965	DAN5-6-5	2	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBJAB Replacement of Webs and Angles at Frame 58	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBJAB Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 58, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347082420000	Item (15)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 58, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 58, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347080520000	Item (16)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 58, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347083020000	Item (17)	Discard
1	Support	D5347032200600	Item (104)	Retain
1	Angle-Support	D5347069520000	Item (105)	Retain
1	Angle	D5347046820800	Item (125)	Retain
	with			
47	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 58.

Refer to NTM 51-10-01.

Refer to Fig. A-GBJAB Sheet 02, Views C, D and F.

1 On Frame 58, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 58, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 7 holes for the fasteners, Item 363, Item 364 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 On the top flange of Frame 58, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 58, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBJAB Sheet 02 thru Fig. A-GBJAB Sheet 04.

1 On Frame 58, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBJAB Sheet 02, View C.

1	Shear Web	E5347001021400	Item 22

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

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3 Transfer drill the fastener holes from the Frame 58 to the shear web, Item 22.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAB Sheet 04.

4 Drill the additional 10 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBJAB Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBJAB Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAB Sheet 04.

5 Transfer drill the tack hole from the Frame 58 between STGR 36 LH and STGR 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 58, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021400	Item 22

7 Clean and deburr the new fastener holes in Frame 58 and the shear web, Item 22, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBJAB Sheet 02, Views C, D and F.

a On Frame 58, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBJAB Sheet 02, View C.

1	Shear Web	E5347001021400	Item 22

b On Frame 58, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAB Sheet 02, View C.

c On Frame 58, between STGR 36 LH and STGR 37 LH, cold expand the 5 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAB Sheet 02, View C.

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d On Frame 58, between STGR 36 LH and STGR 37 LH, cold expand the 2 holes for the fasteners, Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAB Sheet 02, View C.

e On the top flange of Frame 58, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAB Sheet 02, View D.

f On the top flange of Frame 58, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAB Sheet 02, View F.

9 On Frame 58, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021400	Item 22

10 Clean and deburr the cold expansion fastener holes in Frame 58 and the shear web, Item 22, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 58, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBJAB Sheet 02, View C.

1	Shear Web	E5347001021400	Item 22

with

4	Bolt	EN6115K3-3	Item 363

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3	Bolt	EN6115K3-4	Item 364
2	Bolt	EN6115K3A4	Item 374
14	Rivet	EN6069D6-07	Item 567
7	Pin	DAN5-6-4X	Item 764
8	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-06	Item 666
4	Rivet	EN6081D6-08	Item 668
6	Rivet	EN6081D7-08	Item 678
13	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
7	Nut	ASNA2528-3	Item 808
8	Pin	DAN6-6-3	Item 863
2	Nut	ASNA2528-3A	Item 908
5	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 58, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBJAB Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 58, at STGR 35 LH, install:

Refer to Fig. A-GBJAB Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808

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1	Pin	DAN6-6-3	Item 863

14 On the Frame 58 flange, at STGR 35 LH, refer to Fig. A-GBJAB Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 58 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBJAB Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 58 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBJAB Sheet 02, View C and Fig. A-GBJAB Sheet 03, Section A-A.

1	Angle	E5347001120600	Item 24

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 24, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes form the Frame to the angle, Item 24, refer to Fig. A-GBJAB Sheet 02, View C and Fig. A-GBJAB Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAB Sheet 04.

18 On the Frame 58 flange, at STGR 35 LH, remove:

1	Angle	E5347001120600	Item 24

19 Clean and deburr the new fastener holes in the Frame 58, STGR 35 LH and angle, Item 24, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 58 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBJAB Sheet 02, View C and Fig. A-GBJAB Sheet 03, Section A-A.

1	Angle	E5347001120600	Item 24

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
1	Pin	DAN5-6-5X	Item 765
2	Collar	NSA5075-6	Item 806
1	Collar	DAN11-6X	Item 807
2	Pin	DAN5-6-5	Item 965

21 On the Frame 58 flange, at STGR 36 LH, refer to Fig. A-GBJAB Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 58 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBJAB Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 58 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBJAB Sheet 02, View C and Fig. A-GBJAB Sheet 03, Section B-B.

1	Angle	E5347001120800	Item 26

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 26, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH to the angle, Item 26, refer to Fig. A-GBJAB Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAB Sheet 04.

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 26, to the Frame 58 flange, at STGR 36 LH, then transfer drill and ream the two holes from the Frame to the angle, Item 26, refer to Fig. A-GBJAB Sheet 03, View E.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAB

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Sheet 04.

26 On the Frame 58 flange, at STGR 36 LH, remove:

1	Angle	E5347001120800	Item 26	

27 Clean and deburr the new fastener holes in the Frame 58, STGR 36 LH and angle, Item 26, use:

Textile - Lint Free Cotton	14SBA1	As required	

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required	

28 On the Frame 58 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBJAB Sheet 02, View C and Fig. A-GBJAB Sheet 03, Section B-B.

1	Angle	E5347001120800	Item 26	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-06	Item 656	
1	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	

29 On the Frame 58 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBJAB Sheet 02, View C and Fig. A-GBJAB Sheet 03, Section C-C.

1	Support	D5347032200600	Item (104)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

4	Rivet	EN6081D7-10	Item 670	

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4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

30 On the aft side of the Frame 58 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBJAB Sheet 02, View C.

1	Angle	D5347046820800	Item (125)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

1	Pin	DAN5-6-5Y	Item 785	
1	Collar	DAN11-6Y	Item 809	
2	Pin	DAN5-6-5X	Item 765	
2	Collar	DAN11-6X	Item 807	

31 On the Frame 58 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBJAB Sheet 02, View C and Fig. A-GBJAB Sheet 03, Section D-D.

1	Angle-Support	D5347069520000	Item (105)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(12) Subtask 531364-831-212-007 - Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 59 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D03R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
28	E5347001021600	1	WEB	
30	E5347001121000	1	ANGLE	
32	E5347001121200	1	ANGLE	
363	EN6115K3-3	5	BOLT	
364	EN6115K3-4	2	BOLT	
365	EN6115K3-5	3	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	20	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	20	RIVET	
667	EN6081D6-07	3	RIVET	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
668	EN6081D6-08	7	RIVET	(1)
669	EN6081D6-09	3	RIVET	(2)
764	DAN5-6-4X	3	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	21	COLLAR	
807	DAN11-6X	6	COLLAR	
808	ASNA2528-3	11	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	8	PIN	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	6	PIN	
965	DAN5-6-5	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

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NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBKAB Replacement of Webs and Angles at Frame 59	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBKAB Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 59, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347089120000	Item (18)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 59, at STGR 35 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

5	Rivet		Item (100)	Discard

3 From Frame 59, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347089020000	Item (19)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 59, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347088920000	Item (20)	Discard
1	Support	D5347032201000	Item (106)	Retain

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1	Angle-Support	D5347068820000	Item (107)	Retain
1	Angle	D5347046821000	Item (127)	Retain
	with			
59	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 59.

Refer to NTM 51-10-01.

Refer to Fig. A-GBKAB Sheet 02, Views C and D.

1 On Frame 59, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 59, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 7 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 59, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBKAB Sheet 02 thru Fig. A-GBKAB Sheet 04.

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1 On Frame 59, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBKAB Sheet 02, View C.

1	Shear Web	E5347001021600	Item 28

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 59 to the shear web, Item 28.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAB Sheet 04.

4 Drill the additional 17 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBKAB Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBKAB Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAB Sheet 04.

5 Transfer drill the tack hole from the Frame 59 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 59, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021600	Item 28

7 Clean and deburr the new fastener holes in Frame 59 and the shear web, Item 28, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBKAB Sheet 02, Views C and D.

a On Frame 59, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBKAB Sheet 02, View C.

1	Shear Web	E5347001021600	Item 28

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b On Frame 59, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAB Sheet 02, View C.

c On Frame 59, between STGR 36 LH and STGR 37 LH, cold expand the 7 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAB Sheet 02, View C.

d On the top flange of Frame 59, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAB Sheet 02, View D.

9 On Frame 59, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021600	Item 28

10 Clean and deburr the cold expansion fastener holes in Frame 59 and the shear web, Item 28, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 59, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBKAB Sheet 02, View C.

1	Shear Web	E5347001021600	Item 28

with

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4	Bolt	EN6115K3-3	Item 363
2	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
16	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D6-06	Item 666
5	Rivet	EN6081D6-08	Item 668
3	Pin	DAN5-6-4X	Item 764
14	Collar	NSA5075-6	Item 806
3	Collar	DAN11-6X	Item 807
6	Nut	ASNA2528-3	Item 808
8	Pin	DAN6-6-3	Item 863
6	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 59, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBKAB Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 59, at STGR 35 LH, install:

Refer to Fig. A-GBKAB Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

14 On the Frame 59 flange, at STGR 35 LH, refer to Fig. A-GBKAB Sheet 03, Section A-A, countersink the one fastener hole.

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15 On the Frame 59 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBKAB Sheet 02, View C and Fig. A-GBKAB Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 59 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBKAB Sheet 02, View C and Fig. A-GBKAB Sheet 03, Section A-A.

1	Angle	E5347001121000	Item 30

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 30, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 30, refer to Fig. A-GBKAB Sheet 02, View C and Fig. A-GBKAB Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAB Sheet 04.

18 On the Frame 59 flange, at STGR 35 LH, remove:

1	Angle	E5347001121000	Item 30

19 Clean and deburr the new fastener holes in the Frame 59, STGR 35 LH and angle, Item 30, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 59 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBKAB Sheet 02, View C and Fig. A-GBKAB Sheet 03, Section A-A.

1	Angle	E5347001121000	Item 30

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Collar	NSA5075-6	Item 806
3	Pin	DAN5-6-5	Item 965

21 On the Frame 59 flange, at STGR 36 LH, refer to Fig. A-GBKAB Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 59 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBKAB Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 59 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBKAB Sheet 02, View C and Fig. A-GBKAB Sheet 03, Section B-B.

1	Angle	E5347001121200	Item 32

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 32, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 32, refer to Fig. A-GBKAB Sheet 02, View C and Fig. A-GBKAB Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAB Sheet 04.

25 On the Frame 59 flange, at STGR 36 LH, remove:

1	Angle	E5347001121200	Item 32

26 Clean and deburr the new fastener holes in the Frame 59, STGR 36 LH and angle, Item 32, use:

	Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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	Non Aqueous Cleaner - General	08BAA9	As required		

27 On the Frame 59 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBKAB Sheet 02, View C and Fig. A-GBKAB Sheet 03, Section B-B.

1	Angle	E5347001121200	Item 32		
	with				
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required		
	and				
2	Rivet	EN6081D5-06	Item 656		
3	Rivet	EN6081D6-07	Item 667		

28 On the Frame 59 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBKAB Sheet 02, View C and Fig. A-GBKAB Sheet 03, Section C-C.

1	Support	D5347032201000	Item (106)	Retained at removal	
	with				
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required		
	and				
3	Bolt	EN6115K3-5	Item 365		
3	Rivet	EN6081D6-09	Item 669		
4	Collar	NSA5075-6	Item 806		
3	Nut	ASNA2528-3	Item 808		
4	Pin	DAN5-6-3	Item 963		

29 On the Frame 59 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBKAB Sheet 02, View C.

1	Angle	D5347046821000	Item (127)	Retained at removal	

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

1	Pin	DAN5-6-5Y	Item 785	
1	Collar	DAN11-6Y	Item 809	
2	Pin	DAN5-6-5X	Item 765	
2	Collar	DAN11-6X	Item 807	

30 On the Frame 59 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBKAB Sheet 02, View C and Fig. A-GBKAB Sheet 03, Section D-D.

1	Angle-Support	D5347068820000	Item (107)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

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for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(13) Subtask 531364-831-213-007 - Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 60 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D03R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
34	E5347001021800	1	WEB	
38	E5347001121600	1	ANGLE	
40	E5347001121800	1	ANGLE	
363	EN6115K3-3	5	BOLT	
365	EN6115K3-5	8	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
567	EN6069D6-07	20	RIVET	
656	EN6081D5-06	41	RIVET	
666	EN6081D6-06	25	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	4	RIVET	(2)
764	DAN5-6-4X	4	PIN	
765	DAN5-6-5X	1	PIN	
806	NSA5075-6	19	COLLAR	
807	DAN11-6X	5	COLLAR	
808	ASNA2528-3	14	NUT	
864	DAN6-6-4	5	PIN	
865	DAN6-6-5	5	PIN	
963	DAN5-6-3	1	PIN	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
964	DAN5-6-4	4	PIN	
965	DAN5-6-5	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01

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References	
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBLAB Replacement of Webs and Angles at Frame 60	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBLAB Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 60, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347085020000	Item (21)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 60, at STGR 35 LH and from the frame flange between STGR 34 LH and STGR 35 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 60, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347085120000	Item (22)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 60, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347093120000	Item (23)	Discard
1	Support	D5347032201200	Item (108)	Retain
1	Angle	D5347046821200	Item (128)	Retain
1	Section-Connecting	D5347065420400	Item (136)	Retain

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1	Shim	D5347044920000	Item (142)	Retain
1	Shim	D5347044920600	Item (143)	Retain
	with			
77	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 60.

Refer to NTM 51-10-01.

Refer to Fig. A-GBLAB Sheet 02, Views C and D.

1 On Frame 60, at STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 60, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 60, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBLAB Sheet 02 thru Fig. A-GBLAB Sheet 04.

1 On Frame 60, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBLAB Sheet 02, View C.

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1	Shear Web	E5347001021800	Item 34

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 60 to the shear web, Item 34.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAB Sheet 04.

4 Drill the additional 38 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBLAB Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBLAB Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAB Sheet 04.

5 Transfer drill the tack hole from the Frame 60 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 60, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021800	Item 34

7 Clean and deburr the new fastener holes in Frame 60 and the shear web, Item 34, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBLAB Sheet 02, Views C and D.

a On Frame 60, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBLAB Sheet 02, View C.

1	Shear Web	E5347001021800	Item 34

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b On Frame 60, at STGR 35 LH, cold expand the 4 holes for the fasteners, Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAB Sheet 02, View C.

c On Frame 60, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAB Sheet 02, View C.

d On the top flange of Frame 60, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAB Sheet 02, View D.

9 On Frame 60, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021800	Item 34

10 Clean and deburr the cold expansion fastener holes in Frame 60 and the shear web, Item 34, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 60, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBLAB Sheet 02, View C.

1	Shear Web	E5347001021800	Item 34

with

5	Bolt	EN6115K3-3	Item 363

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20	Rivet	EN6069D6-07	Item 567
37	Rivet	EN6081D5-06	Item 656
25	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
4	Pin	DAN5-6-4X	Item 764
4	Collar	DAN11-6X	Item 807
5	Nut	ASNA2528-3	Item 808

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 On the top flange of Frame 60, at STGR 35 LH, install:

Refer to Fig. A-GBLAB Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

13 On the Frame 60 flange, at STGR 35 LH, refer to Fig. A-GBLAB Sheet 03, Section B-B, countersink the one fastener hole.

14 On the Frame 60 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBLAB Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 60 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBLAB Sheet 02, View C and Fig. A-GBLAB Sheet 03, Section B-B.

1	Angle	E5347001121600	Item 38

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16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 38, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH to the angle, Item 38, refer to Fig. A-GBLAB Sheet 02, View C and Fig. A-GBLAB Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAB Sheet 04.

17 On the Frame 60 flange, at STGR 35 LH, remove:

1	Angle	E5347001121600	Item 38

18 Clean and deburr the new fastener holes in the STGR 35 LH and angle, Item 38, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 60 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBLAB Sheet 02, View C and Fig. A-GBLAB Sheet 03, Section B-B.

1	Angle	E5347001121600	Item 38

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

4	Bolt	EN6115K3-5	Item 365
2	Rivet	EN6081D5-06	Item 656
4	Nut	ASNA2528-3	Item 808

20 On the Frame 60 flange, at STGR 36 LH, refer to Fig. A-GBLAB Sheet 03, Section C-C, countersink the one fastener hole.

21 On the Frame 60 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBLAB Sheet 03, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 60 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBLAB Sheet 02, View C and Fig. A-GBLAB Sheet 03, Section C-C.

1	Angle	E5347001121800	Item 40

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 40, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three hole form the Frame to the angle, Item 40, refer to Fig. A-GBLAB Sheet 02, View C and Fig. A-GBLAB Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAB Sheet 04.

24 On the Frame 60 flange, at STGR 36 LH, remove:

1	Angle	E5347001121800	Item 40

25 Clean and deburr the new fastener holes in the Frame 60, STGR 36 LH and angle, Item 40, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 60 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBLAB Sheet 02, View C and Fig. A-GBLAB Sheet 03, Section C-C.

1	Angle	E5347001121800	Item 40

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D6-07	Item 667

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27 On the Frame 60 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBLAB Sheet 02, View C and Fig. A-GBLAB Sheet 03, Section D-D.

1	Support	D5347032201200	Item (108)	Retained at removal
1	Section-Connecting	D5347065420400	Item (136)	Retained at removal
1	Shim	D5347044920000	Item (142)	Retained at removal
1	Shim	D5347044920600	Item (143)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

4	Bolt	EN6115K3-5	Item 365
4	Rivet	EN6081D6-09	Item 669
19	Collar	NSA5075-6	Item 806
4	Nut	ASNA2528-3	Item 808
5	Pin	DAN6-6-4	Item 864
5	Pin	DAN6-6-5	Item 865
1	Pin	DAN5-6-3	Item 963
4	Pin	DAN5-6-4	Item 964
4	Pin	DAN5-6-5	Item 965

28 On the aft side of the Frame 60 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBLAB Sheet 02, View C.

1	Angle	D5347046821200	Item (128)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
3	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(14) Subtask 531364-831-214-007 - Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 61 from Stringer 33 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D03R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
42	E5347001022000	1	WEB	
44	E5347001122000	1	ANGLE	
46	E5347001122200	1	ANGLE	
48	E5347001122400	1	ANGLE	
363	EN6115K3-3	6	BOLT	
364	EN6115K3-4	3	BOLT	
365	EN6115K3-5	4	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	3	RIVET	
567	EN6069D6-07	24	RIVET	
656	EN6081D5-06	36	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	22	RIVET	
667	EN6081D6-07	10	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	6	RIVET	(2)
763	DAN5-6-3X	4	PIN	
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
807	DAN11-6X	13	COLLAR	
808	ASNA2528-3	14	NUT	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	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	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

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NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBMAB Replacement of Webs and Angles at Frame 61	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBMAB Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

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1 From Frame 61, between STGR 33 LH and STGR 34 LH, remove:

1	Clip	D5347091620200	Item (24)	Discard
	with			
12	Rivet		Item (100)	Discard

2 From Frame 61, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347090620000	Item (25)	Discard
	with			
13	Rivet		Item (100)	Discard

3 From the top flange of Frame 61, between STGR 34 LH and STGR 35 LH and from the frame flange between STGR 33 LH and STGR 35 LH, remove:

11	Rivet		Item (100)	Discard
	or			
12	Rivet		Item (100)	Discard

NOTE: Depending on installation on aircraft.

4 From Frame 61, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347090720000	Item (26)	Discard
	with			
13	Rivet		Item (100)	Discard

5 From Frame 61, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347090820000	Item (27)	Discard
1	Support	D5347032201600	Item (109)	Retain
1	Angle-Support	D5347069620000	Item (110)	Retain
1	Angle	D5347046821400	Item (130)	Retain
	with			
65	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

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and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 61.

Refer to NTM 51-10-01.

Refer to Fig. A-GBMAB Sheet 02, Views C and E.

1 On Frame 61, at STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 61, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 61, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBMAB Sheet 02 thru Fig. A-GBMAB Sheet 04.

1 On Frame 61, between STGR 33 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBMAB Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 61 to the shear web, Item 42.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAB Sheet 04.

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4 Drill the additional 31 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBMAB Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBMAB Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAB Sheet 04.

5 Transfer drill the tack hole from the Frame 61 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 61, between STGR 33 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022000	Item 42

7 Clean and deburr the new fastener holes in Frame 61 and the shear web, Item 42, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBMAB Sheet 02, Views C and E.

a On Frame 61, between STGR 33 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBMAB Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

b On Frame 61, at STGR 35 LH, cold expand the 4 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAB Sheet 02, View C.

c On Frame 61, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAB Sheet 02, View C.

d On the top flange of Frame 61, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAB Sheet 02, View E.

9 On Frame 61, between STGR 33 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022000	Item 42

10 Clean and deburr the cold expansion fastener holes in Frame 61 and the shear web, Item 42, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 61, between STGR 33 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBMAB Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

with

5	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
24	Rivet	EN6069D6-07	Item 567
28	Rivet	EN6081D5-06	Item 656
22	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
6	Collar	DAN11-6X	Item 807

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8	Nut	ASNA2528-3	Item 808

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 On the flange of Frame 61, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBMAB Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 61, at STGR 35 LH, install:

Refer to Fig. A-GBMAB Sheet 02, View E.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

14 On the Frame 61 flange, at STGR 34 LH, refer to Fig. A-GBMAB Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 61 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBMAB Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 61 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section A-A.

1	Angle	E5347001122000	Item 44

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 44, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH and the three holes from the Frame to the angle, Item 44, refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAB Sheet 04.

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18 On the Frame 61 flange, at STGR 34 LH, remove:

1	Angle	E5347001122000	Item 44

19 Clean and deburr the new fastener holes in the Frame 61, STGR 34 LH and angle, Item 44, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 61 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section A-A.

1	Angle	E5347001122000	Item 44

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

If necessary, close the rivet hole in the frame flange at STGR 34 LH with:

1	Rivet	EN6081D6-06	Item 666

NOTE: Depending on installation on aircraft.

21 On the Frame 61 flange, at STGR 35 LH, refer to Fig. A-GBMAB Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 61 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBMAB Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 61 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section B-B.

1	Angle	E5347001122200	Item 46

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 46, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the four holes from the Frame to the angle, Item 46, refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAB Sheet 04.

25 On the Frame 61 flange, at STGR 35 LH, remove:

1	Angle	E5347001122200	Item 46

26 Clean and deburr the new fastener holes in the Frame 61, STGR 35 LH and angle, Item 46, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 61 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section B-B.

1	Angle	E5347001122200	Item 46

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
4	Rivet	EN6081D6-07	Item 667

28 On the Frame 61 flange, at STGR 36 LH, refer to Fig. A-GBMAB Sheet 03, Section C-C, countersink the one fastener hole.

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29 On the Frame 61 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBMAB Sheet 03, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

30 On the Frame 61 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section C-C.

1	Angle	E5347001122400	Item 48

31 Transfer drill and ream one new hole from the pilot hole of the angle, Item 48, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 48, refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAB Sheet 04.

32 On the Frame 61 flange, at STGR 36 LH, remove:

1	Angle	E5347001122400	Item 48

33 Clean and deburr the new fastener holes in the Frame 61, STGR 36 LH and angle, Item 48, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

34 On the Frame 61 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section C-C.

1	Angle	E5347001122400	Item 48

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656	
2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

35 On the Frame 61 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section D-D.

1	Support	D5347032201600	Item (109)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
4	Rivet	EN6081D6-09	Item 669
4	Pin	DAN5-6-3X	Item 763
4	Collar	DAN11-6X	Item 807
4	Nut	ASNA2528-3	Item 808

36 On the Frame 61 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBMAB Sheet 02, View C.

1	Angle	D5347046821400	Item (130)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

3	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

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37 On the Frame 61 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBMAB Sheet 02, View C and Fig. A-GBMAB Sheet 03, Section E-E.

1	Angle-Support	D5347069620000	Item (110)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(15) Subtask 531364-831-215-007 - Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 62 from Stringer 32 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D03R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
50	E5347001022200	1	WEB	
52	E5347001122600	1	ANGLE	
54	E5347001122800	1	ANGLE	
56	E5347001123000	1	ANGLE	
58	E5347001123200	1	ANGLE	
363	EN6115K3-3	6	BOLT	
364	EN6115K3-4	3	BOLT	
365	EN6115K3-5	4	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	4	RIVET	
567	EN6069D6-07	28	RIVET	
568	EN6069D6-08	1	RIVET	
656	EN6081D5-06	45	RIVET	
657	EN6081D5-07	7	RIVET	
666	EN6081D6-06	21	RIVET	
667	EN6081D6-07	7	RIVET	
668	EN6081D6-08	16	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	5	PIN	
765	DAN5-6-5X	3	PIN	
806	NSA5075-6	9	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	14	NUT	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	
965	DAN5-6-5	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBNAB Replacement of Webs and Angles at Frame 62	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBNAB Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 62, between STGR 32 LH and STGR 33 LH, remove:

1	Clip	D5347093420200	Item (28)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From Frame 62, between STGR 33 LH and STGR 34 LH, remove:

1	Clip	D5347084020000	Item (29)	Discard
	with			
13	Rivet		Item (100)	Discard

3 From Frame 62, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347084120000	Item (30)	Discard
	with			
11	Rivet		Item (100)	Discard

4 From the top flange of Frame 62, at STGR 34 LH and from the frame flange between STGR 32 LH and STGR 35 LH, remove:

13	Rivet		Item (100)	Discard
	or			
14	Rivet		Item (100)	Discard

NOTE: Depending on installation on aircraft.

5 From Frame 62, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347084220000	Item (31)	Discard
	with			
11	Rivet		Item (100)	Discard

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6 From Frame 62, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347084820000	Item (32)	Discard
1	Support	D5347032201800	Item (111)	Retain
1	Angle-Support	D5347069720000	Item (112)	Retain
1	Angle	D5347046821600	Item (131)	Retain
	with			
58	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 62.

Refer to NTM 51-10-01.

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 03, View F.

1 On Frame 62, between STGR 34 LH and STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 62, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

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5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBNAB Sheet 02 thru Fig. A-GBNAB Sheet 06.

1 On Frame 62, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBNAB Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 62 to the shear web, Item 50.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAB Sheet 06.

4 On Frame 62, between STGR 34 LH and STGR 37 LH, drill the additional 42 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBNAB Sheet 03, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBNAB Sheet 03.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAB Sheet 06.

5 On Frame 62, between STGR 38 LH and STGR 39 LH, drill the additional rivet hole to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBNAB Sheet 03, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBNAB Sheet 03.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAB Sheet 06.

6 Transfer drill the tack hole from the Frame 62 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

7 On Frame 62, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022200	Item 50

8 Clean and deburr the new fastener holes in Frame 62and the shear web, Item 50, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 03, View F.

a On Frame 62, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBNAB Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

b On Frame 62, between STGR 34 LH and STGR 35 LH, cold expand the 4 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAB Sheet 02, View C.

c On Frame 62, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

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FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAB Sheet 02, View C.

d On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAB Sheet 03, View F.

10 On Frame 62, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022200	Item 50

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11 Clean and deburr the cold expansion fastener holes in Frame 62and the shear web, Item 50, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 62, between STGR 32 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBNAB Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

with

5	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
28	Rivet	EN6069D6-07	Item 567
1	Rivet	EN6069D6-08	Item 568
35	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D5-07	Item 657
20	Rivet	EN6081D6-06	Item 666
13	Rivet	EN6081D6-08	Item 668
5	Pin	DAN5-6-4X	Item 764
4	Collar	NSA5075-6	Item 806
5	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
1	Pin	DAN5-6-3	Item 963
3	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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13 On theFrame 62 flange, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBNAB Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBNAB Sheet 03, View F.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

15 On the Frame 62 flange, at STGR 33 LH, refer to Fig. A-GBNAB Sheet 04, Section A-A, countersink the one fastener hole.

16 On the Frame 62 flange, at STGR 33 LH, close the rivet hole in STGR 33 LH with:

Refer to Fig. A-GBNAB Sheet 04, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 62 flange, at STGR 33 LH, put in position:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section A-A.

1	Angle	E5347001122600	Item 52

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 52, to the STGR 33 LH, then transfer drill and ream the other hole from STGR 33 LH and the three holes from the Frame to the angle, Item 52, refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAB Sheet 06.

19 On the Frame 62 flange, at STGR 33 LH, remove:

1	Angle	E5347001122600	Item 52

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20 Clean and deburr the new fastener holes in the Frame 62, STGR 33 LH and angle, Item 52, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 62 flange, at STGR 33 LH, wet install:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section A-A.

1	Angle	E5347001122600	Item 52

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Collar	NSA5075-6	Item 806
1	Pin	DAN5-6-5	Item 965

22 On the Frame 62 flange, at STGR 33 LH, if necessary, install:

Refer to Fig. A-GBNAB Sheet 02, View C.

1	Rivet	EN6081D6-06	Item 666

NOTE: Depending on installation on aircraft.

23 On the Frame 62 flange, at STGR 34 LH, refer to Fig. A-GBNAB Sheet 04, Section B-B, countersink the one fastener hole.

24 On the Frame 62 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBNAB Sheet 04, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

25 On the Frame 62 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section B-B.

1	Angle	E5347001122800	Item 54

26 Transfer drill and ream one new hole from the pilot hole of the angle, Item 54, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH and the three holes from the Frame to the angle, Item 54, refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAB Sheet 06.

27 On the Frame 62 flange, at STGR 34 LH, remove:

1	Angle	E5347001122800	Item 54

28 Clean and deburr the new fastener holes in the Frame 62, STGR 34 LH and angle, Item 54, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

29 On the Frame 62 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section B-B.

1	Angle	E5347001122800	Item 54

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765

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1	Collar	DAN11-6X	Item 807

30 On the Frame 62 flange, at STGR 34 LH, install:

Refer to Fig. A-GBNAB Sheet 02, View C.

1	Rivet	EN6081D6-07	Item 667

31 On the Frame 62 flange, at STGR 35 LH, refer to Fig. A-GBNAB Sheet 04, Section C-C, countersink the one fastener hole.

32 On the Frame 62 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 62 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section C-C.

1	Angle	E5347001123000	Item 56

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 56, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the five holes from the Frame to the angle, Item 56, refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAB Sheet 06.

35 On the Frame 62 flange, at STGR 35 LH, remove:

1	Angle	E5347001123000	Item 56

36 Clean and deburr the new fastener holes in the Frame 62, STGR 35 LH and angle, Item 56, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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37 On the Frame 62 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section C-C.

1	Angle	E5347001123000	Item 56
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

38 On the Frame 62 flange, at STGR 36 LH, refer to Fig. A-GBNAB Sheet 04, Section D-D, countersink the one fastener hole.

39 On the Frame 62 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBNAB Sheet 04, Section D-D.

1	Rivet	EN6069D5-05	Item 555
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

40 On the Frame 62 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section D-D.

1	Angle	E5347001123200	Item 58

41 Transfer drill and ream one new hole from the pilot hole of the angle, Item 58, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 58, refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAB Sheet 06.

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42 On the Frame 62 flange, at STGR 36 LH, remove:

1	Angle	E5347001123200	Item 58	

43 Clean and deburr the new fastener holes in the Frame 62, STGR 36 LH and angle, Item 58, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

44 On the Frame 62 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 04, Section D-D.

1	Angle	E5347001123200	Item 58

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

45 On the Frame 62 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 05, Section E-E.

1	Support	D5347032201800	Item (111)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
4	Rivet	EN6081D6-09	Item 669

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4	Collar	NSA5075-6	Item 806	
4	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	

46 On the aft side of the Frame 62 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBNAB Sheet 02, View C.

1	Angle	D5347046821600	Item (131)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

47 On the Frame 62 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBNAB Sheet 02, View C and Fig. A-GBNAB Sheet 05, Section F-F.

1	Angle-Support	D5347069720000	Item (112)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
2	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

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(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(16) Subtask 531364-831-216-007 - Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 63 from Stringer 32 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D03R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
60	E5347001022400	1	WEB	
62	E5347001123400	1	ANGLE	
64	E5347001123600	2	ANGLE	
363	EN6115K3-3	4	BOLT	
365	EN6115K3-5	8	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	3	RIVET	
567	EN6069D6-07	23	RIVET	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
568	EN6069D6-08	1	RIVET	
656	EN6081D5-06	43	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	22	RIVET	
667	EN6081D6-07	6	RIVET	
668	EN6081D6-08	12	RIVET	(1)
669	EN6081D6-09	7	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	8	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	13	NUT	
963	DAN5-6-3	8	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

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NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBPAB Replacement of Webs and Angles at Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBPAB Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 63, at STGR 33 LH, remove:

1	Shim	D5347032020200	Item (132)	Retain
1	Sheet-Support	D5347109620000	Item (133)	Retain
	with			
7	Rivet		Item (100)	Discard

2 From Frame 63, between STGR 32 LH and STGR 34 LH, remove:

1	Clip	D5347082820000	Item (33)	Discard
	with			
21	Rivet		Item (100)	Discard

3 From the top flange of Frame 63, at STGR 34 LH and from the frame flange between STGR 33 LH and STGR 34 LH, remove:

5	Rivet		Item (100)	Discard

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4 From Frame 63, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347079220000	Item (34)	Discard
	with			
10	Rivet		Item (100)	Discard

5 From Frame 63, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347079920000	Item (35)	Discard
	with			
11	Rivet		Item (100)	Discard

6 From Frame 63, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347082920000	Item (36)	Discard
1	Angle-Support	D5347069820000	Item (113)	Retain
1	Support	D5347032202000	Item (114)	Retain
1	Angle	D5347046821800	Item (115)	Retain
	with			
54	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 63.

Refer to NTM 51-10-01.

Refer to Fig. A-GBPAB Sheet 02, Views C and D.

1 On Frame 63, at STGR 34 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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2 On Frame 63, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 8 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 63, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBPAB Sheet 02 thru Fig. A-GBPAB Sheet 06.

1 On Frame 63, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBPAB Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 63 to the shear web, Item 60.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAB Sheet 06.

4 On Frame 63, between STGR 34 LH and STGR 37 LH, drill the additional 41 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBPAB Sheet 03, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBPAB Sheet 03.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAB Sheet 06.

5 Transfer drill the tack hole from the Frame 63 between STGR 36 LH and STGR 37 LH, to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 63, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022400	Item 60

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7 Clean and deburr the new fastener holes in Frame 63 and the shear web, Item 60, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBPAB Sheet 02, Views C and D.

a On Frame 63, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBPAB Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

b On Frame 63, at STGR 34 LH, cold expand the 4 holes for the fasteners, Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAB Sheet 02, View C.

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c On Frame 63, between STGR 36 LH and STGR 37 LH, cold expand the 8 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAB Sheet 02, View C.

d On the top flange of Frame 63, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAB Sheet 02, View D.

9 On Frame 63, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022400	Item 60

10 Clean and deburr the cold expansion fastener holes in Frame 63 and the shear web, Item 60, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 63, between STGR 32 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBPAB Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

with

4	Bolt	EN6115K3-3	Item 363
23	Rivet	EN6069D6-07	Item 567
1	Rivet	EN6069D6-08	Item 568
35	Rivet	EN6081D5-06	Item 656
22	Rivet	EN6081D6-06	Item 666
10	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
6	Collar	DAN11-6X	Item 807
4	Nut	ASNA2528-3	Item 808

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 On the Frame 63 flange, at STGR 33 LH, wet install:

Refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 04, Section A-A.

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1	Shim	D5347032020200	Item (132)	Retained at removal
1	Sheet-Support	D5347109620000	Item (133)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

3	Rivet	EN6081D6-09	Item 669
4	Collar	NSA5075-6	Item 806
4	Pin	DAN5-6-3	Item 963

13 On the Frame 63 flange, at STGR 34 LH, refer to Fig. A-GBPAB Sheet 04, Section B-B, countersink the one fastener hole.

14 On the Frame 63 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBPAB Sheet 04, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

15 On the Frame 63 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 04, Section B-B.

1	Angle	E5347001123400	Item 62

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 62, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH to the angle, Item 62, refer to Fig. A-GBPAB Sheet 04, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAB Sheet 06.

17 On the Frame 63 flange, at STGR 34 LH, remove:

1	Angle	E5347001123400	Item 62

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18 Clean and deburr the new fastener holes in the STGR 34 LH and angle, Item 62, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 63 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 04, Section B-B.

1	Angle	E5347001123400	Item 62

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
2	Rivet	EN6081D5-06	Item 656
4	Nut	ASNA2528-3	Item 808

20 On the top flange of Frame 63, at STGR 34 LH, install:

Refer to Fig. A-GBPAB Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

21 On the Frame 63 flange, at STGR 35 LH, refer to Fig. A-GBPAB Sheet 04, Section C-C, countersink the one fastener hole.

22 On the Frame 63 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBPAB Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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23 On the Frame 63 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 64, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the five holes from the Frame to the angle, Item 64, refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAB Sheet 06.

25 On the Frame 63 flange, at STGR 35 LH, remove:

1	Angle	E5347001123600	Item 64

26 Clean and deburr the new fastener holes in the Frame 63, STGR 35 LH and angle, Item 64, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 63 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

28 On the Frame 63 flange, at STGR 36 LH, refer to Fig. A-GBPAB Sheet 04, Section C-C, countersink the one fastener hole.

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29 On the Frame 63 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBPAB Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

30 On the Frame 63 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

31 Transfer drill and ream one new hole from the pilot hole of the angle, Item 64, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 64, refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAB Sheet 06.

32 On the Frame 63 flange, at STGR 36 LH, remove:

1	Angle	E5347001123600	Item 64

33 Clean and deburr the new fastener holes in the Frame 63, STGR 36 LH and angle, Item 64, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

34 On the Frame 63 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	

35 On the Frame 63 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 05, Section D-D.

1	Support	D5347032202000	Item (114)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
4	Rivet	EN6081D6-09	Item 669
4	Collar	NSA5075-6	Item 806
4	Nut	ASNA2528-3	Item 808
4	Pin	DAN5-6-3	Item 963

36 On the Frame 63 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBPAB Sheet 02, View C.

1	Angle	D5347046821800	Item (115)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

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37 On the Frame 63 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBPAB Sheet 02, View C and Fig. A-GBPAB Sheet 05, Section E-E.

1	Angle-Support	D5347069820000	Item (113)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
2	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(17) Subtask 531364-831-217-007 - Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 Stringer 38 LH

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To	160	Work location	from Frame 60 to Frame 63 Stringer 38 LH

Manpower Resources	
Manhours	6.50
Minimum number of person	2
Subtask elapsed time	6.50
Skills	AIRFRAME

Material necessary to do the job

Kit 531364D03R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
544	EN6069D4-04	4	RIVET	
545	EN6069D4-05	52	RIVET	
655	EN6081D5-05	15	RIVET	
656	EN6081D5-06	183	RIVET	
657	EN6081D5-07	55	RIVET	
764	DAN5-6-4X	4	PIN	
765	DAN5-6-5X	4	PIN	
784	DAN5-6-4Y	2	PIN	
786	DAN5-6-6Y	6	PIN	
806	NSA5075-6	10	COLLAR	
807	DAN11-6X	8	COLLAR	
809	DAN11-6Y	18	COLLAR	
864	DAN6-6-4	3	PIN	
865	DAN6-6-5	7	PIN	
885	DAN6-6-5Y	4	PIN	
886	DAN6-6-6Y	3	PIN	
887	DAN6-6-7Y	3	PIN	

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	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12 53-41-14

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References	
Fig. A-GBQAC Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Install the shear plates.

Refer to Fig. A-GBQAC Sheet 01 thru Fig. A-GBQAC Sheet 06.

1 Between Frame 49 and Frame 50, on STGR 38 LH and on the bracket, Item 66, put in position:

Refer to Fig. A-GBQAC Sheet 02, View D.

1	Plate-Shear	D5347471500000	Item (139)	Retained at removal

2 Transfer drill and ream the three holes from the shear plate, Item (139), to the bracket, Item 66, refer to Fig. A-GBQAC Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAC Sheet 06.

3 Between Frame 49 and Frame 50, on STGR 38 LH, remove:

1	Plate-Shear	D5347471500000	Item (139)	Retain

4 Between Frame 49 and Frame 50, on STGR 38 LH, clean and deburr the new fastener holes in the bracket, Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

5 Between Frame 49 and Frame 50, on STGR 38 LH and on the bracket, Item 66, wet install:

Refer to Fig. A-GBQAC Sheet 02, View D.

1	Plate-Shear	D5347471500000	Item (139)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6069D4-05	Item 545	
6	Rivet	EN6081D5-06	Item 656	
20	Rivet	EN6081D5-07	Item 657	

6 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item 66, put in position:

Refer to Fig. A-GBQAC Sheet 02, View D.

1	Plate-Shear	D5347471500200	Item (117)	Retained at removal

7 Transfer drill and ream the six holes from the shear plate, Item (117), to the brackets, Item 65 and Item 66, refer to Fig. A-GBQAC Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAC Sheet 06.

8 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item 66, remove:

1	Plate-Shear	D5347471500200	Item (117)	Retain

9 Between Frame 50 and Frame 51, on STGR 38 LH, clean and deburr the new fastener holes in the brackets, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

10 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item 66, wet install:

Refer to Fig. A-GBQAC Sheet 02, View D.

1	Plate-Shear	D5347471500200	Item (117)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545	

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6	Rivet	EN6081D5-06	Item 656	
20	Rivet	EN6081D5-07	Item 657	

11 Between Frame 51 and Frame 53, on STGR 38 LH and on the brackets, Items 65, Item 67 and Item 68, put in position:

Refer to Fig. A-GBQAC Sheet 02, View D and Fig. A-GBQAC Sheet 03, View F.

1	Plate-Shear	D5347471500600	Item (137)	Retained at removal
1	Plate-Shear	D5347471500800	Item (119)	Retained at removal

12 Transfer drill and ream the six holes from the shear plate, Item (137), to the brackets, Item 65 and Item 67, refer to Fig. A-GBQAC Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAC Sheet 06.

13 Transfer drill and ream the six holes from the shear plate, Item (119), to the brackets, Item 65 and Item 68, refer to Fig. A-GBQAC Sheet 03, View F.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAC Sheet 06.

14 Between Frame 51 and Frame 53, on STGR 38 LH, remove:

1	Plate-Shear	D5347471500600	Item (137)	Retain
1	Plate-Shear	D5347471500800	Item (119)	Retain

15 Between Frame 51 and Frame 53, on STGR 38 LH, clean and deburr the new fastener holes in the brackets, Items 65, Item 67 and Item 68, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

16 Between Frame 51 and Frame 53, on STGR 38 LH and on the brackets, Items 65, Item 67 and Item 68, wet install:

Refer to Fig. A-GBQAC Sheet 02, View D and Fig. A-GBQAC Sheet 03, View F.

1	Plate-Shear	D5347471500600	Item (137)	Retained at removal

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1	Plate-Shear	D5347471500800	Item (119)	Retained at removal
1	Section-Connecting	D5347065020200	Item (135)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Rivet	EN6069D4-05	Item 545	
30	Rivet	EN6081D5-06	Item 656	
15	Rivet	EN6081D5-07	Item 657	
6	Pin	DAN5-6-6Y	Item 786	
2	Pin	DAN5-6-4Y	Item 784	
4	Pin	DAN6-6-5Y	Item 885	
3	Pin	DAN6-6-6Y	Item 886	
3	Pin	DAN6-6-7Y	Item 887	
18	Collar	DAN11-6Y	Item 809	

17 Between Frame 53 and Frame 54, on STGR 38 LH and on the brackets, Item 80 and Item 82, put in position:

Refer to Fig. A-GBQAC Sheet 03, View F.

1	Plate-Shear	D5347471501000	Item (141)	Retained at removal

18 Transfer drill and ream the six holes from the shear plate, Item (141), to the brackets, Item 80 and Item 82, refer to Fig. A-GBQAC Sheet 03, View F.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAC Sheet 06.

19 Between Frame 53 and Frame 54, on STGR 38 LH and on the brackets, Item 80 and Item 82, remove:

1	Plate-Shear	D5347471501000	Item (141)	Retain

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20 Between Frame 53 and Frame 54, on STGR 38 LH, clean and deburr the new fastener holes in the brackets, Item 80 and Item 82, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 Between Frame 53 and Frame 54, on STGR 38 LH and on the brackets, Item 80 and Item 82, wet install:

Refer to Fig. A-GBQAC Sheet 03, View F.

1	Plate-Shear	D5347471501000	Item (141)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545
26	Rivet	EN6081D5-06	Item 656

22 Between Frame 54 and Frame 55, on STGR 38 LH and on the brackets, Item 84 and Item (120), wet install:

Refer to Fig. A-GBQAC Sheet 04, View H.

1	Plate Assy-Shear	D5347048800400	Item (122)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

14	Rivet	EN6069D4-05	Item 545
26	Rivet	EN6081D5-06	Item 656

23 Between Frame 56 and Frame 57, on STGR 38 LH and on the brackets, Item (121) and Item (118), wet install:

Refer to Fig. A-GBQAC Sheet 04, View K.

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1	Plate Assy-Shear	D5347048900000	Item (124)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
14	Rivet	EN6069D4-05	Item 545	
26	Rivet	EN6081D5-06	Item 656	

24 Between Frame 58 and Frame 59, on STGR 38 LH and on the brackets, Item (125) and Item (127), wet install:

Refer to Fig. A-GBQAC Sheet 05, View M.

1	Plate-Shear	D5347049200200	Item (126)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
14	Rivet	EN6069D4-05	Item 545	
26	Rivet	EN6081D5-06	Item 656	

25 Between Frame 60 and Frame 61, on STGR 38 LH and on the brackets, Item (128) and Item (130), wet install:

Refer to Fig. A-GBQAC Sheet 05, View P.

1	Plate-Shear	D5347049300000	Item (129)	Retained at removal
1	Section-Connecting	D5347065420400	Item (136)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6069D4-04	Item 544	

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8	Rivet	EN6081D5-05	Item 655	
17	Rivet	EN6081D5-06	Item 656	
4	Pin	DAN5-6-4X	Item 764	
4	Pin	DAN5-6-5X	Item 765	
10	Collar	NSA5075-6	Item 806	
8	Collar	DAN11-6X	Item 807	
3	Pin	DAN6-6-4	Item 864	
7	Pin	DAN6-6-5	Item 865	

26 Between Frame 62 and Frame 63, on STGR 38 LH and on the brackets, Item (131) and Item (115), wet install:

Refer to Fig. A-GBQAC Sheet 06, View R.

1	Plate-Shear	D5347049400000	Item (123)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

7	Rivet	EN6081D5-05	Item 655	
20	Rivet	EN6081D5-06	Item 656	
2	Rivet	EN6069D4-04	Item 544	

(b) Install the corner profiles.

In accordance with SRM 53-41-14.

1 Between Frame 48 thru Frame 63, at STGR 38 LH, install the corner profiles, if removed in accordance with SRM 53-41-14 C2 Identification - Floor Structure - Cargo Compartment.

(c) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(18) Subtask 531364-831-218-002 - Install new Surface Protection on Frame 50 thru Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 from Stringer 31 to Stringer 39
To	160	Work location	from Frame 60 to Frame 63 from Stringer 31 to Stringer 39

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	NON SPECIFIC

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	04JME4	As required	
	Coating - Flexible Structure	04QAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound	12ADB1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12

(a) Clean the working area with:

Non Aqueous Cleaner - General	08BAA9	As required

and

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Textile - Lint Free Cotton	14SBA1	As required

(b) Apply sealant beads around the edges of all new and reinstalled structure parts with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(c) Apply to all sealant beads:

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(d) Apply to all sealant beads:

Top Coat Polyurethane	04JME4	As required

and

Coating - Flexible Structure	04QAB2	As required

(e) Install new water repellent protection on Frame 50 thru Frame 63.

1 Protect the Frame 50 thru Frame 63, STGR 31 LH thru STGR 39 LH and the re-installed shear plates with:

In accordance with SRM 51-23-12.

Corrosion Preventive Compound	12ADB1	As required

****CONF 004**

(1) Subtask 531364-831-201-011 - Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 Stringer 38 LH
To	160	Work location	from Frame 60 to Frame 63 Stringer 38 LH

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

Material necessary to do the job

Consumable CMLD01				
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)	53-41-14
Fig. A-GBQAD Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

CAUTION: AIRBUS CONSIDERS IT IS TECHNICALLY ACCEPTABLE TO REWORK EVERY THIRD FRAME AT THE SAME TIME (I.E. LEAVE TWO FRAMES INTACT AND REWORK ONE) TO KEEP THE FUSELAGE STRUCTURE INTEGRITY.

(a) Remove the corner profiles.

In accordance with SRM 53-41-14 C2 Ident.-Floor Structure-Cargo Compartment.

1 Between Frame 48 thru Frame 63, at STGR 38 LH, remove the corner profiles, if necessary in accordance with SRM 53-41-14 C2 Identification - Floor Structure - Cargo Compartment.

(b) Remove the shear plates.

Refer to Fig. A-GBQAD Sheet 01 thru Fig. A-GBQAD Sheet 07.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 Between Frame 49 and Frame 50, from STGR 38 LH and from the bracket at Frame 49 and bracket, Item (140), remove:

Refer to Fig. A-GBQAD Sheet 02, View C.

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1	Plate-Shear	D5347471500000	Item (139)	Retain
	with			
28	Rivet		Item (100)	Discard

2 Between Frame 50 and Frame 51, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAD Sheet 02, View C.

1	Plate-Shear	D5347471500200	Item (117)	Retain
	with			
28	Rivet		Item (100)	Discard

3 Between Frame 51 and Frame 53, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAD Sheet 03, View E.

1	Plate-Shear	D5347471500600	Item (137)	Retain
1	Plate-Shear	D5347471500800	Item (119)	Retain
1	Section-Connecting	D5347065020200	Item (135)	Retain
	with			
67	Rivet		Item (100)	Discard

4 Between Frame 53 and Frame 54, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAD Sheet 04, View G.

1	Plate-Shear	D5347471501000	Item (141)	Retain
	with			
28	Rivet		Item (100)	Discard

5 Between Frame 54 and Frame 55, from STGR 38 LH and from the brackets, Item (121) and Item (120), remove:

Refer to Fig. A-GBQAD Sheet 04, View J.

1	Plate Assy-Shear	D5347048800400	Item (122)	Retain
	with			
40	Rivet		Item (100)	Discard

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6 Between Frame 56 and Frame 57, from STGR 38 LH and from the brackets, Item (121) and Item (118), remove:

Refer to Fig. A-GBQAD Sheet 05, View L.

1	Plate Assy-Shear	D5347048900000	Item (124)	Retain
	with			
40	Rivet		Item (100)	Discard

7 Between Frame 58 and Frame 59, from STGR 38 LH and from the brackets, Item (125) and Item (127), remove:

Refer to Fig. A-GBQAD Sheet 05, View N.

1	Plate-Shear	D5347049200000	Item (126)	Retain
	with			
40	Rivet		Item (100)	Discard

8 Between Frame 60 and Frame 61, from STGR 38 LH and from the brackets, Item (128) and Item (130), remove:

Refer to Fig. A-GBQAD Sheet 06, View Q.

1	Plate-Shear	D5347049300000	Item (129)	Retain
1	Section-Connecting	D5347065420400	Item (136)	Retain
	with			
45	Rivet		Item (100)	Discard

9 Between Frame 62 and Frame 63, from STGR 38 LH and from the brackets, Item (131) and Item (115), remove:

Refer to Fig. A-GBQAD Sheet 06, View S.

1	Plate-Shear	D5347049400000	Item (123)	Retain
	with			
29	Rivet		Item (100)	Discard

(c) Clean the contact surfaces and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

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Textile - Lint Free Cotton	14SBA1	As required

(2) Subtask 531364-831-202-003 - Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 from Stringer 33 LH to Stringer 34 LH from Stringer 36 LH to Stringer 37 LH
To	160	Work location	from Frame 60 to Frame 62 from Stringer 32 LH to Stringer 33 LH from Stringer 36 LH to Stringer 37 LH Frame 63 from Stringer 31 LH to Stringer 32 LH from Stringer 36 LH to Stringer 37 LH

Manpower Resources	
Manhours	5.00
Minimum number of person	1
Subtask elapsed time	5.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

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 Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane	04JME4	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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

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For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00
Fig. A-GBRAA Cold Expansion of Holes in Frame 50 thru Frame 63	Sheet 01 Sheet 02 Sheet 03

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

(a) Inspect the holes for cracks from Frame 50 thru Frame 55 and from Frame 57 thru Frame 59.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 33 LH and STGR 34 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(b) Cold expand the holes from Frame 50 thru Frame 55 and from Frame 57 thru Frame 59.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

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1 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 33 LH and STGR 34 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 02, View C.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

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(c) Inspect the holes for cracks at Frame 56.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 At Frame 56, between STGR 33 LH and STGR 34 LH and between STGR 35 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(d) Cold expand the holes at Frame 56.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 At Frame 56, between STGR 33 LH and STGR 34 LH and between STGR 35 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 02, View D.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

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2 Clean the area of the expanded holes with:

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

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(e) Inspect the holes for cracks from Frame 60 thru Frame 62.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

1 From Frame 60 thru Frame 62, between STGR 32 LH and STGR 33 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(f) Cold expand the holes from Frame 60 thru Frame 62.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

1 From Frame 60 thru Frame 62, between STGR 32 LH and STGR 33 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 03, View E.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(g) Inspect the holes for cracks at Frame 63.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

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1 At Frame 63, between STGR 31 LH and STGR 32 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frame, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(h) Cold expand the holes at Frame 63.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

1 At Frame 63, between STGR 31 LH and STGR 32 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frame. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 03, View F.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

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and

Textile - Lint Free Cotton	14SBA1	As required

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(3) Subtask 531364-831-203-008 - Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 50 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D04R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
4	E5347001024400	1	WEB	
36	E5347001124200	1	ANGLE	
65	E5347001420200	1	ANGLE	
66	E5347001420000	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	11	RIVET	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
668	EN6081D6-08	11	RIVET	(1)
764	DAN5-6-4X	15	PIN	
765	DAN5-6-5X	13	PIN	
766	DAN5-6-6X	6	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	2	PIN	
785	DAN5-6-5Y	3	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	37	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

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NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBAAD Replacement of Webs and Angles at Frame 50	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBAAD Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 50, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
17	Rivet		Item (100)	Discard

2 From the flange of Frame 50, between STGR 35 LH and STGR 36 LH, remove:

6	Rivet		Item (100)	Discard

3 From Frame 50, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347073420200	Item (1)	Discard
	with			

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18	Rivet		Item (100)	Discard

4 From Frame 50, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072820600	Item (2)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347470120200	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard
	with			
66	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 50.

Refer to NTM 51-10-01.

Refer to Fig. A-GBAAD Sheet 02, View C.

1 On Frame 50, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 50, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

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(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBAAD Sheet 02 thru Fig. A-GBAAD Sheet 04.

1 On Frame 50, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBAAD Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 50 to the shear web, Item 4.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAD Sheet 04.

4 Transfer drill the tack hole from the Frame 50 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

5 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBAAD Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBAAD Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAD Sheet 04.

6 On Frame 50, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

7 Clean and deburr the new fastener holes in Frame 50 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBAAD Sheet 02, View C.

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a On Frame 50, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBAAD Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

b On Frame 50, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAD Sheet 02, View C.

c On Frame 50, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAD Sheet 02, View C.

d On Frame 50, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAD Sheet 02, View C.

9 On Frame 50, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

10 Clean and deburr the cold expansion fastener holes in Frame 50 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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11 At Frame 50, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBAAD Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4
	with		
3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
11	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
11	Rivet	EN6081D6-08	Item 668
15	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-5X	Item 765
3	Pin	DAN5-6-5Y	Item 785
24	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809
5	Nut	ASNA2528-3A	Item 908
	use		
Polysulfide Sealant - General Purpose Brushable		06AAA1	As required

12 Install 1 fastener in the flange of Frame 50, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBAAD Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

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13 On the Frame 50 flange, at STGR 35 LH, refer to Fig. A-GBAAD Sheet 03, Section C-C, countersink the one fastener hole.

14 On the Frame 50 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBAAD Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 50 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBAAD Sheet 02, View C and Fig. A-GBAAD Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBAAD Sheet 02, View C and Fig. A-GBAAD Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAD Sheet 04.

17 On the Frame 50 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 50, STGR 35 LH and the angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 50 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBAAD Sheet 02, View C and Fig. A-GBAAD Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

20 On the Frame 50 flange, at STGR 36 LH, refer to Fig. A-GBAAD Sheet 03, Section D-D, countersink the one fastener hole.

21 On the Frame 50 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBAAD Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 50 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBAAD Sheet 02, View C and Fig. A-GBAAD Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream the one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBAAD Sheet 02, View C and Fig. A-GBAAD Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAD Sheet 04.

24 On the Frame 50 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

25 Clean and deburr the new fastener hole in the Frame 50, STGR 36 LH and angle, Item 2, use:

	Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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	Non Aqueous Cleaner - General	08BAA9	As required	

26 On the Frame 50 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBAAD Sheet 02, View C and Fig. A-GBAAD Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

27 On the Frame 50 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBAAD Sheet 02, View C and Fig. A-GBAAD Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Pin	DAN5-6-6X	Item 766	
2	Pin	DAN5-6-7X	Item 767	
4	Collar	NSA5075-6	Item 806	
6	Collar	DAN11-6X	Item 807	
4	Pin	DAN5-6-3	Item 963	

28 On the Frame 50 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBAAD Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65

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1	Angle	E5347001420000	Item 66

29 Transfer drill and ream the three holes from the Frame to the angles, Item 65 and Item 66, refer to Fig. A-GBAAD Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAD Sheet 04.

30 On the Frame 50 flange, at STGR 38 LH, remove:

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

31 Clean and deburr the new fastener holes in the Frame 50 and angles, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

32 On the Frame 50 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBAAD Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-8X	Item 768
1	Pin	DAN5-6-6Y	Item 786
2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

33 On the Frame 50 flange, at STGR 39 LH, refer to Fig. A-GBAAD Sheet 03, Section F-F, countersink the one fastener hole.

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34 On the Frame 50 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBAAD Sheet 03, Section F-F.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

35 On the Frame 50 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBAAD Sheet 02, View C and Fig. A-GBAAD Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

36 Transfer drill and ream the one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBAAD Sheet 03, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAD Sheet 04.

37 On the Frame 50 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

38 Clean and deburr the new fastener holes in the Frame 50, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

39 On the Frame 50 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBAAD Sheet 02, View C and Fig. A-GBAAD Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-07	Item 657
2	Pin	DAN5-6-6X	Item 766
2	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(4) Subtask 531364-831-204-015 - Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 51 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D04R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
2	E5347001120200	1	ANGLE	
4	E5347001024400	1	WEB	
36	E5347001124200	1	ANGLE	
65	E5347001420200	1	ANGLE	
66	E5347001420000	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	3	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	4	RIVET	(2)
764	DAN5-6-4X	14	PIN	
765	DAN5-6-5X	13	PIN	
766	DAN5-6-6X	5	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	1	PIN	
785	DAN5-6-5Y	3	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	34	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	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
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

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For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBBAD Replacement of Webs and Angles at Frame 51	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBBAD Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 51, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard

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with

17	Rivet		Item (100)	Discard

2 From the flange of Frame 51, between STGR 35 LH and STGR 36 LH, remove:

6	Rivet		Item (100)	Discard

3 From Frame 51, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347073420200	Item (1)	Discard

with

18	Rivet		Item (100)	Discard

4 From Frame 51, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072820600	Item (2)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347470120200	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard

with

66	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 51.

Refer to NTM 51-10-01.

Refer to Fig. A-GBBAD Sheet 02, View C.

1 On Frame 51, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

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2 On Frame 51, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBBAD Sheet 02 thru Fig. A-GBBAD Sheet 04.

1 On Frame 51, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBBAD Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 51 to the shear web, Item 4.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAD Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBBAD Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBBAD Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAD Sheet 04.

5 Transfer drill the tack hole from the Frame 51 between STGR 36 LH and 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 51, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

7 Clean and deburr the new fastener holes in Frame 51 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBBAD Sheet 02, View C.

a On Frame 51, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBBAD Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

b On Frame 51, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAD Sheet 02, View C.

c On Frame 51, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAD Sheet 02, View C.

d On Frame 51, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAD Sheet 02, View C.

9 On Frame 51, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

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10 Clean and deburr the cold expansion fastener holes in Frame 51 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 51, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBBAD Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

with

3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
19	Rivet	EN6081D6-08	Item 668
4	Rivet	EN6081D6-09	Item 669
14	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-5X	Item 765
3	Pin	DAN5-6-5Y	Item 785
24	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809
5	Nut	ASNA2528-3A	Item 908

use

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 51, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBBAD Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

13 On the Frame 51 flange, at STGR 35 LH, refer to Fig. A-GBBAD Sheet 03, Section C-C, countersink the one fastener hole.

14 On the Frame 51 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBBAD Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 51 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAD Sheet 04.

17 On the Frame 51 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 51, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 51 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

20 On the Frame 51 flange, at STGR 36 LH, refer to Fig. A-GBBAD Sheet 03, Section D-D, countersink the one fastener hole.

21 On the Frame 51 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBBAD Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 51 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAD

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Sheet 04.

24 On the Frame 51 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2	

25 Clean and deburr the new fastener holes in the Frame 51, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required	

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required	

26 On the Frame 51 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

27 On the Frame 51 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

4	Pin	DAN5-6-6X	Item 766	
2	Pin	DAN5-6-7X	Item 767	

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4	Collar	NSA5075-6	Item 806
4	Collar	DAN11-6X	Item 807
4	Pin	DAN5-6-3	Item 963

28 On the Frame 51 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBBAD Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

29 Transfer drill and ream the three holes from the Frame to the angles, Item 65 and Item 66, refer to Fig. A-GBBAD Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAD Sheet 04.

30 On the Frame 51 flange, at STGR 38 LH, remove:

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

31 Clean and deburr the new fastener holes in the Frame 51 and angles, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

32 On the Frame 51 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBBAD Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

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1	Pin	DAN5-6-8X	Item 768
1	Pin	DAN5-6-6Y	Item 786
1	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

33 On the Frame 51 flange, at STGR 39 LH, refer to Fig. A-GBBAD Sheet 03, Section F-F, countersink the one fastener hole.

34 On the Frame 51 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBBAD Sheet 03, Section F-F.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

35 On the Frame 51 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

36 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAD Sheet 04.

37 On the Frame 51 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

38 Clean and deburr the new fastener holes in the Frame 51, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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39 On the Frame 51 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-07	Item 657
1	Pin	DAN5-6-6X	Item 766
2	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(5) Subtask 531364-831-205-008 - Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 52 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D04R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
6	E5347001023600	1	WEB	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	2	RIVET	
567	EN6069D6-07	11	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	4	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	2	RIVET	
668	EN6081D6-08	30	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	8	PIN	
765	DAN5-6-5X	1	PIN	
766	DAN5-6-6X	8	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	13	COLLAR	
807	DAN11-6X	17	COLLAR	
808	ASNA2528-3	10	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	1	PIN	
865	DAN6-6-5	4	PIN	
866	DAN6-6-6	6	PIN	
963	DAN5-6-3	1	PIN	
964	DAN5-6-4	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBCAD Replacement of Webs and Angles at Frame 52	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBCAD Sheet 01, View B and Sections A-A and B-B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 52, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920200	Item (3)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 52, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

8	Rivet		Item (100)	Discard

3 From Frame 52, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 52, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347077420200	Item (5)	Discard
1	Support	D5347032200400	Item (103)	Retain
1	Angle		Item (116)	Retain
1	Section-Connecting	D5347065020200	Item (135)	Retain
1	Angle		Item (140)	Retain
1	Shim	D5347044920000	Item (142)	Retain
1	Shim	D5347044920600	Item (143)	Retain
	with			
65	Rivet		Item (100)	Discard

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(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 52.

Refer to NTM 51-10-01.

Refer to Fig. A-GBCAD Sheet 02, Views C, D and F.

1 On Frame 52, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 52, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 52, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 52, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBCAD Sheet 02 thru Fig. A-GBCAD Sheet 04.

1 On Frame 52, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBCAD Sheet 02, View C.

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1 Shear Web E5347001023600 Item 6

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 52 to the shear web, Item 6.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAD Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBCAD Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBCAD Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAD Sheet 04.

5 Transfer drill the tack hole from the Frame 52 between STGR 36 LH and 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 52, between STGR 34 LH and STGR 39 LH, remove:

1 Shear Web E5347001023600 Item 6

7 Clean and deburr the new fastener holes in Frame 52 and the shear web, Item 6, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBCAD Sheet 02, Views C, D and F.

a On Frame 52, between STGR 34 LH and STGR 39 LH, put in position:

1 Shear Web E5347001023600 Item 6

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b On Frame 52, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAD Sheet 02, View C.

c On Frame 52, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAD Sheet 02, View C.

d On the top flange of Frame 52, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAD Sheet 02, View D.

e On the top flange of Frame 52, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAD Sheet 02, View F.

9 On Frame 52, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001023600	Item 6

10 Clean and deburr the cold expansion fastener holes in Frame 52 and the shear web, Item 6, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 On the Shear Web, Item 6, at Frame 52, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBCAD Sheet 02, View C.

1	Shear Web	E5347001023600	Item 6

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
11	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
30	Rivet	EN6081D6-08	Item 668
7	Pin	DAN5-6-4X	Item 764
1	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
1	Pin	DAN5-6-3	Item 963

use

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 52, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBCAD Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 52, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBCAD Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

14 On the Frame 52 flange, at STGR 35 LH, refer to Fig. A-GBCAD Sheet 03, Section D-D, countersink the one fastener hole.

15 On the Frame 52 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBCAD Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 52 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBCAD Sheet 02, View C and Fig. A-GBCAD Sheet 03, Section D-D.

1	Angle	E5347001120000	Item 1

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17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBCAD Sheet 02, View C and Fig. A-GBCAD Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAD Sheet 04.

18 On the Frame 52 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 52, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 52 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBCAD Sheet 02, View C and Fig. A-GBCAD Sheet 03, Section D-D.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

21 On the Frame 52 flange, at STGR 36 LH, refer to Fig. A-GBCAD Sheet 03, Section E-E, countersink the one fastener hole.

22 On the Frame 52 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBCAD Sheet 03, Section E-E.

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1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 52 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBCAD Sheet 02, View C and Fig. A-GBCAD Sheet 03, Section E-E.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBCAD Sheet 02, View C and Fig. A-GBCAD Sheet 03, Section E-E.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAD Sheet 04.

25 On the Frame 52 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 52, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 52 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBCAD Sheet 02, View C and Fig. A-GBCAD Sheet 03, Section E-E.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657

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2	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-4	Item 964	
1	Collar	NSA5075-6	Item 806	

28 On the Frame 52 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBCAD Sheet 02, View C and Fig. A-GBCAD Sheet 03, Section F-F.

1	Support	D5347032200400	Item (103)	Retained at removal
1	Section-Connecting	D5347065020200	Item (135)	Retained at removal
1	Shim	D5347044920000	Item (142)	Retained at removal
1	Shim	D5347044920600	Item (143)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

6	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-4X	Item 764
6	Pin	DAN5-6-6X	Item 766
7	Collar	DAN11-6X	Item 807
10	Collar	NSA5075-6	Item 806
4	Pin	DAN6-6-5	Item 865
6	Pin	DAN6-6-6	Item 866

29 On the Frame 52 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBCAD Sheet 02, View C and Section C-C.

1	Angle		Item (116)	Retained at removal

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1	Angle		Item (140)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-6X	Item 766	
1	Pin	DAN5-6-6Y	Item 786	
2	Collar	DAN11-6X	Item 807	
1	Collar	DAN11-6Y	Item 809	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(6) Subtask 531364-831-206-008 - Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 53 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D04R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
8	E5347001027400	1	WEB	
36	E5347001124200	1	ANGLE	
68	E5347001420400	1	ANGLE	
80	E5347001420600	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	2	RIVET	
668	EN6081D6-08	17	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	4	PIN	
765	DAN5-6-5X	1	PIN	
766	DAN5-6-6X	2	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	18	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	9	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	10	PIN	
875	DAN6-6-5X	2	PIN	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBDAD Replacement of Webs and Angles at Frame 53	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBDAD Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 53, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the flange of Frame 53, between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 53, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 53, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078320200	Item (6)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347470120200	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 53.

Refer to NTM 51-10-01.

Refer to Fig. A-GBDAD Sheet 02, View C.

1 On Frame 53, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 53, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBDAD Sheet 02 thru Fig. A-GBDAD Sheet 04.

1 On Frame 53, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBDAD Sheet 02, View C.

1	Shear Web	E5347001027400	Item 8

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 53 to the shear web, Item 8.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAD Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBDAD Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBDAD Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAD Sheet 04.

5 Transfer drill the tack hole from the Frame 53 between STGR 36 LH and 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

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6 On Frame 53, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001027400	Item 8

7 Clean and deburr the new fastener holes in Frame 53 and the shear web, Item 8, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBDAD Sheet 02, View C.

a On Frame 53, between STGR 34 LH and STGR 39 LH, put in position:

1	Shear Web	E5347001027400	Item 8

b On Frame 53, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAD Sheet 02, View C.

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c On Frame 53, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAD Sheet 02, View C.

9 On Frame 53, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001027400	Item 8

10 Clean and deburr the cold expansion fastener holes in Frame 53 and the shear web, Item 8, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 On the Shear Web, Item 8, at Frame 53, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBDAD Sheet 02, View C.

1	Shear Web	E5347001027400	Item 8

with

3	Bolt	EN6115K3-3	Item 363

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5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
4	Pin	DAN5-6-4X	Item 764
13	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863
2	Pin	DAN6-6-5X	Item 875
1	Pin	DAN5-6-3	Item 963
2	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 53, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBDAD Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the Frame 53 flange, at STGR 35 LH, refer to Fig. A-GBDAD Sheet 03, Section C-C, countersink the one fastener hole.

14 On the Frame 53 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBDAD Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 53 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBDAD Sheet 02, View C and Fig. A-GBDAD Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBDAD Sheet 02, View C and Fig. A-GBDAD Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAD Sheet 04.

17 On the Frame 53 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 53, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 53 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBDAD Sheet 02, View C and Fig. A-GBDAD Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765

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1	Collar	DAN11-6X	Item 807

20 On the Frame 53 flange, at STGR 36 LH, refer to Fig. A-GBDAD Sheet 03, Section D-D, countersink the one fastener hole.

21 On the Frame 53 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBDAD Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 53 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBDAD Sheet 02, View C and Fig. A-GBDAD Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBDAD Sheet 02, View C and Fig. A-GBDAD Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAD Sheet 04.

24 On the Frame 53 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

25 Clean and deburr the new fastener holes in the Frame 53, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 53 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBDAD Sheet 02, View C and Fig. A-GBDAD Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-4	Item 964	
1	Collar	NSA5075-6	Item 806	

27 On the Frame 53 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBDAD Sheet 02, View C and Fig. A-GBDAD Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

28 On the Frame 53 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBDAD Sheet 02, View C and Section B-B.

1	Angle	E5347001420400	Item 68
1	Angle	E5347001420600	Item 80

29 Transfer drill and ream the three holes from the Frame to the angles, Item 68 and Item 80, refer to Fig. A-GBDAD Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAD Sheet 04.

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30 On the Frame 53 flange, at STGR 38 LH, remove:

1	Angle	E5347001420400	Item 68
1	Angle	E5347001420600	Item 80

31 Clean and deburr the new fastener holes in the Frame 53 and angles, Item 68 and Item 80, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

32 On the Frame 53 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBDAD Sheet 02, View C and Section B-B.

1	Angle	E5347001420400	Item 68
1	Angle	E5347001420600	Item 80

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-6X	Item 766
1	Pin	DAN5-6-5Y	Item 785
1	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

33 On the Frame 53 flange, at STGR 39 LH, refer to Fig. A-GBDAD Sheet 03, Section F-F, countersink the one fastener hole.

34 On the Frame 53 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBDAD Sheet 03, Section F-F.

1	Rivet	EN6069D5-06	Item 556

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

35 On the Frame 53 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBDAD Sheet 02, View C and Fig. A-GBDAD Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

36 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBDAD Sheet 02, View C and Fig. A-GBDAD Sheet 03, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBDAD Sheet 04.

37 On the Frame 53 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

38 Clean and deburr the new fastener holes in the Frame 53, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

39 On the Frame 53 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBDAD Sheet 02, View C and Fig. A-GBDAD Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-08	Item 668
2	Rivet	EN6081D5-07	Item 657

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(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(7) Subtask 531364-831-207-008 - Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 54 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D04R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
10	E5347001023400	1	WEB	
36	E5347001124200	1	ANGLE	
82	E5347001420800	1	ANGLE	
84	E5347001421000	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	6	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	1	PIN	
766	DAN5-6-6X	2	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	16	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	10	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	12	PIN	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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.

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NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBEAD Replacement of Webs and Angles at Frame 54	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBEAD Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 54, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 54, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

10	Rivet		Item (100)	Discard

3 From Frame 54, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

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4 From Frame 54, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078520200	Item (7)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347470120000	Item (140)	Discard
1	Angle	D5347046824000	Item (121)	Discard
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 54.

Refer to NTM 51-10-01.

Refer to Fig. A-GBEAD Sheet 02, Views C, D and F.

1 On Frame 54, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 54, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 54, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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4 On the top flange of Frame 54, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBEAD Sheet 02 thru Fig. A-GBEAD Sheet 04.

1 On Frame 54, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBEAD Sheet 02, View C.

1	Shear Web	E5347001023400	Item 10

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 54 to the shear web, Item 10.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAD Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBEAD Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBEAD Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAD Sheet 04.

5 Transfer drill the tack hole from the Frame 54 to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 54, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001023400	Item 10

7 Clean and deburr the fastener holes in Frame 54 and the shear web, Item 10, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBEAD Sheet 02, Views C, D and F.

a On Frame 54, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBEAD Sheet 02, View C.

1	Shear Web	E5347001023400	Item 10

b On Frame 54, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAD Sheet 02, View C.

c On Frame 54, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAD Sheet 02, View C.

d On the top flange of Frame 54, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAD Sheet 02, View D.

e On the top flange of Frame 54, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

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FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAD Sheet 02, View F.

9 On Frame 54, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001023400	Item 10

10 Clean and deburr the fastener holes in Frame 54 and the shear web, Item 10, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 54, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBEAD Sheet 02, View C.

1	Shear Web	E5347001023400	Item 10

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
6	Rivet	EN6081D6-06	Item 666

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17	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
10	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 54, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBEAD Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 54, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBEAD Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

14 On the Frame 54 flange, at STGR 35 LH, refer to Fig. A-GBEAD Sheet 03, Section C-C, countersink the one fastener hole.

15 On the Frame 54 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBEAD Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 54 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBEAD Sheet 02, View C and Fig. A-GBEAD Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBEAD Sheet 02, View C and Fig. A-GBEAD Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAD Sheet 04.

18 On the Frame 54 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 54, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 54 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBEAD Sheet 02, View C and Fig. A-GBEAD Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765

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1	Collar	DAN11-6X	Item 807

21 On the Frame 54 flange, at STGR 36 LH, refer to Fig. A-GBEAD Sheet 03, Section D-D, countersink the one fastener hole.

22 On the Frame 54 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBEAD Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 54 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBEAD Sheet 02, View C and Fig. A-GBEAD Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBEAD Sheet 02, View C and Fig. A-GBEAD Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAD Sheet 04.

25 On the Frame 54 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 54, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 54 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBEAD Sheet 02, View C and Fig. A-GBEAD Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

28 On the Frame 54 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBEAD Sheet 02, View C and Fig. A-GBEAD Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 54 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBEAD Sheet 02, View C and Section B-B.

1	Angle	E5347001420800	Item 82
1	Angle	E5347001421000	Item 84

30 Transfer drill and ream the three holes from the Frame to the angles, Item 82 and Item 84, refer to Fig. A-GBEAD Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAD Sheet 04.

31 On the Frame 54 flange, at STGR 38 LH, remove:

1	Angle	E5347001420800	Item 82
1	Angle	E5347001421000	Item 84

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32 Clean and deburr the new fastener holes in the Frame 54 and angles, Item 82 and Item 84, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

33 On the Frame 54 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBEAD Sheet 02, View C and Section B-B.

1	Angle	E5347001420800	Item 82
1	Angle	E5347001421000	Item 84

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-6X	Item 766
1	Pin	DAN5-6-6Y	Item 786
2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

34 On the Frame 54 flange, at STGR 39 LH, refer to Fig. A-GBEAD Sheet 03, Section F-F, countersink the one fastener hole.

35 On the Frame 54 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBEAD Sheet 03, Section F-F.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

36 On the Frame 54 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBEAD Sheet 02, View C and Fig. A-GBEAD Sheet 03, Section F-F.

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1	Angle	E5347001124200	Item 36

37 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBEAD Sheet 02, View C and Fig. A-GBEAD Sheet 03, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAD Sheet 04.

38 On the Frame 54 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

39 Clean and deburr the new fastener holes in the Frame 54, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

40 On the Frame 54 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBEAD Sheet 02, View C and Fig. A-GBEAD Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

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for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(8) Subtask 531364-831-208-008 - Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 55 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D04R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
12	E5347001020800	1	WEB	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	6	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	6	PIN	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	16	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	10	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	12	PIN	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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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.

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBFAD Replacement of Webs and Angles at Frame 55	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBFAD Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 55, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 55, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

10	Rivet		Item (100)	Discard

3 From Frame 55, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 55, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072120600	Item (8)	Discard
1	Support	D5347032200000	Item (101)	Retain

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1	Angle	D5347046823800	Item (120)	Retain
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 55.

Refer to NTM 51-10-01.

Refer to Fig. A-GBFAD Sheet 02, Views C, D and F.

1 On Frame 55, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 55, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 55, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

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(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBFAD Sheet 02 thru Fig. A-GBFAD Sheet 04.

1 On Frame 55, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBFAD Sheet 02, View C.

1	Shear Web	E5347001020800	Item 12

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 55 to the shear web, Item 12.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAD Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBFAD Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBFAD Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAD Sheet 04.

5 Transfer drill the tack hole from the Frame 55 to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 55, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001020800	Item 12

7 Clean and deburr the new fastener holes in Frame 55 and the shear web, Item 12, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBFAD Sheet 02, Views C, D and F.

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a On Frame 55, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBFAD Sheet 02, View C.

1	Shear Web	E5347001020800	Item 12

b On Frame 55, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAD Sheet 02, View C.

c On Frame 55, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAD Sheet 02, View C.

d On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAD Sheet 02, View D.

e On the top flange of Frame 55, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAD Sheet 02, View F.

9 On Frame 55, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001020800	Item 12

10 Clean and deburr the cold expansion fastener holes in Frame 55 and the shear web, Item 12, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 55, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBFAD Sheet 02, View C.

1	Shear Web	E5347001020800	Item 12

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
6	Rivet	EN6081D6-06	Item 666
17	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
10	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807

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8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 55, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBFAD Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBFAD Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

14 On the Frame 55 flange, at STGR 35 LH, refer to Fig. A-GBFAD Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 55 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBFAD Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 55 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

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17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAD Sheet 04.

18 On the Frame 55 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 55, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 55 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

21 On the Frame 55 flange, at STGR 36 LH, refer to Fig. A-GBFAD Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 55 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBFAD Sheet 03, Section B-B.

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1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 55 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAD Sheet 04.

25 On the Frame 55 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 55, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 55 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657

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3	Rivet	EN6081D6-07	Item 667	

28 On the Frame 55 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 55 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBFAD Sheet 02, View C.

1	Angle	D5347046823800	Item (120)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-5X	Item 765	
1	Pin	DAN5-6-5Y	Item 785	
2	Collar	DAN11-6X	Item 807	
1	Collar	DAN11-6Y	Item 809	

30 On the Frame 55 flange, at STGR 39 LH, refer to Fig. A-GBFAD Sheet 03, Section D-D, countersink the one fastener hole.

31 On the Frame 55 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBFAD Sheet 03, Section D-D.

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1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

32 On the Frame 55 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes form the Frame to the angle, Item 36, refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAD Sheet 04.

34 On the Frame 55 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

35 Clean and deburr the new fastener holes in the Frame 55, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

36 On the Frame 55 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657

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2	Rivet	EN6081D6-08	Item 668

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(9) Subtask 531364-831-209-008 - Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 56 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D04R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
14	E5347001021000	1	WEB	
16	E5347001120400	1	ANGLE	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	10	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	9	RIVET	
668	EN6081D6-08	24	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	2	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	24	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	10	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	17	PIN	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	2	PIN	
965	DAN5-6-5	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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

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For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBGAD Replacement of Webs and Angles at Frame 56	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBGAD Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 56, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347078720000	Item (9)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 56, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 34 LH and STGR 36 LH, remove:

12	Rivet		Item (100)	Discard

3 From Frame 56, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347078820000	Item (10)	Discard
	with			

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14	Rivet		Item (100)	Discard

4 From Frame 56, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078620200	Item (11)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046820600	Item (121)	Retain
1	Support	D5347068520100	Item (134)	Retain
	with			
64	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 56.

Refer to NTM 51-10-01.

Refer to Fig. A-GBGAD Sheet 02, Views C, D and F.

1 On Frame 56, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 56, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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4 On the top flange of Frame 56, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBGAD Sheet 02 thru Fig. A-GBGAD Sheet 04.

1 On Frame 56, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBGAD Sheet 02, View C.

1	Shear Web	E5347001021000	Item 14

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 56 to the shear web, Item 14.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAD Sheet 04.

4 Drill the additional 6 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBGAD Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBGAD Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAD Sheet 04.

5 Transfer drill the tack hole from the Frame 56 between STGR 36 LH and 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 56, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021000	Item 14

7 Clean and deburr the new fastener holes in Frame 56 and the shear web, Item 14, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBGAD Sheet 02, Views C, D and F.

a On Frame 56, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBGAD Sheet 02, View C.

1	Shear Web	E5347001021000	Item 14

b On Frame 56, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAD Sheet 02, View C.

c On Frame 56, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAD Sheet 02, View C.

d On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAD Sheet 02, View D.

e On the top flange of Frame 56, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

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FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAD Sheet 02, View F.

9 On Frame 56, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021000	Item 14

10 Clean and deburr the cold expansion fastener holes in Frame 56 and the shear web, Item 14, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 56, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBGAD Sheet 02, View C.

1	Shear Web	E5347001021000	Item 14

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
10	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
9	Rivet	EN6081D6-06	Item 666

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19	Rivet	EN6081D6-08	Item 668
7	Pin	DAN5-6-4X	Item 764
17	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
15	Pin	DAN6-6-3	Item 863
2	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 56, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBGAD Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBGAD Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

14 On the Frame 56 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBGAD Sheet 02, View C and Fig. A-GBGAD Sheet 03, Section A-A.

1	Angle	E5347001120400	Item 16

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15 Transfer drill and ream the holes from the Frame 56 and from STGR 35 LH to the angle, Item 16, refer to Fig. A-GBGAD Sheet 02, View C and Fig. A-GBGAD Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAD Sheet 04.

16 On the Frame 56 flange, at STGR 35 LH, remove:

1	Angle	E5347001120400	Item 16

17 Clean and deburr the new fastener holes in the Frame 56, STGR 35 LH and angle, Item 16, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

18 On the Frame 56 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBGAD Sheet 02, View C and Fig. A-GBGAD Sheet 03, Section A-A.

1	Angle	E5347001120400	Item 16

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Collar	NSA5075-6	Item 806
1	Pin	DAN5-6-5	Item 965

19 On the Frame 56 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBGAD Sheet 02, View C and Fig. A-GBGAD Sheet 03, Section B-B.

1	Support	D5347068520100	Item (134)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D6-08	Item 668	

20 On the Frame 56 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBGAD Sheet 02, View C and Fig. A-GBGAD Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

21 On the aft side of the Frame 56 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBGAD Sheet 02, View C.

1	Angle	D5347046820600	Item (121)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-5X	Item 765	
1	Pin	DAN5-6-5Y	Item 785	
2	Collar	DAN11-6X	Item 807	
1	Collar	DAN11-6Y	Item 809	

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22 On the Frame 56 flange, at STGR 39 LH, refer to Fig. A-GBGAD Sheet 03, Section D-D, countersink the one fastener hole.

23 On the Frame 56 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBGAD Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 56 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBGAD Sheet 02, View C and Fig. A-GBGAD Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBGAD Sheet 02, View C and Fig. A-GBGAD Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAD Sheet 04.

26 On the Frame 56 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

27 Clean and deburr the new fastener holes in the Frame 56, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 56 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBGAD Sheet 02, View C and Fig. A-GBGAD Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(10) Subtask 531364-831-210-008 - Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 57 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D04R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
18	E5347001021200	1	WEB	
20	E5347001123800	1	ANGLE	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	1	RIVET	
668	EN6081D6-08	17	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	19	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	10	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	11	PIN	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBHAD Replacement of Webs and Angles at Frame 57	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBHAD Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 57, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347081820000	Item (12)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 57, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

8	Rivet		Item (100)	Discard

3 From Frame 57, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347081720000	Item (13)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 57, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347081620400	Item (14)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046820200	Item (118)	Retain
	with			
57	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 57.

Refer to NTM 51-10-01.

Refer to Fig. A-GBHAD Sheet 02, Views C, D and F.

1 On Frame 57, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 57, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 57, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBHAD Sheet 02 thru Fig. A-GBHAD Sheet 04.

1 On Frame 57, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBHAD Sheet 02, View C.

1	Shear Web	E5347001021200	Item 18

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 57 to the shear web, Item 18.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAD

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Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBHAD Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBHAD Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAD Sheet 04.

5 Transfer drill the tack hole from the Frame 57 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 57, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021200	Item 18

7 Clean and deburr the new fastener holes in Frame 57 and the shear web, Item 18, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBHAD Sheet 02, Views C, D and F.

a On Frame 57, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBHAD Sheet 02, View C.

1	Shear Web	E5347001021200	Item 18

b On Frame 57, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAD Sheet 02, View C.

c On Frame 57, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAD Sheet 02, View C.

d On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAD Sheet 02, View D.

e On the top flange of Frame 57, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAD Sheet 02, View F.

9 On Frame 57, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021200	Item 18

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10 Clean and deburr the cold expansion fastener holes in Frame 57 and the shear web, Item 18, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 57, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBHAD Sheet 02, View C.

1	Shear Web	E5347001021200	Item 18

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
13	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863
1	Pin	DAN5-6-3	Item 963
2	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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12 Install 1 fastener in the flange of Frame 57, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBHAD Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBHAD Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

14 On the Frame 57 flange, at STGR 35 LH, refer to Fig. A-GBHAD Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 57 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBHAD Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 57 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from the STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAD Sheet 04.

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18 On the Frame 57 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 57, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 57 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

21 On the Frame 57 flange, at STGR 36 LH, refer to Fig. A-GBHAD Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 57 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBHAD Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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23 On the Frame 57 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section B-B.

1	Angle	E5347001123800	Item 20

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 20, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the two holes form the Frame to the angle, Item 20, refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAD Sheet 04.

25 On the Frame 57 flange, at STGR 36 LH, remove:

1	Angle	E5347001123800	Item 20

26 Clean and deburr the new fastener holes in the Frame 57, STGR 36 LH and angle, Item 20, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 57 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section B-B.

1	Angle	E5347001123800	Item 20

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-07	Item 667
1	Collar	NSA5075-6	Item 806
1	Pin	DAN5-6-4	Item 964

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28 On the Frame 57 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 57 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBHAD Sheet 02, View C.

1	Angle	D5347046820200	Item (118)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-5X	Item 765	
1	Pin	DAN5-6-5Y	Item 785	
2	Collar	DAN11-6X	Item 807	
1	Collar	DAN11-6Y	Item 809	

30 On the Frame 57 flange, at STGR 39 LH, refer to Fig. A-GBHAD Sheet 03, Section D-D, countersink the one fastener hole.

31 On the Frame 57 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBHAD Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

32 On the Frame 57 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBHAD Sheet 04.

34 On the Frame 57 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

35 Clean and deburr the new fastener holes in the Frame 57, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

36 On the Frame 57 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668

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(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(11) Subtask 531364-831-211-008 - Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 58 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D04R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
22	E5347001021400	1	WEB	
24	E5347001120600	1	ANGLE	
26	E5347001120800	1	ANGLE	
70	E5347001124400	1	ANGLE	
363	EN6115K3-3	5	BOLT	
364	EN6115K3-4	3	BOLT	
374	EN6115K3A4	2	BOLT	
463	EN6114K3-3	1	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
555	EN6069D5-05	3	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	14	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	3	RIVET	
666	EN6081D6-06	2	RIVET	
667	EN6081D6-07	4	RIVET	
668	EN6081D6-08	4	RIVET	(1)
670	EN6081D7-10	4	RIVET	
678	EN6081D7-08	6	RIVET	
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	20	COLLAR	
807	DAN11-6X	10	COLLAR	
808	ASNA2528-3	9	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	9	PIN	
908	ASNA2528-3A	2	NUT	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	5	PIN	
965	DAN5-6-5	2	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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.

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NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBJAD Replacement of Webs and Angles at Frame 58	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBJAD Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 58, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347082420000	Item (15)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 58, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 58, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347080520000	Item (16)	Discard

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with

13	Rivet		Item (100)	Discard

4 From Frame 58, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347083020400	Item (17)	Discard
1	Support	D5347032200600	Item (104)	Retain
1	Angle	D5347046820800	Item (125)	Retain

with

47	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 58.

Refer to NTM 51-10-01.

Refer to Fig. A-GBJAD Sheet 02, Views C, D and F.

1 On Frame 58, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 58, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 7 holes for the fasteners, Item 363, Item 364 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 On the top flange of Frame 58, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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4 On the top flange of Frame 58, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBJAD Sheet 02 thru Fig. A-GBJAD Sheet 04.

1 On Frame 58, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBJAD Sheet 02, View C.

1	Shear Web	E5347001021400	Item 22

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 58 to the shear web, Item 22.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAD Sheet 04.

4 Drill the additional 10 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBJAD Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBJAD Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAD Sheet 04.

5 Transfer drill the tack hole from the Frame 58 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 58, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021400	Item 22

7 Clean and deburr the new fastener holes in Frame 58 and the shear web, Item 22, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBJAD Sheet 02, Views C, D and F.

a On Frame 58, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBJAD Sheet 02, View C.

1	Shear Web	E5347001021400	Item 22

b On Frame 58, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAD Sheet 02, View C.

c On Frame 58, between STGR 36 LH and STGR 37 LH, cold expand the 5 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAD Sheet 02, View C.

d On Frame 58, between STGR 36 LH and STGR 37 LH, cold expand the 2 holes for the fasteners, Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAD Sheet 02, View C.

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e On the top flange of Frame 58, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAD Sheet 02, View D.

f On the top flange of Frame 58, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAD Sheet 02, View F.

9 On Frame 58, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021400	Item 22

10 Clean and deburr the cold expansion fastener holes in Frame 58 and the shear web, Item 22, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 58, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBJAD Sheet 02, View C.

1	Shear Web	E5347001021400	Item 22

with

4	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
2	Bolt	EN6115K3A4	Item 374
14	Rivet	EN6069D6-07	Item 567
7	Pin	DAN5-6-4X	Item 764
8	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-06	Item 666
4	Rivet	EN6081D6-08	Item 668
6	Rivet	EN6081D7-08	Item 678
13	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
7	Nut	ASNA2528-3	Item 808
8	Pin	DAN6-6-3	Item 863
2	Nut	ASNA2528-3A	Item 908

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5	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 58, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBJAD Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 58, at STGR 35 LH, install:

Refer to Fig. A-GBJAD Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

14 On the Frame 58 flange, at STGR 35 LH, refer to Fig. A-GBJAD Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 58 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBJAD Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 58 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBJAD Sheet 02, View C and Fig. A-GBJAD Sheet 03, Section A-A.

1	Angle	E5347001120600	Item 24

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17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 24, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 24, refer to Fig. A-GBJAD Sheet 02, View C and Fig. A-GBJAD Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAD Sheet 04.

18 On the Frame 58 flange, at STGR 35 LH, remove:

1	Angle	E5347001120600	Item 24

19 Clean and deburr the new fastener holes in the Frame 58, STGR 35 LH and angle, Item 24, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 58 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBJAD Sheet 02, View C and Fig. A-GBJAD Sheet 03, Section A-A.

1	Angle	E5347001120600	Item 24

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-06	Item 656
1	Pin	DAN5-6-5X	Item 765
2	Collar	NSA5075-6	Item 806
1	Collar	DAN11-6X	Item 807
2	Pin	DAN5-6-5	Item 965

21 On the Frame 58 flange, at STGR 36 LH, refer to Fig. A-GBJAD Sheet 03, Section B-B, countersink the one fastener hole.

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22 On the Frame 58 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBJAD Sheet 03, Section B-B.

2	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 58 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBJAD Sheet 02, View C and Fig. A-GBJAD Sheet 03, Section B-B.

1	Angle	E5347001120800	Item 26

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 26, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH to the angle, Item 26, refer to Fig. A-GBJAD Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAD Sheet 04.

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 26, to the Frame 58 flange, at STGR 36 LH, then transfer drill and ream the two holes from the Frame to the angle, Item 26, refer to Fig. A-GBJAD Sheet 03, View E.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAD Sheet 04.

26 On the Frame 58 flange, at STGR 36 LH, remove:

1	Angle	E5347001120800	Item 26

27 Clean and deburr the new fastener holes in the Frame 58, STGR 36 LH and angle, Item 26, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 58 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBJAD Sheet 02, View C and Fig. A-GBJAD Sheet 03, Section B-B.

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1	Angle	E5347001120800	Item 26	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
1	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	

29 On the Frame 58 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBJAD Sheet 02, View C and Fig. A-GBJAD Sheet 03, Section C-C.

1	Support	D5347032200600	Item (104)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Rivet	EN6081D7-10	Item 670	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

30 On the aft side of the Frame 58 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBJAD Sheet 02, View C.

1	Angle	D5347046820800	Item (125)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-5X	Item 765	

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1	Pin	DAN5-6-5Y	Item 785
2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

31 On the Frame 58 flange, at STGR 39 LH, refer to Fig. A-GBJAD Sheet 03, Section D-D, countersink the one fastener hole.

32 On the Frame 58 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBJAD Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 58 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBJAD Sheet 02, View C and Fig. A-GBJAD Sheet 03, Section D-D.

1	Angle	E5347001124400	Item 70

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 70, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 70, refer to Fig. A-GBJAD Sheet 02, View C and Fig. A-GBJAD Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBJAD Sheet 04.

35 On the Frame 58 flange, at STGR 39 LH, remove:

1	Angle	E5347001124400	Item 70

36 Clean and deburr the new fastener holes in the Frame 58, STGR 39 LH and angle, Item 70, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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37 On the Frame 58 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBJAD Sheet 02, View C and Fig. A-GBJAD Sheet 03, Section D-D.

1	Angle	E5347001124400	Item 70
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(12) Subtask 531364-831-212-008 - Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 59 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D03R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
365	EN6115K3-5	3	BOLT	

Kit 531364D04R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
28	E5347001021600	1	WEB	
30	E5347001121000	1	ANGLE	
32	E5347001121200	1	ANGLE	
72	E5347001124600	1	ANGLE	
363	EN6115K3-3	5	BOLT	
364	EN6115K3-4	2	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	20	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	20	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	7	RIVET	(1)
669	EN6081D6-09	3	RIVET	(2)
764	DAN5-6-4X	3	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	21	COLLAR	
807	DAN11-6X	6	COLLAR	
808	ASNA2528-3	11	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	8	PIN	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	6	PIN	
965	DAN5-6-5	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBKAD Replacement of Webs and Angles at Frame 59	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBKAD Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 59, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347089120000	Item (18)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 59, at STGR 35 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

5	Rivet		Item (100)	Discard

3 From Frame 59, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347089020000	Item (19)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 59, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347088920400	Item (20)	Discard
1	Support	D5347032201000	Item (106)	Retain
1	Angle	D5347046821000	Item (127)	Retain
	with			
59	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 59.

Refer to NTM 51-10-01.

Refer to Fig. A-GBKAD Sheet 02, Views C and D.

1 On Frame 59, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 59, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 7 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 59, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBKAD Sheet 02 thru Fig. A-GBKAD Sheet 04.

1 On Frame 59, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBKAD Sheet 02, View C.

1	Shear Web	E5347001021600	Item 28

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 59 to the shear web, Item 28.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAD Sheet 04.

4 Drill the additional 17 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBKAD Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBKAD Sheet

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02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAD Sheet 04.

5 Transfer drill the tack hole from the Frame 59 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 59, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021600	Item 28

7 Clean and deburr the new fastener holes in Frame 59 and the shear web, Item 28, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBKAD Sheet 02, Views C and D.

a On Frame 59, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBKAD Sheet 02, View C.

1	Shear Web	E5347001021600	Item 28

b On Frame 59, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAD Sheet 02, View C.

c On Frame 59, between STGR 36 LH and STGR 37 LH, cold expand the 7 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAD Sheet 02, View C.

d On the top flange of Frame 59, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAD Sheet 02, View D.

9 On Frame 59, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021600	Item 28

10 Clean and deburr the cold expansion fastener holes in Frame 59 and the shear web, Item 28, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 59, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBKAD Sheet 02, View C.

1	Shear Web	E5347001021600	Item 28

with

4	Bolt	EN6115K3-3	Item 363
2	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
16	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D6-06	Item 666
5	Rivet	EN6081D6-08	Item 668
3	Pin	DAN5-6-4X	Item 764
14	Collar	NSA5075-6	Item 806
3	Collar	DAN11-6X	Item 807

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6	Nut	ASNA2528-3	Item 808
8	Pin	DAN6-6-3	Item 863
6	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 59, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBKAD Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 59, at STGR 35 LH, install:

Refer to Fig. A-GBKAD Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

14 On the Frame 59 flange, at STGR 35 LH, refer to Fig. A-GBKAD Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 59 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBKAD Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 59 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section A-A.

1	Angle	E5347001121000	Item 30

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17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 30, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 30, refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAD Sheet 04.

18 On the Frame 59 flange, at STGR 35 LH, remove:

1	Angle	E5347001121000	Item 30

19 Clean and deburr the new fastener holes in the Frame 59, STGR 35 LH and angle, Item 30, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 59 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section A-A.

1	Angle	E5347001121000	Item 30

with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Collar	NSA5075-6	Item 806
3	Pin	DAN5-6-5	Item 965

21 On the Frame 59 flange, at STGR 36 LH, refer to Fig. A-GBKAD Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 59 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBKAD Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 59 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section B-B.

1	Angle	E5347001121200	Item 32

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 32, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 32, refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAD Sheet 04.

25 On the Frame 59 flange, at STGR 36 LH, remove:

1	Angle	E5347001121200	Item 32

26 Clean and deburr the new fastener holes in the Frame 59, STGR 36 LH and angle, Item 32, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 59 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section B-B.

1	Angle	E5347001121200	Item 32

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D6-07	Item 667

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28 On the Frame 59 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section C-C.

1	Support	D5347032201000	Item (106)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Bolt	EN6115K3-5	Item 365	
3	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
3	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 59 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBKAD Sheet 02, View C.

1	Angle	D5347046821000	Item (127)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-5X	Item 765	
1	Pin	DAN5-6-5Y	Item 785	
2	Collar	DAN11-6X	Item 807	
1	Collar	DAN11-6Y	Item 809	

30 On the Frame 59 flange, at STGR 39 LH, refer to Fig. A-GBKAD Sheet 03, Section D-D, countersink the one fastener hole.

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31 On the Frame 59 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBKAD Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

32 On the Frame 59 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section D-D.

1	Angle	E5347001124600	Item 72

33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 72, to the STGR 39 LH, then transfer drill and ream the other hole from the STGR 39 LH and the three holes from the Frame to the angle, Item 72, refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBKAD Sheet 04.

34 On the Frame 59 flange, at STGR 39 LH, remove:

1	Angle	E5347001124600	Item 72

35 Clean and deburr the new fastener holes in the Frame 59, STGR 39 LH and angle, Item 72, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

36 On the Frame 59 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section D-D.

1	Angle	E5347001124600	Item 72

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(13) Subtask 531364-831-213-008 - Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 60 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D04R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
34	E5347001021800	1	WEB	
38	E5347001121600	1	ANGLE	
40	E5347001121800	1	ANGLE	
363	EN6115K3-3	5	BOLT	
365	EN6115K3-5	8	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
567	EN6069D6-07	20	RIVET	
656	EN6081D5-06	41	RIVET	
666	EN6081D6-06	25	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	4	RIVET	(2)
764	DAN5-6-4X	4	PIN	
765	DAN5-6-5X	1	PIN	
806	NSA5075-6	19	COLLAR	
807	DAN11-6X	5	COLLAR	
808	ASNA2528-3	14	NUT	
864	DAN6-6-4	5	PIN	
865	DAN6-6-5	5	PIN	
963	DAN5-6-3	1	PIN	
964	DAN5-6-4	4	PIN	
965	DAN5-6-5	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)

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ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBLAD Replacement of Webs and Angles at Frame 60	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBLAD Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural

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parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 60, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347085020000	Item (21)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 60, at STGR 35 LH and from the frame flange between STGR 34 LH and STGR 35 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 60, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347085120000	Item (22)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 60, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347093120600	Item (23)	Discard
1	Support	D5347032201200	Item (108)	Retain
1	Angle	D5347046821200	Item (128)	Retain
1	Section-Connecting	D5347065420400	Item (136)	Retain
1	Shim	D5347044920000	Item (142)	Retain
1	Shim	D5347044920600	Item (143)	Retain
	with			
77	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 60.

Refer to NTM 51-10-01.

Refer to Fig. A-GBLAD Sheet 02, Views C and D.

1 On Frame 60, at STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 60, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 60, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBLAD Sheet 02 thru Fig. A-GBLAD Sheet 04.

1 On Frame 60, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBLAD Sheet 02, View C.

1	Shear Web	E5347001021800	Item 34

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 60 to the shear web, Item 34.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAD Sheet 04.

4 Drill the additional 38 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBLAD Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBLAD Sheet 02.

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NOTE: For the hole diameters, refer to the table on Fig. A-GBLAD Sheet 04.

5 Transfer drill the tack hole from the Frame 60 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 60, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021800	Item 34

7 Clean and deburr the new fastener holes in Frame 60 and the shear web, Item 34, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBLAD Sheet 02, Views C and D.

a On Frame 60, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBLAD Sheet 02, View C.

1	Shear Web	E5347001021800	Item 34

b On Frame 60, at STGR 35 LH, cold expand the 4 holes for the fasteners, Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAD Sheet 02, View C.

c On Frame 60, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAD Sheet 02, View C.

d On the top flange of Frame 60, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAD Sheet 02, View D.

9 On Frame 60, between STGR 34 LH and STGR 39 LH, wet install:

1	Shear Web	E5347001021800	Item 34

10 Clean and deburr the cold expansion fastener holes in Frame 60 and the shear web, Item 34, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 60, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBLAD Sheet 02, View C.

1	Shear Web	E5347001021800	Item 34

with

5	Bolt	EN6115K3-3	Item 363
20	Rivet	EN6069D6-07	Item 567
37	Rivet	EN6081D5-06	Item 656
25	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
4	Pin	DAN5-6-4X	Item 764
4	Collar	DAN11-6X	Item 807
5	Nut	ASNA2528-3	Item 808

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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12 On the top flange of Frame 60, at STGR 35 LH, install:

Refer to Fig. A-GBLAD Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

13 On the Frame 60 flange, at STGR 35 LH, refer to Fig. A-GBLAD Sheet 03, Section B-B, countersink the one fastener hole.

14 On the Frame 60 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBLAD Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 60 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBLAD Sheet 02, View C and Fig. A-GBLAD Sheet 03, Section B-B.

1	Angle	E5347001121600	Item 38

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 38, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH to the angle, Item 38, refer to Fig. A-GBLAD Sheet 02, View C and Fig. A-GBLAD Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAD Sheet 04.

17 On the Frame 60 flange, at STGR 35 LH, remove:

1	Angle	E5347001121600	Item 38

18 Clean and deburr the new fastener holes in the STGR 35 LH and angle, Item 38, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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19 On the Frame 60 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBLAD Sheet 02, View C and Fig. A-GBLAD Sheet 03, Section B-B.

1	Angle	E5347001121600	Item 38
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
4	Bolt	EN6115K3-5	Item 365
2	Rivet	EN6081D5-06	Item 656
4	Nut	ASNA2528-3	Item 808

20 On the Frame 60 flange, at STGR 36 LH, refer to Fig. A-GBLAD Sheet 03, Section C-C, countersink the one fastener hole.

21 On the Frame 60 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBLAD Sheet 03, Section C-C.

1	Rivet	EN6069D5-05	Item 555
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 60 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBLAD Sheet 02, View C and Fig. A-GBLAD Sheet 03, Section C-C.

1	Angle	E5347001121800	Item 40

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 40, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 40, refer to Fig. A-GBLAD Sheet 02, View C and Fig. A-GBLAD Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAD Sheet 04.

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24 On the Frame 60 flange, at STGR 36 LH, remove:

1	Angle	E5347001121800	Item 40

25 Clean and deburr the new fastener holes in the Frame 60, STGR 36 LH and angle, Item 40, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 60 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBLAD Sheet 02, View C and Fig. A-GBLAD Sheet 03, Section C-C.

1	Angle	E5347001121800	Item 40

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D6-07	Item 667

27 On the Frame 60 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBLAD Sheet 02, View C and Fig. A-GBLAD Sheet 03, Section D-D.

1	Support	D5347032201200	Item (108)	Retained at removal
1	Section-Connecting	D5347065420400	Item (136)	Retained at removal
1	Shim	D5347044920000	Item (142)	Retained at removal
1	Shim	D5347044920600	Item (143)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	
19	Collar	NSA5075-6	Item 806	
4	Nut	ASNA2528-3	Item 808	
5	Pin	DAN6-6-4	Item 864	
5	Pin	DAN6-6-5	Item 865	
1	Pin	DAN5-6-3	Item 963	
4	Pin	DAN5-6-4	Item 964	
4	Pin	DAN5-6-5	Item 965	

28 On the aft side of the Frame 60 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBLAD Sheet 02, View C.

1	Angle	D5347046821200	Item (128)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(14) Subtask 531364-831-214-008 - Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 61 from Stringer 33 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D04R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
42	E5347001022000	1	WEB	
44	E5347001122000	1	ANGLE	
46	E5347001122200	1	ANGLE	
48	E5347001122400	1	ANGLE	
74	E5347001124800	1	ANGLE	
363	EN6115K3-3	7	BOLT	
364	EN6115K3-4	3	BOLT	
365	EN6115K3-5	4	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	4	RIVET	
567	EN6069D6-07	24	RIVET	
656	EN6081D5-06	36	RIVET	
657	EN6081D5-07	2	RIVET	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
666	EN6081D6-06	23	RIVET	
667	EN6081D6-07	10	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	6	RIVET	(2)
763	DAN5-6-3X	4	PIN	
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
807	DAN11-6X	13	COLLAR	
808	ASNA2528-3	15	NUT	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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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.

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBMAD Replacement of Webs and Angles at Frame 61	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBMAD Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 61, between STGR 33 LH and STGR 34 LH, remove:

1	Clip	D5347091620200	Item (24)	Discard
	with			
12	Rivet		Item (100)	Discard
	or			
13	Rivet		Item (100)	Discard

NOTE: Depending on installation on aircraft.

2 From Frame 61, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347090620000	Item (25)	Discard
	with			
13	Rivet		Item (100)	Discard

3 From the top flange of Frame 61, between STGR 34 LH and STGR 35 LH and from the frame flange between STGR 34 LH and STGR 35 LH, remove:

11	Rivet		Item (100)	Discard

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4 From Frame 61, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347090720000	Item (26)	Discard
	with			
13	Rivet		Item (100)	Discard

5 From Frame 61, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347090820400	Item (27)	Discard
1	Support	D5347032201600	Item (109)	Retain
1	Angle	D5347046821400	Item (130)	Retain
	with			
65	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 61.

Refer to NTM 51-10-01.

Refer to Fig. A-GBMAD Sheet 02, Views C and E.

1 On Frame 61, at STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 61, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 61, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBMAD Sheet 02 thru Fig. A-GBMAD Sheet 04.

1 On Frame 61, between STGR 33 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBMAD Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 61 to the shear web, Item 42.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAD Sheet 04.

4 Drill the additional 31 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBMAD Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBMAD Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAD Sheet 04.

5 Transfer drill the tack hole from the Frame 61 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 61, between STGR 33 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022000	Item 42

7 Clean and deburr the new fastener holes in Frame 61 and the shear web, Item 42, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

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Refer to Fig. A-GBMAD Sheet 02, Views C and E.

a On Frame 61, between STGR 33 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBMAD Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

b On Frame 61, at STGR 35 LH, cold expand the 4 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAD Sheet 02, View C.

c On Frame 61, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAD Sheet 02, View C.

d On the top flange of Frame 61, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAD Sheet 02, View E.

9 On Frame 61, between STGR 33 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022000	Item 42

10 Clean and deburr the cold expansion fastener holes in Frame 61 and the shear web, Item 42, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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11 At Frame 61, between STGR 33 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBMAD Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42
	with		
6	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
24	Rivet	EN6069D6-07	Item 567
28	Rivet	EN6081D5-06	Item 656
22	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
6	Collar	DAN11-6X	Item 807
9	Nut	ASNA2528-3	Item 808
	use		
Polysulfide Sealant - General Purpose Brushable		06AAA1	As required

12 On the top flange of Frame 61, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBMAD Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 61, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBMAD Sheet 02, View E.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

14 On the Frame 61 flange, at STGR 34 LH, refer to Fig. A-GBMAD Sheet 03, Section A-A, countersink the one fastener hole.

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15 On the Frame 61 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBMAD Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 61 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section A-A.

1	Angle	E5347001122000	Item 44

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 44, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH and the three holes from the Frame to the angle, Item 44, refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAD Sheet 04.

18 On the Frame 61 flange, at STGR 34 LH, remove:

1	Angle	E5347001122000	Item 44

19 Clean and deburr the new fastener holes in the Frame 61, STGR 34 LH and angle, Item 44, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 61 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section A-A.

1	Angle	E5347001122000	Item 44

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

If necessary, close the rivet hole in the frame flange at STGR 34 LH with:

1	Rivet	EN6081D6-06	Item 666

NOTE: Depending on installation on aircraft.

21 On the Frame 61 flange, at STGR 35 LH, refer to Fig. A-GBMAD Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 61 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBMAD Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 61 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section B-B.

1	Angle	E5347001122200	Item 46

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 46, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the four holes from the Frame to the angle, Item 46, refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAD Sheet 04.

25 On the Frame 61 flange, at STGR 35 LH, remove:

1	Angle	E5347001122200	Item 46

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26 Clean and deburr the new fastener holes in the Frame 61, STGR 35 LH and angle, Item 46, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 61 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section B-B.

1	Angle	E5347001122200	Item 46

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
4	Rivet	EN6081D6-07	Item 667

28 On the Frame 61 flange, at STGR 36 LH, refer to Fig. A-GBMAD Sheet 03, Section C-C, countersink the one fastener hole.

29 On the Frame 61 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBMAD Sheet 03, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

30 On the Frame 61 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section C-C.

1	Angle	E5347001122400	Item 48

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31 Transfer drill and ream one new hole from the pilot hole of the angle, Item 48, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 48, refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAD Sheet 04.

32 On the Frame 61 flange, at STGR 36 LH, remove:

1	Angle	E5347001122400	Item 48

33 Clean and deburr the new fastener holes in the Frame 61, STGR 36 LH and angle, Item 48, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

34 On the Frame 61 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section C-C.

1	Angle	E5347001122400	Item 48

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D5-07	Item 657
3	Rivet	EN6081D6-07	Item 667

35 On the Frame 61 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section D-D.

1	Support	D5347032201600	Item (109)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	
4	Pin	DAN5-6-3X	Item 763	
4	Collar	DAN11-6X	Item 807	
4	Nut	ASNA2528-3	Item 808	

36 On the Frame 61 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBMAD Sheet 02, View C.

1	Angle	D5347046821400	Item (130)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

37 On the Frame 61 flange, at STGR 39 LH, refer to Fig. A-GBMAD Sheet 03, Section E-E, countersink the one fastener hole.

38 On the Frame 61 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBMAD Sheet 03, Section E-E.

1	Rivet	EN6069D5-05	Item 555	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

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39 On the Frame 61 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section E-E.

1	Angle	E5347001124800	Item 74

40 Transfer drill and ream one new hole from the pilot hole of the angle, Item 74, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the four holes from the Frame to the angle, Item 74, refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section E-E.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAD Sheet 04.

41 On the Frame 61 flange, at STGR 39 LH, remove:

1	Angle	E5347001124800	Item 74

42 Clean and deburr the new fastener holes in the Frame 61, STGR 39 LH and angle, Item 74, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

43 On the Frame 61 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section E-E.

1	Angle	E5347001124800	Item 74

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

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(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(15) Subtask 531364-831-215-008 - Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 62 from Stringer 32 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D04R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
50	E5347001022200	1	WEB	
52	E5347001122600	1	ANGLE	
54	E5347001122800	1	ANGLE	
56	E5347001123000	1	ANGLE	
58	E5347001123200	1	ANGLE	
76	E5347001125000	1	ANGLE	
363	EN6115K3-3	7	BOLT	
364	EN6115K3-4	3	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
365	EN6115K3-5	4	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	5	RIVET	
567	EN6069D6-07	28	RIVET	
568	EN6069D6-08	1	RIVET	
656	EN6081D5-06	45	RIVET	
657	EN6081D5-07	7	RIVET	
666	EN6081D6-06	21	RIVET	
667	EN6081D6-07	8	RIVET	
668	EN6081D6-08	16	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	5	PIN	
765	DAN5-6-5X	3	PIN	
806	NSA5075-6	9	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	15	NUT	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	
965	DAN5-6-5	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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.

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NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBNAD Replacement of Webs and Angles at Frame 62	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBNAD Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 62, between STGR 32 LH and STGR 33 LH, remove:

1	Clip	D5347093420200	Item (28)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From Frame 62, between STGR 33 LH and STGR 34 LH, remove:

1	Clip	D5347084020000	Item (29)	Discard
	with			
13	Rivet		Item (100)	Discard

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3 From Frame 62, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347084120000	Item (30)	Discard
	with			
11	Rivet		Item (100)	Discard

4 From the top flange of Frame 62, at STGR 34 LH and from the frame flange between STGR 32 LH and STGR 35 LH, remove:

13	Rivet		Item (100)	Discard
	or			
14	Rivet		Item (100)	Discard

NOTE: Depending on installation on aircraft.

5 From Frame 62, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347084220000	Item (31)	Discard
	with			
11	Rivet		Item (100)	Discard

6 From Frame 62, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347084820400	Item (32)	Discard
1	Support	D5347032201800	Item (111)	Retain
1	Angle	D5347046821600	Item (131)	Retain
	with			
58	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 62.

Refer to NTM 51-10-01.

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 03, View F.

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1 On Frame 62, between STGR 34 LH and STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 62, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBNAD Sheet 02 thru Fig. A-GBNAD Sheet 06.

1 On Frame 62, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBNAD Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 62 to the shear web, Item 50.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAD Sheet 06.

4 On Frame 62, between STGR 34 LH and STGR 37 LH, drill the additional 42 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBNAD Sheet 03, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBNAD Sheet 03.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAD Sheet 06.

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5 On Frame 62, between STGR 38 LH and STGR 39 LH, drill the additional rivet hole to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBNAD Sheet 03, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBNAD Sheet 03.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAD Sheet 06.

6 Transfer drill the tack hole from the Frame 62 between STGR 36 LH and 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

7 On Frame 62, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022200	Item 50

8 Clean and deburr the new fastener holes in Frame 62 and shear web, Item 50, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 03, View F.

a On Frame 62, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBNAD Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

b On Frame 62, between STGR 34 LH and STGR 35 LH, cold expand the 4 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAD Sheet 02, View C.

c On Frame 62, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAD Sheet 02, View C.

d On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAD Sheet 03, View F.

10 On Frame 62, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022200	Item 50

11 Clean and deburr the cold expansion fastener holes in Frame 62 and shear web, Item 50, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 62, between STGR 32 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBNAD Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

with

6	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
28	Rivet	EN6069D6-07	Item 567
1	Rivet	EN6069D6-08	Item 568
35	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D5-07	Item 657

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20	Rivet	EN6081D6-06	Item 666
1	Rivet	EN6081D6-07	Item 667
13	Rivet	EN6081D6-08	Item 668
5	Pin	DAN5-6-4X	Item 764
4	Collar	NSA5075-6	Item 806
5	Collar	DAN11-6X	Item 807
9	Nut	ASNA2528-3	Item 808
1	Pin	DAN5-6-3	Item 963
3	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 On the flange of Frame 62, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBNAD Sheet 03, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBNAD Sheet 03, View F.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

15 On the Frame 62 flange, at STGR 33 LH, refer to Fig. A-GBNAD Sheet 04, Section A-A, countersink the one fastener hole.

16 On the Frame 62 flange, at STGR 33 LH, close the rivet hole in STGR 33 LH with:

Refer to Fig. A-GBNAD Sheet 04, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 62 flange, at STGR 33 LH, put in position:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section A-A.

1	Angle	E5347001122600	Item 52

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 52, to the STGR 33 LH, then transfer drill and ream the other hole from STGR 33 LH and the three holes from the Frame to the angle, Item 52, refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAD Sheet 06.

19 On the Frame 62 flange, at STGR 33 LH, remove:

1	Angle	E5347001122600	Item 52

20 Clean and deburr the new fastener holes in the Frame 62, STGR 33 LH and angle, Item 52, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 62 flange, at STGR 33 LH, wet install:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section A-A.

1	Angle	E5347001122600	Item 52

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Collar	NSA5075-6	Item 806

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1	Pin	DAN5-6-5	Item 965

If necessary, close the rivet hole in the frame flange at STGR 33 LH with:

1	Rivet	EN6081D6-06	Item 666

NOTE: Depending on installation on aircraft.

22 On the Frame 62 flange, at STGR 34 LH, refer to Fig. A-GBNAD Sheet 04, Section B-B, countersink the one fastener hole.

23 On the Frame 62 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBNAD Sheet 04, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 62 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section B-B.

1	Angle	E5347001122800	Item 54

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 54, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH and the three holes from the Frame to the angle, Item 54, refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAD Sheet 06.

26 On the Frame 62 flange, at STGR 34 LH, remove:

1	Angle	E5347001122800	Item 54

27 Clean and deburr the new fastener holes in the Frame 62, STGR 34 LH and angle, Item 54, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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28 On the Frame 62 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section B-B.

1	Angle	E5347001122800	Item 54
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

29 On the Frame 62 flange, at STGR 34 LH, install:

Refer to Fig. A-GBNAD Sheet 02, View C.

1	Rivet	EN6081D6-07	Item 667

30 On the Frame 62 flange, at STGR 35 LH, refer to Fig. A-GBNAD Sheet 04, Section C-C, countersink the one fastener hole.

31 On the Frame 62 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBNAD Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

32 On the Frame 62 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section C-C.

1	Angle	E5347001123000	Item 56

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33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 56, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the five holes from the Frame to the angle, Item 56, refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAD Sheet 06.

34 On the Frame 62 flange, at STGR 35 LH, remove:

1	Angle	E5347001123000	Item 56

35 Clean and deburr the new fastener holes in the Frame 62, STGR 35 LH and angle, Item 56, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

36 On the Frame 62 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section C-C.

1	Angle	E5347001123000	Item 56

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

37 On the Frame 62 flange, at STGR 36 LH, refer to Fig. A-GBNAD Sheet 04, Section D-D, countersink the one fastener hole.

38 On the Frame 62 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBNAD Sheet 04, Section D-D.

1	Rivet	EN6069D5-05	Item 555

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

39 On the Frame 62 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section D-D.

1	Angle	E5347001123200	Item 58

40 Transfer drill and ream one new hole from the pilot hole of the angle, Item 58, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 58, refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAD Sheet 06.

41 On the Frame 62 flange, at STGR 36 LH, remove:

1	Angle	E5347001123200	Item 58

42 Clean and deburr the new fastener holes in the Frame 62, STGR 36 LH and angle, Item 58, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

43 On the Frame 62 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section D-D.

1	Angle	E5347001123200	Item 58

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

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44 On the Frame 62 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 05, Section E-E.

1	Support	D5347032201800	Item (111)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	

45 On the aft side of the Frame 62 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBNAD Sheet 02, View C.

1	Angle	D5347046821600	Item (131)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

46 On the Frame 62 flange, at STGR 39 LH, refer to Fig. A-GBNAD Sheet 05, Section F-F, countersink the one fastener hole.

47 On the Frame 62 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBNAD Sheet 05, Section F-F.

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1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

48 On the Frame 62 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 05, Section F-F.

1	Angle	E5347001125000	Item 76

49 Transfer drill and ream one new hole from the pilot hole of the angle, Item 76, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 76, refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 05, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBNAD Sheet 06.

50 On the Frame 62 flange, at STGR 39 LH, remove:

1	Angle	E5347001125000	Item 76

51 Clean and deburr the new fastener holes in the Frame 62, STGR 39 LH and angle, Item 76, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

52 On the Frame 62 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 05, Section F-F.

1	Angle	E5347001125000	Item 76

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656

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2	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(16) Subtask 531364-831-216-008 - Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 63 from Stringer 32 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D04R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
60	E5347001022400	1	WEB	
62	E5347001123400	1	ANGLE	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
64	E5347001123600	2	ANGLE	
78	E5347001125200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
365	EN6115K3-5	8	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	4	RIVET	
567	EN6069D6-07	23	RIVET	
568	EN6069D6-08	1	RIVET	
656	EN6081D5-06	43	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	22	RIVET	
667	EN6081D6-07	6	RIVET	
668	EN6081D6-08	12	RIVET	(1)
669	EN6081D6-09	7	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	8	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	13	NUT	
963	DAN5-6-3	8	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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.

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NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBPAD Replacement of Webs and Angles at Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBPAD Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 63, at STGR 33 LH, remove:

1	Shim	D5347032020200	Item (132)	Retain
1	Sheet-Support	D5347109620000	Item (133)	Retain
	with			
7	Rivet		Item (100)	Discard

2 From Frame 63, between STGR 32 LH and STGR 34 LH, remove:

1	Clip	D5347082820000	Item (33)	Discard
	with			

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21	Rivet		Item (100)	Discard

3 From the top flange of Frame 63, at STGR 34 LH and from the frame flange between STGR 33 LH and STGR 34 LH, remove:

5	Rivet		Item (100)	Discard

4 From Frame 63, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347079220000	Item (34)	Discard
	with			
10	Rivet		Item (100)	Discard

5 From Frame 63, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347079920000	Item (35)	Discard
	with			
11	Rivet		Item (100)	Discard

6 From Frame 63, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347082920200	Item (36)	Discard
1	Support	D5347032202000	Item (114)	Retain
1	Angle	D5347046821800	Item (115)	Retain
	with			
54	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 63.

Refer to NTM 51-10-01.

Refer to Fig. A-GBPAD Sheet 02, Views C and D.

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1 On Frame 63, at STGR 34 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 63, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 8 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 63, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBPAD Sheet 02 thru Fig. A-GBPAD Sheet 06.

1 On Frame 63, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBPAD Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 63 to the shear web, Item 60.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAD Sheet 06.

4 On Frame 63, between STGR 34 LH and STGR 37 LH, drill the additional 41 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBPAD Sheet 03, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBPAD Sheet 03.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAD Sheet 06.

5 Transfer drill the tack hole from the Frame 63 between STGR 36 LH and STGR 37 LH, to the shear web with 6.100mm (0.2401in) dia. drill.

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6 On Frame 63, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022400	Item 60

7 Clean and deburr the new fastener holes in Frame 63 and the shear web, Item 60, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBPAD Sheet 02, Views C and D.

a On Frame 63, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBPAD Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

b On Frame 63, at STGR 34 LH, cold expand the 4 holes for the fasteners, Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAD Sheet 02, View C.

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c On Frame 63, between STGR 36 LH and STGR 37 LH, cold expand the 8 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAD Sheet 02, View C.

d On the top flange of Frame 63, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAD Sheet 02, View D.

9 On Frame 63, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022400	Item 60

10 Clean and deburr the cold expansion fastener holes in Frame 63 and the shear web, Item 60, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 63, between STGR 32 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBPAD Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

with

4	Bolt	EN6115K3-3	Item 363
23	Rivet	EN6069D6-07	Item 567
1	Rivet	EN6069D6-08	Item 568
35	Rivet	EN6081D5-06	Item 656
22	Rivet	EN6081D6-06	Item 666
10	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
6	Collar	DAN11-6X	Item 807
4	Nut	ASNA2528-3	Item 808

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 On the Frame 63 flange, at STGR 33 LH, wet install:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 04, Section A-A.

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1	Shim	D5347032020200	Item (132)	Retained at removal
1	Sheet-Support	D5347109620000	Item (133)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

3	Rivet	EN6081D6-09	Item 669
4	Collar	NSA5075-6	Item 806
4	Pin	DAN5-6-3	Item 963

13 On the Frame 63 flange, at STGR 34 LH, refer to Fig. A-GBPAD Sheet 04, Section B-B, countersink the one fastener hole.

14 On the Frame 63 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBPAD Sheet 04, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 63 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 04, Section B-B.

1	Angle	E5347001123400	Item 62

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 62, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH to the angle, Item 62, refer to Fig. A-GBPAD Sheet 04, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAD Sheet 06.

17 On the Frame 63 flange, at STGR 34 LH, remove:

1	Angle	E5347001123400	Item 62

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18 Clean and deburr the new fastener holes in the STGR 34 LH and angle, Item 62, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 63 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 04, Section B-B.

1	Angle	E5347001123400	Item 62

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
2	Rivet	EN6081D5-06	Item 656
4	Nut	ASNA2528-3	Item 808

20 On the top flange of Frame 63, at STGR 35 LH, install:

Refer to Fig. A-GBPAD Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

21 On the Frame 63 flange, at STGR 35 LH, refer to Fig. A-GBPAD Sheet 04, Section C-C, countersink the one fastener hole.

22 On the Frame 63 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBPAD Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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23 On the Frame 63 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 64, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the five holes from the Frame to the angle, Item 64, refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAD Sheet 06.

25 On the Frame 63 flange, at STGR 35 LH, remove:

1	Angle	E5347001123600	Item 64

26 Clean and deburr the new fastener holes in the Frame 63, STGR 35 LH and angle, Item 64, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 63 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

28 On the Frame 63 flange, at STGR 36 LH, refer to Fig. A-GBPAD Sheet 04, Section C-C, countersink the one fastener hole.

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29 On the Frame 63 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBPAD Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

30 On the Frame 63 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

31 Transfer drill and ream one new hole from the pilot hole of the angle, Item 64, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 64, refer to Fig. A-GBPAD Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAD Sheet 06.

32 On the Frame 63 flange, at STGR 36 LH, remove:

1	Angle	E5347001123600	Item 64

33 Clean and deburr the new fastener holes in the Frame 63, STGR 36 LH and angle, Item 64, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

34 On the Frame 63 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	

35 On the Frame 63 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 05, Section D-D.

1	Support	D5347032202000	Item (114)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
4	Rivet	EN6081D6-09	Item 669
4	Collar	NSA5075-6	Item 806
4	Nut	ASNA2528-3	Item 808
4	Pin	DAN5-6-3	Item 963

36 On the Frame 63 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBPAD Sheet 02, View C.

1	Angle	D5347046821800	Item (115)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

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37 On the Frame 63 flange, at STGR 39 LH, refer to Fig. A-GBPAD Sheet 05, Section E-E, countersink the one fastener hole.

38 On the Frame 63 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBPAD Sheet 05, Section E-E.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

39 On the Frame 63 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 05, Section E-E.

1	Angle	E5347001125200	Item 78

40 Transfer drill and ream one new hole from the pilot hole of the angle, Item 78, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 78, refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 05, Section E-E.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAD Sheet 06.

41 On the Frame 63 flange, at STGR 39 LH, remove:

1	Angle	E5347001125200	Item 78

42 Clean and deburr the new fastener holes in the Frame 63, STGR 39 LH and angle, Item 78, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

43 On the Frame 63 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 05, Section E-E.

1	Angle	E5347001125200	Item 78

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(17) Subtask 531364-831-217-008 - Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 Stringer 38 LH
To	160	Work location	from Frame 60 to Frame 63 Stringer 38 LH

Manpower Resources	
Manhours	6.50
Minimum number of person	2
Subtask elapsed time	6.50
Skills	AIRFRAME

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Material necessary to do the job

Kit 531364D04R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
544	EN6069D4-04	4	RIVET	
545	EN6069D4-05	52	RIVET	
655	EN6081D5-05	15	RIVET	
656	EN6081D5-06	183	RIVET	
657	EN6081D5-07	55	RIVET	
764	DAN5-6-4X	4	PIN	
765	DAN5-6-5X	4	PIN	
784	DAN5-6-4Y	2	PIN	
786	DAN5-6-6Y	6	PIN	
806	NSA5075-6	10	COLLAR	
807	DAN11-6X	8	COLLAR	
809	DAN11-6Y	18	COLLAR	
864	DAN6-6-4	3	PIN	
865	DAN6-6-5	7	PIN	
885	DAN6-6-5Y	4	PIN	
886	DAN6-6-6Y	3	PIN	
887	DAN6-6-7Y	3	PIN	

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	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12 53-41-14
Fig. A-GBQAD Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

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(a) Install the shear plates.

Refer to Fig. A-GBQAD Sheet 01 thru Fig. A-GBQAD Sheet 07.

1 Between Frame 49 and Frame 50, on STGR 38 LH and on the bracket, Item 66, put in position:

Refer to Fig. A-GBQAD Sheet 02, View D.

1	Plate-Shear	D5347471500000	Item (139)	Retained at removal

2 Transfer drill and ream the three holes from the shear plate, Item (139), to the bracket, Item 66, refer to Fig. A-GBQAD Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAD Sheet 07.

3 Between Frame 49 and Frame 50, on STGR 38 LH and on the bracket, Item 66, remove:

1	Plate-Shear	D5347471500000	Item (139)	Retain

4 Between Frame 49 and Frame 50, on STGR 38 LH, clean and deburr the new fastener holes in the bracket, Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

5 Between Frame 49 and Frame 50, on STGR 38 LH and on the bracket, Item 66, wet install:

Refer to Fig. A-GBQAD Sheet 02, View D.

1	Plate-Shear	D5347471500000	Item (139)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545
6	Rivet	EN6081D5-06	Item 656

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20	Rivet	EN6081D5-07	Item 657	

6 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item 66, put in position:

Refer to Fig. A-GBQAD Sheet 02, View D.

1	Plate-Shear	D5347049000000	Item (117)	Retained at removal

7 Transfer drill and ream the six holes from the shear plate, Item (117), to the brackets, Item 65 and Item 66, refer to Fig. A-GBQAD Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAD Sheet 07.

8 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item 66, remove:

1	Plate-Shear	D5347049000000	Item (117)	Retain

9 Between Frame 50 and Frame 51, on STGR 38 LH, clean and deburr the new fastener holes in the brackets, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

10 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item 66, wet install:

Refer to Fig. A-GBQAD Sheet 02, View D.

1	Plate-Shear	D5347049000000	Item (117)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545
6	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D5-07	Item 657

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11 Between Frame 51 and Frame 52, on STGR 38 LH and on the brackets, Item 65 and Item (140), put in position:

Refer to Fig. A-GBQAD Sheet 03, View F.

1	Plate-Shear	D5347471500600	Item (137)	Retained at removal

12 Transfer drill and ream the three holes from the shear plate, Item (137), to the bracket, Item 65, refer to Fig. A-GBQAD Sheet 03, View F.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAD Sheet 07.

13 Between Frame 51 and Frame 52, on STGR 38 LH, remove:

1	Plate-Shear	D5347471500600	Item (137)	Retain

14 Between Frame 51 and Frame 52, on STGR 38 LH, clean and deburr the new fastener holes in the bracket, Item 65, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

15 Between Frame 51 and Frame 52, on STGR 38 LH and on the brackets, Item 65 and Item (140), wet install:

Refer to Fig. A-GBQAD Sheet 03, View F.

1	Plate-Shear	D5347471500600	Item (137)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545
6	Rivet	EN6081D5-06	Item 656
15	Rivet	EN6081D5-07	Item 657

16 Between Frame 52 and Frame 53, on STGR 38 LH and on the brackets, Item (116) and Item 68, put in position:

Refer to Fig. A-GBQAD Sheet 03, View F.

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1	Plate-Shear	D5347471500800	Item (119)	Retained at removal

17 Transfer drill and ream the three holes from the shear plate, Item (119), to the bracket, Item 68, refer to Fig. A-GBQAD Sheet 03, View F.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAD Sheet 07.

18 Between Frame 52 and Frame 53, on STGR 38 LH, remove:

1	Plate-Shear	D5347471500800	Item (119)	Retain

19 Between Frame 52 and Frame 53, on STGR 38 LH, clean and deburr the new fastener holes in the bracket, Item 68, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 Between Frame 52 and Frame 53, on STGR 38 LH and on the brackets, Item (116) and Item 68, wet install:

Refer to Fig. A-GBQAD Sheet 03, View F.

1	Plate-Shear	D5347471500800	Item (119)	Retained at removal
1	Section-Connecting	D5347065020200	Item (135)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545
24	Rivet	EN6081D5-06	Item 656
2	Pin	DAN5-6-4Y	Item 784
6	Pin	DAN5-6-6Y	Item 786
18	Collar	DAN11-6Y	Item 809
4	Pin	DAN6-6-5Y	Item 885

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3	Pin	DAN6-6-6Y	Item 886	
3	Pin	DAN6-6-7Y	Item 887	

21 Between Frame 53 and Frame 54, on STGR 38 LH and on the brackets, Item 80 and Item 82, put in position:

Refer to Fig. A-GBQAD Sheet 04, View H.

1	Plate-Shear	D5347471501000	Item (141)	Retained at removal

22 Transfer drill and ream the six holes from the shear plate, Item (141), to the brackets, Item 80 and Item 82, refer to Fig. A-GBQAD Sheet 04, View H.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAD Sheet 07.

23 Between Frame 53 and Frame 54, on STGR 38 LH, remove:

1	Plate-Shear	D5347471501000	Item (141)	Retain

24 Between Frame 53 and Frame 54, on STGR 38 LH, clean and deburr the new fastener holes in the bracket, Item 80 and Item 82, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

25 Between Frame 53 and Frame 54, on STGR 38 LH and on the brackets, Item 80 and Item 82, wet install:

Refer to Fig. A-GBQAD Sheet 04, View H.

1	Plate-Shear	D5347471501000	Item (141)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545
26	Rivet	EN6081D5-06	Item 656

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26 Between Frame 54 and Frame 55, on STGR 38 LH and on the brackets, Item 84 and Item (120), put in position:

Refer to Fig. A-GBQAD Sheet 04, View K.

1	Plate Assy-Shear	D5347048800400	Item (122)	Retained at removal

27 Transfer drill and ream the three holes from the shear plate, Item (122), to the bracket, Item 84, refer to Fig. A-GBQAD Sheet 04, View H.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAD Sheet 07.

28 Between Frame 54 and Frame 55, on STGR 38 LH, remove:

1	Plate Assy-Shear	D5347048800400	Item (122)	Retain

29 Between Frame 54 and Frame 55, on STGR 38 LH, clean and deburr the new fastener holes in the bracket, Item 84, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

30 Between Frame 54 and Frame 55, on STGR 38 LH and on the brackets, Item 84 and Item (120), wet install:

Refer to Fig. A-GBQAD Sheet 04, View K.

1	Plate Assy-Shear	D5347048800400	Item (122)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

14	Rivet	EN6069D4-05	Item 545
26	Rivet	EN6081D5-06	Item 656

31 Between Frame 56 and Frame 57, on STGR 38 LH and on the brackets, Item (121) and Item (118), wet install:

Refer to Fig. A-GBQAD Sheet 05, View M.

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1	Plate Assy-Shear	D5347048900000	Item (124)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
14	Rivet	EN6069D4-05	Item 545	
26	Rivet	EN6081D5-06	Item 656	

32 Between Frame 58 and Frame 59, on STGR 38 LH and on the brackets, Item (125) and Item (127), wet install:

Refer to Fig. A-GBQAD Sheet 05, View P.

1	Plate-Shear	D5347049200000	Item (126)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
14	Rivet	EN6069D4-05	Item 545	
26	Rivet	EN6081D5-06	Item 656	

33 Between Frame 60 and Frame 61, on STGR 38 LH and on the brackets, Item (128) and Item (130), wet install:

Refer to Fig. A-GBQAD Sheet 06, View R.

1	Plate-Shear	D5347049300000	Item (129)	Retained at removal
1	Section-Connecting	D5347065420400	Item (136)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6069D4-04	Item 544	

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8	Rivet	EN6081D5-05	Item 655	
17	Rivet	EN6081D5-06	Item 656	
4	Pin	DAN5-6-4X	Item 764	
4	Pin	DAN5-6-5X	Item 765	
10	Collar	NSA5075-6	Item 806	
8	Collar	DAN11-6X	Item 807	
3	Pin	DAN6-6-4	Item 864	
7	Pin	DAN6-6-5	Item 865	

34 Between Frame 62 and Frame 63, on STGR 38 LH and on the brackets, Item (131) and Item (115), wet install:

Refer to Fig. A-GBQAD Sheet 06, View T.

1	Plate-Shear	D5347049400000	Item (123)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-04	Item 544	
7	Rivet	EN6081D5-05	Item 655	
20	Rivet	EN6081D5-06	Item 656	

(b) Install the corner profiles.

In accordance with SRM 53-41-14.

1 Between Frame 48 thru Frame 63, at STGR 38 LH, install the corner profiles, if removed in accordance with SRM 53-41-14 C2 Identification - Floor Structure - Cargo Compartment.

(c) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(18) Subtask 531364-831-218-002 - Install new Surface Protection on Frame 50 thru Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 from Stringer 31 to Stringer 39
To	160	Work location	from Frame 60 to Frame 63 from Stringer 31 to Stringer 39

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	NON SPECIFIC

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	04JME4	As required	
	Coating - Flexible Structure	04QAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound	12ADB1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12

(a) Clean the working area with:

Non Aqueous Cleaner - General	08BAA9	As required

and

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Textile - Lint Free Cotton	14SBA1	As required

(b) Apply sealant beads around the edges of all new and reinstalled structure parts with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(c) Apply to all sealant beads:

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(d) Apply to all sealant beads:

Top Coat Polyurethane	04JME4	As required

and

Coating - Flexible Structure	04QAB2	As required

(e) Install new water repellent protection on Frame 50 thru Frame 63.

1 Protect the Frame 50 thru Frame 63, STGR 31 LH thru STGR 39 LH and the re-installed shear plates with:

In accordance with SRM 51-23-12.

Corrosion Preventive Compound	12ADB1	As required

****CONF 005**

(1) Subtask 531364-831-201-012 - Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 Stringer 38 LH
To	160	Work location	from Frame 60 to Frame 63 Stringer 38 LH

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

Material necessary to do the job

Consumable CMLD01

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)	53-41-14
Fig. A-GBQAE Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

CAUTION: AIRBUS CONSIDERS IT IS TECHNICALLY ACCEPTABLE TO REWORK EVERY THIRD FRAME AT THE SAME TIME (I.E. LEAVE TWO FRAMES INTACT AND REWORK ONE) TO KEEP THE FUSELAGE STRUCTURE INTEGRITY.

(a) Remove the corner profiles.

In accordance with SRM 53-41-14 C2 Ident.-Floor Structure-Cargo Compartment.

1 Between Frame 48 thru Frame 63, at STGR 38 LH, remove the corner profiles, if necessary in accordance with SRM 53-41-14 C2 Identification - Floor Structure - Cargo Compartment.

(b) Remove the shear plates.

Refer to Fig. A-GBQAE Sheet 01 thru Fig. A-GBQAE Sheet 06.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 Between Frame 49 and Frame 50, from STGR 38 LH and from the bracket at Frame 49 and bracket, Item (140), remove:

Refer to Fig. A-GBQAE Sheet 02, View C.

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1	Plate-Shear	D5347471500000	Item (139)	Retain
	with			
28	Rivet		Item (100)	Discard

2 Between Frame 50 and Frame 51, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAE Sheet 02, View C.

1	Plate-Shear	D5347471500200	Item (117)	Retain
	with			
28	Rivet		Item (100)	Discard

3 Between Frame 51 and Frame 52, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAE Sheet 02, View C.

1	Plate-Shear	D5347471502800	Item (180)	Retain
	with			
28	Rivet		Item (100)	Discard

4 Between Frame 52 and Frame 53, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAE Sheet 03, View E.

1	Plate-Shear	D5347471503000	Item (190)	Retain
	with			
28	Rivet		Item (100)	Discard

5 Between Frame 53 and Frame 54, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAE Sheet 03, View E.

1	Plate-Shear	D5347471501000	Item (141)	Retain
	with			
28	Rivet		Item (100)	Discard

6 Between Frame 54 and Frame 55, from STGR 38 LH and from the brackets, Item (121) and Item (120), remove:

Refer to Fig. A-GBQAE Sheet 03, View E.

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1	Plate Assy-Shear	D5347048800400	Item (122)	Retain
	with			
28	Rivet		Item (100)	Discard

7 Between Frame 56 and Frame 57, from STGR 38 LH and from the brackets, Item (121) and Item (118), remove:

Refer to Fig. A-GBQAE Sheet 04, View G.

1	Plate Assy-Shear	D5347048900000	Item (124)	Retain
	with			
28	Rivet		Item (100)	Discard

8 Between Frame 58 and Frame 59, from STGR 38 LH and from the brackets, Item (125) and Item (127), remove:

Refer to Fig. A-GBQAE Sheet 05, View J.

1	Plate-Shear	D5347049200200	Item (126)	Retain
	with			
40	Rivet		Item (100)	Discard

9 Between Frame 60 and Frame 61, from STGR 38 LH and from the brackets, Item (128) and Item (130), remove:

Refer to Fig. A-GBQAE Sheet 05, View L.

1	Plate-Shear	D5347049300200	Item (129)	Retain
	with			
30	Rivet		Item (100)	Discard

10 Between Frame 62 and Frame 63, from STGR 38 LH and from the brackets, Item (131) and Item (115), remove:

Refer to Fig. A-GBQAE Sheet 06, View N.

1	Plate-Shear	D5347049400000	Item (123)	Retain
	with			
29	Rivet		Item (100)	Discard

(c) Clean the contact surfaces and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

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and

Textile - Lint Free Cotton	14SBA1	As required

(2) Subtask 531364-831-202-006 - Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 55 from Stringer 33 LH to Stringer 34 LH from Stringer 36 LH to Stringer 37 LH Frame 56 from Stringer 33 LH to Stringer 34 LH from Stringer 35 LH to Stringer 37 LH from Frame 57 to Frame 59 from Stringer 33 LH to Stringer 34 LH from Stringer 36 LH to Stringer 37 LH
To	160	Work location	from Frame 60 to Frame 62 from Stringer 32 LH to Stringer 33 LH from Stringer 36 LH to Stringer 37 LH Frame 63 from Stringer 31 LH to Stringer 32 LH from Stringer 36 LH to Stringer 37 LH

Manpower Resources	
Manhours	5.00
Minimum number of person	1
Subtask elapsed time	5.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

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 Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane	04JME4	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

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Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

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NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00
Fig. A-GBRAB Cold Expansion of Holes in Frame 50 thru Frame 63	Sheet 01 Sheet 02 Sheet 03

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

(a) Inspect the holes for cracks from Frame 50 thru Frame 55 and from Frame 57 thru Frame 59.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 02.

1 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 33 LH and STGR 34 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(b) Cold expand the holes from Frame 50 thru Frame 55 and from Frame 57 thru Frame 59.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 02.

1 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 33 LH and STGR 34 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 02, View C.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

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FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 02, View C.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

4 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(c) Inspect the holes for cracks at Frame 56.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 02.

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1 At Frame 56, between STGR 33 LH and STGR 34 LH and between STGR 35 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 At Frame 56, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Cold expand the holes at Frame 56.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 02.

1 At Frame 56, between STGR 33 LH and STGR 34 LH and between STGR 35 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 02, View D.

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NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 At Frame 56, between STGR 37 LH and STGR 38 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 02, View D.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

4 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

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Top Coat Polyurethane	04JME4	As required

(e) Inspect the holes for cracks from Frame 60 thru Frame 62.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 02.

1 From Frame 60 thru Frame 62, between STGR 32 LH and STGR 33 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 From Frame 60 thru Frame 62, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(f) Cold expand the holes from Frame 60 thru Frame 62.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 02.

1 From Frame 60 thru Frame 62, between STGR 32 LH and STGR 33 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 02, View E.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 From Frame 60 thru Frame 62, between STGR 37 LH and STGR 38 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 02, View E.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

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Textile - Lint Free Cotton	14SBA1	As required

4 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(g) Inspect the holes for cracks at Frame 63.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 03.

1 At Frame 63, between STGR 31 LH and STGR 32 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frame, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 At Frame 63, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(h) Cold expand the holes at Frame 63.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 03.

1 At Frame 63, between STGR 31 LH and STGR 32 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frame. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

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FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 03, View F.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 At Frame 63, between STGR 37 LH and STGR 38 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 03, View F.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

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NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 Clean the area of the expanded holes with:

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

4 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(3) Subtask 531364-831-203-013 - Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 50 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D05R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
4	E5347001024400	1	WEB	
36	E5347001124200	1	ANGLE	
65	E5347001420200	1	ANGLE	
66	E5347001420000	1	ANGLE	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	11	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
668	EN6081D6-08	11	RIVET	(1)
764	DAN5-6-4X	15	PIN	
765	DAN5-6-5X	13	PIN	
766	DAN5-6-6X	6	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	2	PIN	
785	DAN5-6-5Y	3	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	38	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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.

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NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBAAE Replacement of Webs and Angles at Frame 50	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBAAE Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 50, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
17	Rivet		Item (100)	Discard

2 From the flange of Frame 50, between STGR 35 LH and STGR 36 LH, remove:

6	Rivet		Item (100)	Discard

3 From Frame 50, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347073420200	Item (1)	Discard

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with

18	Rivet		Item (100)	Discard

4 From Frame 50, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072820600	Item (2)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046820000	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard

with

66	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 50.

Refer to NTM 51-10-01.

Refer to Fig. A-GBAAE Sheet 02, View C.

1 On Frame 50, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 50, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

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(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBAAE Sheet 02 thru Fig. A-GBAAE Sheet 04.

1 On Frame 50, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBAAE Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 50 to the shear web, Item 4.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAE Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBAAE Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBAAE Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAE Sheet 04.

5 Transfer drill the tack hole from the Frame 50 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 50 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 50, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

8 Clean and deburr the new fastener holes in Frame 50 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

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Refer to Fig. A-GBAAE Sheet 02, View C.

a On Frame 50, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBAAE Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

b On Frame 50, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAE Sheet 02, View C.

c On Frame 50, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAE Sheet 02, View C.

d On Frame 50, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAE Sheet 02, View C.

10 On Frame 50, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

11 Clean and deburr the cold expansion fastener holes in Frame 50 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 50, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBAAE Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4
	with		
3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
11	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
11	Rivet	EN6081D6-08	Item 668
15	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-5X	Item 765
3	Pin	DAN5-6-5Y	Item 785
25	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809
5	Nut	ASNA2528-3A	Item 908
	use		
Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

13 Install 1 fastener in the flange of Frame 50, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBAAE Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

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14 On the Frame 50 flange, at STGR 35 LH, refer to Fig. A-GBAAE Sheet 03, Section C-C, countersink the one fastener hole.

15 On the Frame 50 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBAAE Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 50 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBAAE Sheet 02, View C and Fig. A-GBAAE Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBAAE Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAE Sheet 04.

18 On the Frame 50 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 50, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 50 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBAAE Sheet 02, View C and Fig. A-GBAAE Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

21 On the Frame 50 flange, at STGR 36 LH, refer to Fig. A-GBAAE Sheet 03, Section D-D, countersink the one fastener hole.

22 On the Frame 50 flange, at STGR 36 LH, close the rivet hole in STGR 56 LH with:

Refer to Fig. A-GBAAE Sheet 03, Section D-D

1	Rivet	EN6069D5-06	Item 556

with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 50 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBAAE Sheet 02, View C and Fig. A-GBAAE Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBAAE Sheet 02, View C and Fig. A-GBAAE Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAE Sheet 04.

25 On the Frame 50 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 50, STGR 36 LH and angle, Item 2, use:

	Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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	Non Aqueous Cleaner - General	08BAA9	As required	

27 On the Frame 50 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBAAE Sheet 02, View C and Fig. A-GBAAE Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

28 On the Frame 50 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBAAE Sheet 02, View C and Fig. A-GBAAE Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Pin	DAN5-6-6X	Item 766	
2	Pin	DAN5-6-7X	Item 767	
4	Collar	NSA5075-6	Item 806	
6	Collar	DAN11-6X	Item 807	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 50 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBAAE Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65

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1	Angle	E5347001420000	Item 66

30 Transfer drill and ream three holes from the Frame to the angles, Item 65 and Item 66, refer to Fig. A-GBAAE Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAE Sheet 04.

31 On the Frame 50 flange, at STGR 38 LH, remove:

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

32 Clean and deburr the new fastener holes in the Frame 50 and angles, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

33 On the Frame 50 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBAAE Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-8X	Item 768
1	Pin	DAN5-6-6Y	Item 786
2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

34 On the Frame 50 flange, at STGR 39 LH, refer to Fig. A-GBAAE Sheet 03, Section F-F, countersink the one fastener hole.

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35 On the Frame 50 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBAAE Sheet 03, Section F-F.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

36 On the Frame 50 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBAAE Sheet 02, View C and Fig. A-GBAAE Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

37 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBAAE Sheet 02, View C and Fig. A-GBAAE Sheet 03, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAE Sheet 04.

38 On the Frame 50 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

39 Clean and deburr the new fastener holes in the Frame 50, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

40 On the Frame 50 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBAAE Sheet 02, View C and Fig. A-GBAAE Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-07	Item 657
2	Pin	DAN5-6-6X	Item 766
2	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(4) Subtask 531364-831-204-012 - Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 51 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D05R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
2	E5347001120200	1	ANGLE	
4	E5347001024400	1	WEB	
36	E5347001124200	1	ANGLE	
65	E5347001420200	1	ANGLE	
66	E5347001420000	1	ANGLE	
363	EN6115K3-3	3	BOLT	
374	EN6115K3A4	5	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	3	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
669	EN6081D6-09	4	RIVET	(1)
764	DAN5-6-4X	14	PIN	
765	DAN5-6-5X	13	PIN	
766	DAN5-6-6X	4	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	4	PIN	
785	DAN5-6-5Y	3	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	37	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

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Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

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NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBBAE Replacement of Webs and Angles at Frame 51	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBBAE Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 51, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
17	Rivet		Item (100)	Discard

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2 From the top flange of Frame 51, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

6	Rivet		Item (100)	Discard

3 From Frame 51, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347073420200	Item (1)	Discard
	with			
18	Rivet		Item (100)	Discard

4 From Frame 51, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072820600	Item (2)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347470120200	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard
	with			
66	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 51.

Refer to NTM 51-10-01.

Refer to Fig. A-GBBAE Sheet 02, View C.

1 On Frame 51, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

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2 On Frame 51, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBBAE Sheet 02 thru Fig. A-GBBAE Sheet 04.

1 On Frame 51, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBBAE Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 51 to the shear web, Item 4.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAE Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBBAE Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBBAE Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAE Sheet 04.

5 Transfer drill the tack hole from the Frame 51 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 51 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 51, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

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8 Clean and deburr the new fastener holes in Frame 51 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBBAE Sheet 02, View C.

a On Frame 51, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBBAE Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

b On Frame 51, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAE Sheet 02, View C.

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c On Frame 51, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAE Sheet 02, View C.

d On Frame 51, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAE Sheet 02, View C.

10 On Frame 51, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

11 Clean and deburr the cold expansion fastener holes in Frame 51 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 On the Shear Web, Item 4, at Frame 51, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBBAE Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

with

3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
4	Rivet	EN6081D6-09	Item 669
14	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-5X	Item 765
3	Pin	DAN5-6-5Y	Item 785
24	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809

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5	Nut	ASNA2528-3A	Item 908

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 51, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBBAE Sheet 02, View C.

1	Bolt	EN6115K3A4	Item 374
1	Nut	ASNA2528-3A	Item 908

14 On the Frame 51 flange, at STGR 35 LH, refer to Fig. A-GBBAE Sheet 03, Section C-C, countersink the one fastener hole.

15 On the Frame 51 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBBAE Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 51 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAE Sheet 04.

18 On the Frame 51 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

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19 Clean and deburr the new fastener holes in the Frame 51, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 51 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

21 On the Frame 51 flange, at STGR 36 LH, refer to Fig. A-GBBAE Sheet 03, Section D-D, countersink the one fastener hole.

22 On the Frame 51 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBBAE Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 51 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

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24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole in STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAE Sheet 04.

25 On the Frame 51 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 51, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 51 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Rivet	EN6081D6-07	Item 667

28 On the Frame 51 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

4	Pin	DAN5-6-6X	Item 766
2	Pin	DAN5-6-7X	Item 767
4	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
4	Pin	DAN5-6-3	Item 963

29 On the Frame 51 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBBAE Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

30 Transfer drill and ream the three holes from the Frame to the angles, Item 65 and Item 66, refer to Fig. A-GBBAE Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAE Sheet 04.

31 On the Frame 51 flange, at STGR 38 LH, remove:

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

32 Clean and deburr the new fastener holes in the Frame 51 and angles, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

33 On the Frame 51 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBBAE Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-8X	Item 768
1	Pin	DAN5-6-6Y	Item 786
2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

34 On the Frame 51 flange, at STGR 39 LH, refer to Fig. A-GBBAE Sheet 03, Section F-F, countersink the one fastener hole.

35 On the Frame 51 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBBAE Sheet 03, Section F-F.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

36 On the Frame 51 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

37 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAE Sheet 04.

38 On the Frame 51 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

39 Clean and deburr the new fastener holes in the Frame 51, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

40 On the Frame 51 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Pin	DAN5-6-8X	Item 768
2	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

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(5) Subtask 531364-831-205-012 - Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 52 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D05R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
6	E5347001023800	1	WEB	
88	E5347001125400	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	11	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	2	RIVET	
668	EN6081D6-08	32	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	1	PIN	
766	DAN5-6-6X	2	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	7	COLLAR	
807	DAN11-6X	10	COLLAR	
808	ASNA2528-3	10	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	1	PIN	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	1	PIN	

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NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBCAE Replacement of Webs and Angles at Frame 52	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBCAE Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 52, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920200	Item (3)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 52, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

8	Rivet		Item (100)	Discard

3 From Frame 52, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 52, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347077420200	Item (5)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046820000	Item (116)	Retain
1	Angle	D5347470120000	Item (140)	Retain
	with			
52	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

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Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 52.

Refer to NTM 51-10-01.

Refer to Fig. A-GBCAE Sheet 02, Views C, D and F.

1 On Frame 52, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 52, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 52, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 52, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBCAE Sheet 02 thru Fig. A-GBCAE Sheet 04.

1 On Frame 52, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBCAE Sheet 02, View C.

1	Shear Web	E5347001023800	Item 6

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

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3 Transfer drill the fastener holes from the Frame 52 to the shear web, Item 6.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAE Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBCAE Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBCAE Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAE Sheet 04.

5 Transfer drill the tack hole from the Frame 52 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 52 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 52, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001023800	Item 6

8 Clean and deburr the new fastener holes in Frame 52 and the shear web, Item 6, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBCAE Sheet 02, Views C, D and F.

a On Frame 52, between STGR 34 LH and STGR 39 LH, put in position:

1	Shear Web	E5347001023800	Item 6

b On Frame 52, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

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FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAE Sheet 02, View C.

c On Frame 52, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAE Sheet 02, View C.

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d On the top flange of Frame 52, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAE Sheet 02, View D.

e On the top flange of Frame 52, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAE Sheet 02, View F.

10 On Frame 52, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001023800	Item 6

11 Clean and deburr the cold expansion fastener holes in Frame 52 and the shear web, Item 6, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 52, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBCAE Sheet 02, View C.

1	Shear Web	E5347001023800	Item 6

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
11	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
30	Rivet	EN6081D6-08	Item 668
7	Pin	DAN5-6-4X	Item 764
1	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
1	Pin	DAN5-6-3	Item 963

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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13 Install 1 fastener in the flange of Frame 52, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBCAE Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 52, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBCAE Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

15 On the Frame 52 flange, at STGR 35 LH, refer to Fig. A-GBCAE Sheet 03, Section C-C, countersink the one fastener hole.

16 On the Frame 52 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBCAE Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 52 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBCAE Sheet 02, View C and Fig. A-GBCAE Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole in STGR 35 LH and the three holes in the Frame to the angle, Item 1, refer to Fig. A-GBCAE Sheet 02, View C and Fig. A-GBCAE Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAE Sheet 04.

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19 On the Frame 52 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

20 Clean and deburr the new fastener holes in the Frame 52, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 52 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBCAE Sheet 02, View C and Fig. A-GBCAE Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

22 On the Frame 52 flange, at STGR 36 LH, refer to Fig. A-GBCAE Sheet 03, Section D-D, countersink the one fastener hole.

23 On the Frame 52 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBCAE Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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24 On the Frame 52 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBCAE Sheet 02, View C and Fig. A-GBCAE Sheet 03, Section D-D.

2	Angle	E5347001120200	Item 2

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole in STGR 36 LH and the three holes in the Frame to the angle, Item 2, refer to Fig. A-GBCAE Sheet 02, View C and Fig. A-GBCAE Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAE Sheet 04.

26 On the Frame 52 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

27 Clean and deburr the new fastener holes in the Frame 52, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 52 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBCAE Sheet 02, View C and Fig. A-GBCAE Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-4	Item 964
1	Collar	NSA5075-6	Item 806

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29 On the Frame 52 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBCAE Sheet 02, View C and Fig. A-GBCAE Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

30 On the Frame 52 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBCAE Sheet 02, View C and Section B-B.

1	Angle	D5347046820000	Item (116)	Retained at removal
1	Angle	D5347470120000	Item (140)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
1	Pin	DAN5-6-6Y	Item 786	
2	Pin	DAN5-6-6X	Item 766	
2	Collar	DAN11-6X	Item 807	
1	Collar	DAN11-6Y	Item 809	

31 On the Frame 52 flange, at STGR 39 LH, refer to Fig. A-GBCAE Sheet 03, Section F-F, countersink the one fastener hole.

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32 On the Frame 52 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBCAE Sheet 03, Section F-F.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 52 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBCAE Sheet 02, View C and Fig. A-GBCAE Sheet 03, Section F-F.

1	Angle	E5347001125400	Item 88

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 88, to the STGR 39 LH, then transfer drill and ream the other hole in STGR 39 LH and the two holes in the Frame to the angle, Item 88, refer to Fig. A-GBCAE Sheet 02, View C and Fig. A-GBCAE Sheet 03, Section F-F.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAE Sheet 04.

35 On the Frame 52 flange, at STGR 39 LH, remove:

1	Angle	E5347001125400	Item 88

36 Clean and deburr the new fastener holes in the Frame 52, STGR 39 LH and angle, Item 88, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

37 On the Frame 52 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBCAE Sheet 02, View C and Fig. A-GBCAE Sheet 03, Section F-F.

1	Angle	E5347001125400	Item 88

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D6-08	Item 668
2	Rivet	EN6081D5-07	Item 657

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(6) Subtask 531364-831-206-011 - Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 53 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D05R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
8	E5347001027400	1	WEB	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
36	E5347001124200	1	ANGLE	
68	E5347001420400	1	ANGLE	
80	E5347001420600	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	2	RIVET	
668	EN6081D6-08	17	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	4	PIN	
765	DAN5-6-5X	1	PIN	
766	DAN5-6-6X	2	PIN	
784	DAN5-6-4Y	1	PIN	
806	NSA5075-6	18	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	9	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	10	PIN	
875	DAN6-6-5X	2	PIN	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

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Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

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NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBDAE Replacement of Webs and Angles at Frame 53	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBDAE Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 53, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

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2 From the flange of Frame 53, between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 53, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 53, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078320200	Item (6)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347470120200	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 53.

Refer to NTM 51-10-01.

Refer to Fig. A-GBDAE Sheet 02, View C.

1 On Frame 53, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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2 On Frame 53, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBDAE Sheet 02 thru Fig. A-GBDAE Sheet 04.

1 On Frame 53, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBDAE Sheet 02, View C.

1	Shear Web	E5347001027400	Item 8

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 53 to the shear web, Item 8.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAE Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBDAE Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBDAE Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAE Sheet 04.

5 Transfer drill the tack hole from the Frame 53 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 53 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 53, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001027400	Item 8

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8 Clean and deburr the new fastener holes in Frame 53 and the shear web, Item 8, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBDAE Sheet 02, View C.

a On Frame 53, between STGR 34 LH and STGR 39 LH, put in position:

1	Shear Web	E5347001027400	Item 8

b On Frame 53, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAE Sheet 02, View C.

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c On Frame 53, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAE Sheet 02, View C.

10 On Frame 53, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001027400	Item 8

11 Clean and deburr the cold expansion fastener holes in Frame 53 and the shear web, Item 8, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 53, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBDAE Sheet 02, View C.

1	Shear Web	E5347001027400	Item 8

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364

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15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
4	Pin	DAN5-6-4X	Item 764
13	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863
2	Pin	DAN6-6-5X	Item 875
1	Pin	DAN5-6-3	Item 963
2	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 53, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBDAE Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the Frame 53 flange, at STGR 35 LH, refer to Fig. A-GBDAE Sheet 03, Section C-C, countersink the one fastener hole.

15 On the Frame 53 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBDAE Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 53 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBDAE Sheet 02, View C and Fig. A-GBDAE Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBDAE Sheet 02, View C and Fig. A-GBDAE Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAE Sheet 04.

18 On the Frame 53 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 53, STGR 35 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 53 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBDAE Sheet 02, View C and Fig. A-GBDAE Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765

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1	Collar	DAN11-6X	Item 807

21 On the Frame 53 flange, at STGR 36 LH, refer to Fig. A-GBDAE Sheet 03, Section D-D, countersink the one fastener hole.

22 On the Frame 53 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBDAE Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 53 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBDAE Sheet 02, View C and Fig. A-GBDAE Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBDAE Sheet 02, View C and Fig. A-GBDAE Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAE Sheet 04.

25 On the Frame 53 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 53, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 53 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBDAE Sheet 02, View C and Fig. A-GBDAE Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-4	Item 964	
1	Collar	NSA5075-6	Item 806	

28 On the Frame 53 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBDAE Sheet 02, View C and Fig. A-GBDAE Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

6	Rivet	EN6081D6-09	Item 669
4	Collar	NSA5075-6	Item 806
4	Pin	DAN5-6-3	Item 963

29 On the Frame 53 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBDAE Sheet 02, View C and Section B-B.

1	Angle	E5347001420400	Item 68
1	Angle	E5347001420600	Item 80

30 Transfer drill and ream the three holes from the Frame to the angles, Item 68 and Item 80, refer to Fig. A-GBDAE Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAE Sheet 04.

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31 On the Frame 53 flange, at STGR 38 LH, remove:

1	Angle	E5347001420400	Item 68
1	Angle	E5347001420600	Item 80

32 Clean and deburr the new fastener holes in the Frame 53 and angles, Item 68 and Item 80, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

33 On the Frame 53 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBDAE Sheet 02, View C and Section B-B.

1	Angle	E5347001420400	Item 68
1	Angle	E5347001420600	Item 80

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-6X	Item 766
1	Pin	DAN5-6-4Y	Item 784
2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

34 On the Frame 53 flange, at STGR 39 LH, refer to Fig. A-GBDAE Sheet 03, Section F-F, countersink the one fastener hole.

35 On the Frame 53 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBDAE Sheet 03, Section F-F.

1	Rivet	EN6069D5-06	Item 556

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

36 On the Frame 53 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBDAE Sheet 02, View C and Fig. A-GBDAE Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

37 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBDAE Sheet 02, View C and Fig. A-GBDAE Sheet 03, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBDAE Sheet 04.

38 On the Frame 53 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

39 Clean and deburr the new fastener holes in the Frame 53, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

40 On the Frame 53 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBDAE Sheet 02, View C and Fig. A-GBDAE Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668

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(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(7) Subtask 531364-831-207-011 - Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 54 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D05R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
10	E5347001025200	1	WEB	
36	E5347001124200	1	ANGLE	
82	E5347001420800	1	ANGLE	
84	E5347001421000	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	6	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	1	PIN	
766	DAN5-6-6X	2	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	16	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	10	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	12	PIN	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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.

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NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBEAE Replacement of Webs and Angles at Frame 54	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBEAE Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 54, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 54, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

10	Rivet		Item (100)	Discard

3 From Frame 54, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard

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with

14	Rivet		Item (100)	Discard

4 From Frame 54, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078520400	Item (7)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046824000	Item (121)	Discard
1	Angle	D5347470120000	Item (140)	Discard

with

56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 54.

Refer to NTM 51-10-01.

Refer to Fig. A-GBEAE Sheet 02, Views C, D and F.

1 On Frame 54, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 54, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 54, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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4 On the top flange of Frame 54, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBEAE Sheet 02 thru Fig. A-GBEAE Sheet 04.

1 On Frame 54, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBEAE Sheet 02, View C.

1	Shear Web	E5347001025200	Item 10

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 54 to the shear web, Item 10.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAE Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBEAE Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBEAE Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAE Sheet 04.

5 Transfer drill the tack hole from the Frame 54 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 54 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 54, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025200	Item 10

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8 Clean and deburr the fastener holes in Frame 54 and the shear web, Item 10, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBEAE Sheet 02, Views C, D and F.

a On Frame 54, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBEAE Sheet 02, View C.

1	Shear Web	E5347001025200	Item 10

b On Frame 54, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAE Sheet 02, View C.

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c On Frame 54, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAE Sheet 02, View C.

d On the top flange of Frame 54, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAE Sheet 02, View D.

e On the top flange of Frame 54, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAE Sheet 02, View F.

10 On Frame 54, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025200	Item 10

11 Clean and deburr the cold expansion fastener holes in Frame 54 and the shear web, Item 10, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 54, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBEAE Sheet 02, View C.

1	Shear Web	E5347001025200	Item 10

with

3	Bolt	EN6115K3-3	Item 363

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5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
6	Rivet	EN6081D6-06	Item 666
17	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
10	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 54, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBEAE Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 54, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBEAE Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

15 On the Frame 54 flange, at STGR 35 LH, refer to Fig. A-GBEAE Sheet 03, Section C-C, countersink the one fastener hole.

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16 On the Frame 54 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBEAE Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 54 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBEAE Sheet 02, View C and Fig. A-GBEAE Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three hole from the Frame to the angle, Item 1, refer to Fig. A-GBEAE Sheet 02, View C and Fig. A-GBEAE Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAE Sheet 04.

19 On the Frame 54 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

20 Clean and deburr the new fastener holes in the Frame 54, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 54 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBEAE Sheet 02, View C and Fig. A-GBEAE Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

22 On the Frame 54 flange, at STGR 36 LH, refer to Fig. A-GBEAE Sheet 03, Section D-D, countersink the one fastener hole.

23 On the Frame 54 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBEAE Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 54 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBEAE Sheet 02, View C and Fig. A-GBEAE Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBEAE Sheet 02, View C and Fig. A-GBEAE Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAE Sheet 04.

26 On the Frame 54 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

27 Clean and deburr the new fastener holes in the Frame 54, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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	Non Aqueous Cleaner - General	08BAA9	As required	

28 On the Frame 54 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBEAE Sheet 02, View C and Fig. A-GBEAE Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

29 On the Frame 54 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBEAE Sheet 02, View C and Fig. A-GBEAE Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

30 On the Frame 54 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBEAE Sheet 02, View C and Section B-B.

1	Angle	E5347001420800	Item 82
1	Angle	E5347001421000	Item 84

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31 Transfer drill and ream the three holes from the Frame to the angles, Item 82 and Item 84, refer to Fig. A-GBEAE Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAE Sheet 04.

32 On the Frame 54 flange, at STGR 38 LH, remove:

1	Angle	E5347001420800	Item 82
1	Angle	E5347001421000	Item 84

33 Clean and deburr the new fastener holes in the Frame 54 and angle, Item 82 and Item 84, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

34 On the Frame 54 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBEAE Sheet 02, View C and Section B-B.

1	Angle	E5347001420800	Item 82
1	Angle	E5347001421000	Item 84

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-6X	Item 766
2	Collar	DAN11-6X	Item 807
1	Pin	DAN5-6-6Y	Item 786
1	Collar	DAN11-6Y	Item 809

35 On the Frame 54 flange, at STGR 39 LH, refer to Fig. A-GBEAE Sheet 03, Section F-F, countersink the one fastener hole.

36 On the Frame 54 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBEAE Sheet 03, Section F-F.

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1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

37 On the Frame 54 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBEAE Sheet 02, View C and Fig. A-GBEAE Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

38 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two hole from the Frame to the angle, Item 36, refer to Fig. A-GBEAE Sheet 02, View C and Fig. A-GBEAE Sheet 03, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAE Sheet 04.

39 On the Frame 54 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

40 Clean and deburr the new fastener holes in the Frame 54, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

41 On the Frame 54 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBEAE Sheet 02, View C and Fig. A-GBEAE Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657

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2	Rivet	EN6081D6-08	Item 668

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(8) Subtask 531364-831-208-011 - Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 55 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D05R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
12	E5347001025400	1	WEB	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	6	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	16	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	10	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	12	PIN	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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

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For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBFAE Replacement of Webs and Angles at Frame 55	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBFAE Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 55, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 55, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

10	Rivet		Item (100)	Discard

3 From Frame 55, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			

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14	Rivet		Item (100)	Discard

4 From Frame 55, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072121000	Item (8)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046823800	Item (120)	Retain
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 55.

Refer to NTM 51-10-01.

Refer to Fig. A-GBFAE Sheet 02, Views C, D and F.

1 On Frame 55, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 55, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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4 On the top flange of Frame 55, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBFAE Sheet 02 thru Fig. A-GBFAE Sheet 04.

1 On Frame 55, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBFAE Sheet 02, View C.

1	Shear Web	E5347001025400	Item 12

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 55 to the shear web, Item 12.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAE Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBFAE Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBFAE Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAE Sheet 04.

5 Transfer drill the tack hole from the Frame 55 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 55 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 55, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025400	Item 12

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8 Clean and deburr the new fastener holes in Frame 55 and the shear web, Item 12, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBFAE Sheet 02, Views C, D and F.

a On Frame 55, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBFAE Sheet 02, View C.

1	Shear Web	E5347001025400	Item 12

b On Frame 55, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAE Sheet 02, View C.

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c On Frame 55, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAE Sheet 02, View C.

d On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAE Sheet 02, View D.

e On the top flange of Frame 55, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAE Sheet 02, View F.

10 On Frame 55, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025400	Item 12

11 Clean and deburr the cold expansion fastener holes in Frame 55 and the shear web, Item 12, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 55, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBFAE Sheet 02, View C.

1	Shear Web	E5347001025400	Item 12

with

3	Bolt	EN6115K3-3	Item 363

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5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
6	Rivet	EN6081D6-06	Item 666
17	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
10	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 55, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBFAE Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBFAE Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

15 On the Frame 55 flange, at STGR 35 LH, refer to Fig. A-GBFAE Sheet 03, Section A-A, countersink the one fastener hole.

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16 On the Frame 55 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBFAE Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 55 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes form the Frame to the angle, Item 1, refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAE Sheet 04.

19 On the Frame 55 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

20 Clean and deburr the new fastener holes in the Frame 55, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 55 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

22 On the Frame 55 flange, at STGR 36 LH, refer to Fig. A-GBFAE Sheet 03, Section B-B, countersink the one fastener hole.

23 On the Frame 55 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBFAE Sheet 03, Section B-B.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 55 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAE Sheet 04.

26 On the Frame 55 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

27 Clean and deburr the new fastener holes in the Frame 55, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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	Non Aqueous Cleaner - General	08BAA9	As required	

28 On the Frame 55 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

29 On the Frame 55 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

30 On the Frame 55 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBFAE Sheet 02, View C.

1	Angle	D5347046823800	Item (120)	Retained at removal
	with			

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

1	Pin	DAN5-6-5Y	Item 785
1	Collar	DAN11-6Y	Item 809
2	Pin	DAN5-6-5X	Item 765
2	Collar	DAN11-6X	Item 807

31 On the Frame 55 flange, at STGR 39 LH, refer to Fig. A-GBFAE Sheet 03, Section D-D, countersink the one fastener hole.

32 On the Frame 55 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBFAE Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 55 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes form the Frame to the angle, Item 36, refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAE Sheet 04.

35 On the Frame 55 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

36 Clean and deburr the new fastener holes in the Frame 55, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

37 On the Frame 55 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(9) Subtask 531364-831-209-011 - Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 56 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D05R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
14	E5347001024000	1	WEB	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	10	RIVET	
656	EN6081D5-06	10	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	6	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	10	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	21	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	2	NUT	
863	DAN6-6-3	17	PIN	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)

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ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBGAE Replacement of Webs and Angles at Frame 56	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBGAE Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural

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parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 56, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 56, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 34 LH and STGR 36 LH, remove:

10	Rivet		Item (100)	Discard

3 From Frame 56, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 56, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078620400	Item (8)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046820600	Item (121)	Retain
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 56.

Refer to NTM 51-10-01.

Refer to Fig. A-GBGAE Sheet 02, Views C, D and F.

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1 On Frame 56, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 56, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 56, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBGAE Sheet 02 thru Fig. A-GBGAE Sheet 04.

1 On Frame 56, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBGAE Sheet 02, View C.

1	Shear Web	E5347001024000	Item 14

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 56 to the shear web, Item 14.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAE Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBGAE Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBGAE Sheet

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02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAE Sheet 04.

5 Transfer drill the tack hole from the Frame 56 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 56 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 56, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024000	Item 14

8 Clean and deburr the new fastener holes in Frame 56 and the shear web, Item 14, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBGAE Sheet 02, Views C, D and F.

a On Frame 56, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBGAE Sheet 02, View C.

1	Shear Web	E5347001024000	Item 14

b On Frame 56, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAE Sheet 02, View C.

c On Frame 56, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAE Sheet 02, View C.

d On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAE Sheet 02, View D.

e On the top flange of Frame 56, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAE Sheet 02, View F.

10 On Frame 56, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024000	Item 14

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11 Clean and deburr the cold expansion fastener holes in Frame 56 and the shear web, Item 14, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 56, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBGAE Sheet 02, View C.

1	Shear Web	E5347001024000	Item 14

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
10	Rivet	EN6069D6-07	Item 567
6	Rivet	EN6081D5-06	Item 656
6	Rivet	EN6081D6-06	Item 666
17	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
15	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
15	Pin	DAN6-6-3	Item 863

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 56, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBGAE Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

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14 On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBGAE Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

15 On the Frame 56 flange, at STGR 35 LH, refer to Fig. A-GBGAE Sheet 03, Section A-A, countersink the one fastener hole.

16 On the Frame 56 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBGAE Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 56 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAE Sheet 04.

19 On the Frame 56 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

20 Clean and deburr the new fastener holes in the Frame 56, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 56 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

22 On the Frame 56 flange, at STGR 36 LH, refer to Fig. A-GBGAE Sheet 03, Section B-B, countersink the one fastener hole.

23 On the Frame 56 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBGAE Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 56 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

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25 Transfer drill and ream the one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAE Sheet 04.

26 On the Frame 56 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

27 Clean and deburr the new fastener holes in the Frame 56, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 56 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D6-07	Item 667

29 On the Frame 56 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

30 On the aft side of the Frame 56 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBGAE Sheet 02, View C.

1	Angle	D5347046820600	Item (121)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-09	Item 669	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

31 On the Frame 56 flange, at STGR 39 LH, refer to Fig. A-GBGAE Sheet 03, Section D-D, countersink the one fastener hole.

32 On the Frame 56 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBGAE Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 56 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36	

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34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 36, refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAE Sheet 04.

35 On the Frame 56 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

36 Clean and deburr the new fastener holes in the Frame 56, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

37 On the Frame 56 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

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Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(10) Subtask 531364-831-210-011 - Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 57 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D05R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
18	E5347001025600	1	WEB	
20	E5347001123800	1	ANGLE	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	1	RIVET	
668	EN6081D6-08	17	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	19	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	10	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	11	PIN	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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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.

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBHAE Replacement of Webs and Angles at Frame 57	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBHAE Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 57, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347081820000	Item (12)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 57, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

8	Rivet		Item (100)	Discard

3 From Frame 57, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347081720000	Item (13)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 57, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347081620600	Item (14)	Discard
1	Support	D5347032200000	Item (101)	Retain

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1	Angle	D5347046820200	Item (118)	Retain
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 57.

Refer to NTM 51-10-01.

Refer to Fig. A-GBHAE Sheet 02, Views C, D and F.

1 On Frame 57, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 57, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 57, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

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(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBHAE Sheet 02 thru Fig. A-GBHAE Sheet 04.

1 On Frame 57, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBHAE Sheet 02, View C.

1	Shear Web	E5347001025600	Item 18

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 57 to the shear web, Item 18.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAE Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBHAE Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBHAE Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAE Sheet 04.

5 Transfer drill the tack hole from the Frame 57 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 57 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 57, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025600	Item 18

8 Clean and deburr the new fastener holes in Frame 57 and the shear web, Item 18, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

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Refer to Fig. A-GBHAE Sheet 02, Views C, D and F.

a On Frame 57, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBHAE Sheet 02, View C.

1	Shear Web	E5347001025600	Item 18

b On Frame 57, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAE Sheet 02, View C.

c On Frame 57, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAE Sheet 02, View C.

d On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAE Sheet 02, View D.

e On the top flange of Frame 57, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAE Sheet 02, View F.

10 On Frame 57, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025600	Item 18

11 Clean and deburr the cold expansion fastener holes in Frame 57 and the shear web, Item 18, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 57, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBHAE Sheet 02, View C.

1	Shear Web	E5347001025600	Item 18

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
13	Collar	NSA5075-6	Item 806

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6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863
1	Pin	DAN5-6-3	Item 963
2	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 57, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBHAE Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBHAE Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

15 On the Frame 57 flange, at STGR 35 LH, refer to Fig. A-GBHAE Sheet 03, Section A-A, countersink the one fastener hole.

16 On the Frame 57 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBHAE Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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17 On the Frame 57 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAE Sheet 04.

19 On the Frame 57 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

20 Clean and deburr the new fastener holes in the Frame 57, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 57 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

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22 On the Frame 57 flange, at STGR 36 LH, refer to Fig. A-GBHAE Sheet 03, Section B-B, countersink the one fastener hole.

23 On the Frame 57 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBHAE Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 57 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section B-B.

1	Angle	E5347001123800	Item 20

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 20, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the two holes from the Frame to the angle, Item 20, refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAE Sheet 04.

26 On the Frame 57 flange, at STGR 36 LH, remove:

1	Angle	E5347001123800	Item 20

27 Clean and deburr the new fastener holes in the Frame 57, STGR 36 LH and angle, Item 20, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 57 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section B-B.

1	Angle	E5347001123800	Item 20

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
1	Rivet	EN6081D6-07	Item 667	
1	Collar	NSA5075-6	Item 806	
1	Pin	DAN5-6-4	Item 964	

29 On the Frame 57 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

30 On the Frame 57 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBHAE Sheet 02, View C.

1	Angle	D5347046820200	Item (118)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-5X	Item 765	
1	Pin	DAN5-6-5Y	Item 785	

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2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

31 On the Frame 57 flange, at STGR 39 LH, refer to Fig. A-GBHAE Sheet 03, Section D-D, countersink the one fastener hole.

32 On the Frame 57 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBHAE Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 57 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBHAE Sheet 04.

35 On the Frame 57 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

36 Clean and deburr the new fastener holes in the Frame 57, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

37 On the Frame 57 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section D-D.

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1	Angle	E5347001124200	Item 36
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(11) Subtask 531364-831-211-011 - Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 58 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D05R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
22	E5347001025800	1	WEB	
24	E5347001120600	1	ANGLE	
26	E5347001120800	1	ANGLE	
70	E5347001124400	1	ANGLE	
363	EN6115K3-3	5	BOLT	
364	EN6115K3-4	3	BOLT	
374	EN6115K3A4	2	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	14	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	3	RIVET	
666	EN6081D6-06	2	RIVET	
667	EN6081D6-07	4	RIVET	
668	EN6081D6-08	4	RIVET	(1)
670	EN6081D7-10	4	RIVET	
678	EN6081D7-08	6	RIVET	
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	20	COLLAR	
807	DAN11-6X	10	COLLAR	
808	ASNA2528-3	9	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	9	PIN	
908	ASNA2528-3A	2	NUT	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	5	PIN	
965	DAN5-6-5	2	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBJAE Replacement of Webs and Angles at Frame 58	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBJAE Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 58, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347082420200	Item (15)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 58, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 58, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347080520000	Item (16)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 58, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347083020600	Item (17)	Discard
1	Support	D5347032200600	Item (104)	Retain
1	Angle	D5347046820800	Item (125)	Retain
	with			
47	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 58.

Refer to NTM 51-10-01.

Refer to Fig. A-GBJAE Sheet 02, Views C, D and F.

1 On Frame 58, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 58, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 7 holes for the fasteners, Item 363, Item 364 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 On the top flange of Frame 58, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 58, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBJAE Sheet 02 thru Fig. A-GBJAE Sheet 04.

1 On Frame 58, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBJAE Sheet 02, View C.

1	Shear Web	E5347001025800	Item 22

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

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3 Transfer drill the fastener holes from the Frame 58 to the shear web, Item 22.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAE Sheet 04.

4 Drill the additional 10 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBJAE Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBJAE Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAE Sheet 04.

5 Transfer drill the tack hole from the Frame 58 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 58 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 58, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025800	Item 22

8 Clean and deburr the new fastener holes in Frame 58 and shear web, Item 22, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBJAE Sheet 02, Views C, D and F.

a On Frame 58, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBJAE Sheet 02, View C.

1	Shear Web	E5347001025800	Item 22

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b On Frame 58, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAE Sheet 02, View C.

c On Frame 58, between STGR 36 LH and STGR 37 LH, cold expand the 5 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAE Sheet 02, View C.

d On Frame 58, between STGR 36 LH and STGR 37 LH, cold expand the 2 holes for the fasteners, Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAE Sheet 02, View C.

e On the top flange of Frame 58, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1

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DK-A320531364-1 Durable Tooling 1

EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAE Sheet 02, View D.

f On the top flange of Frame 58, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1 Capital Tooling 1

DK-A320531364-1 Durable Tooling 1

EK-A320531364-1 Expendable Tooling 1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1 Capital Tooling 1

DK-A320531364-1 Durable Tooling 1

EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAE Sheet 02, View F.

10 On Frame 58, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025800	Item 22

11 Clean and deburr the cold expansion fastener holes in Frame 58 and shear web, Item 22, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 58, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBJAE Sheet 02, View C.

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1	Shear Web	E5347001025800	Item 22
	with		
4	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
2	Bolt	EN6115K3A4	Item 374
14	Rivet	EN6069D6-07	Item 567
7	Pin	DAN5-6-4X	Item 764
8	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-06	Item 666
4	Rivet	EN6081D6-08	Item 668
6	Rivet	EN6081D7-08	Item 678
13	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
7	Nut	ASNA2528-3	Item 808
8	Pin	DAN6-6-3	Item 863
2	Nut	ASNA2528-3A	Item 908
5	Pin	DAN5-6-4	Item 964
	use		
Polysulfide Sealant - General Purpose Brushable		06AAA1	As required

13 Install 1 fastener in the flange of Frame 58, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBJAE Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 58, at STGR 35 LH, install:

Refer to Fig. A-GBJAE Sheet 02, View D.

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1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

15 On the Frame 58 flange, at STGR 35 LH, refer to Fig. A-GBJAE Sheet 03, Section A-A, countersink the one fastener hole.

16 On the Frame 58 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBJAE Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 58 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBJAE Sheet 02, View C and Fig. A-GBJAE Sheet 03, Section A-A.

1	Angle	E5347001120600	Item 24

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 24, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 24, refer to Fig. A-GBJAE Sheet 02, View C and Fig. A-GBJAE Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAE Sheet 04.

19 On the Frame 58 flange, at STGR 35 LH, remove:

1	Angle	E5347001120600	Item 24

20 Clean and deburr the new fastener holes in the Frame 58, STGR 35 LH and angle, Item 24, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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21 On the Frame 58 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBJAE Sheet 02, View C and Fig. A-GBJAE Sheet 03, Section A-A.

1	Angle	E5347001120600	Item 24
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-06	Item 656
1	Pin	DAN5-6-5X	Item 765
2	Collar	NSA5075-6	Item 806
1	Collar	DAN11-6X	Item 807
2	Pin	DAN5-6-5	Item 965

22 On the Frame 58 flange, at STGR 36 LH, refer to Fig. A-GBJAE Sheet 03, Section B-B, countersink the one fastener hole.

23 On the Frame 58 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBJAE Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 58 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBJAE Sheet 02, View C and Fig. A-GBJAE Sheet 03, Section B-B.

1	Angle	E5347001120800	Item 26

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 26, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH to the angle, Item 26, refer to Fig. A-GBJAE Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAE Sheet 04.

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26 Transfer drill and ream one new hole from the pilot hole of the angle, Item 26, to the Frame 58 flange, at STGR 36 LH, then transfer drill and ream the two holes from the Frame to the angle, Item 26, refer to Fig. A-GBJAE Sheet 02, View E.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAE Sheet 04.

27 On the Frame 58 flange, at STGR 36 LH, remove:

1	Angle	E5347001120800	Item 26

28 Clean and deburr the new fastener holes in the Frame 58, STGR 36 LH and angle, Item 26, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

29 On the Frame 58 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBJAE Sheet 02, View C and Fig. A-GBJAE Sheet 03, Section B-B.

1	Angle	E5347001120800	Item 26

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

30 On the Frame 58 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBJAE Sheet 02, View C and Fig. A-GBJAE Sheet 03, Section C-C.

1	Support	D5347032200600	Item (104)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Rivet	EN6081D7-10	Item 670	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

31 On the aft side of the Frame 58 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBJAE Sheet 02, View C.

1	Angle	D5347046820800	Item (125)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-5X	Item 765	
1	Pin	DAN5-6-5Y	Item 785	
2	Collar	DAN11-6X	Item 807	
1	Collar	DAN11-6Y	Item 809	

32 On the Frame 58 flange, at STGR 39 LH, refer to Fig. A-GBJAE Sheet 03, Section D-D, countersink the one fastener hole.

33 On the Frame 58 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBJAE Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

34 On the Frame 58 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBJAE Sheet 02, View C and Fig. A-GBJAE Sheet 03, Section D-D.

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1	Angle	E5347001124400	Item 70

35 Transfer drill and ream one new hole from the pilot hole of the angle, Item 70, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes form the Frame to the angle, Item 70, refer to Fig. A-GBJAE Sheet 02, View C and Fig. A-GBJAE Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBJAE Sheet 04.

36 On the Frame 58 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBJAE Sheet 02, View C and Fig. A-GBJAE Sheet 03, Section D-D.

1	Angle	E5347001124400	Item 70

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

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(12) Subtask 531364-831-212-012 - Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 59 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D05R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
28	E5347001026000	1	WEB	
30	E5347001121000	1	ANGLE	
32	E5347001121200	1	ANGLE	
72	E5347001124600	1	ANGLE	
363	EN6115K3-3	5	BOLT	
364	EN6115K3-4	2	BOLT	
365	EN6115K3-5	3	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	20	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	20	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	7	RIVET	(1)
669	EN6081D6-09	3	RIVET	(2)
764	DAN5-6-4X	3	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	21	COLLAR	
807	DAN11-6X	6	COLLAR	
808	ASNA2528-3	11	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	8	PIN	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	6	PIN	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
965	DAN5-6-5	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01

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References	
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBKAE Replacement of Webs and Angles at Frame 59	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBKAE Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 59, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347089120000	Item (18)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 59, at STGR 35 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

5	Rivet		Item (100)	Discard

3 From Frame 59, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347089020000	Item (19)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 59, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347088920800	Item (20)	Discard
1	Support	D5347032201000	Item (106)	Retain
1	Angle	D5347046821000	Item (127)	Retain
	with			
59	Rivet		Item (100)	Discard

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(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 59.

Refer to NTM 51-10-01.

Refer to Fig. A-GBKAE Sheet 02, Views C and D.

1 On Frame 59, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 59, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 7 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 59, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBKAE Sheet 02 thru Fig. A-GBKAE Sheet 04.

1 On Frame 59, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBKAE Sheet 02, View C.

1	Shear Web	E5347001026000	Item 28

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

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3 Transfer drill the fastener holes from the Frame 59 to the shear web, Item 28.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAE Sheet 04.

4 Drill the additional 17 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBKAE Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBKAE Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAE Sheet 04.

5 Transfer drill the tack hole from the Frame 59 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 59 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 59, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001026000	Item 28

8 Clean and deburr the new fastener holes in Frame 59 and the shear web, Item 28, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBKAE Sheet 02, Views C and D.

a On Frame 59, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBKAE Sheet 02, View C.

1	Shear Web	E5347001026000	Item 28

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b On Frame 59, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAE Sheet 02, View C.

c On Frame 59, between STGR 36 LH and STGR 37 LH, cold expand the 7 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAE Sheet 02, View C.

d On the top flange of Frame 59, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAE Sheet 02, View D.

10 On Frame 59, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001026000	Item 28

11 Clean and deburr the cold expansion fastener holes in Frame 59 and the shear web, Item 28, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 59, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBKAE Sheet 02, View C.

1	Shear Web	E5347001026000	Item 28

with

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4	Bolt	EN6115K3-3	Item 363
2	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
16	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D6-06	Item 666
5	Rivet	EN6081D6-08	Item 668
3	Pin	DAN5-6-4X	Item 764
14	Collar	NSA5075-6	Item 806
3	Collar	DAN11-6X	Item 807
6	Nut	ASNA2528-3	Item 808
8	Pin	DAN6-6-3	Item 863
6	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 59, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBKAE Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 59, at STGR 35 LH, install:

Refer to Fig. A-GBKAE Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

15 On the Frame 59 flange, at STGR 35 LH, refer to Fig. A-GBKAE Sheet 03, Section A-A, countersink the one fastener hole.

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16 On the Frame 59 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBKAE Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 59 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section A-A.

1	Angle	E5347001121000	Item 30

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 30, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 30, refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAE Sheet 04.

19 On the Frame 59 flange, at STGR 35 LH, remove:

1	Angle	E5347001121000	Item 30

20 Clean and deburr the new fastener holes in the Frame 59, STGR 35 LH and angle, Item 30, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 59 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section A-A.

1	Angle	E5347001121000	Item 30

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656
3	Collar	NSA5075-6	Item 806
3	Pin	DAN5-6-5	Item 965

22 On the Frame 59 flange, at STGR 36 LH, refer to Fig. A-GBKAE Sheet 03, Section B-B, countersink the one fastener hole.

23 On the Frame 59 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBKAE Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 59 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section B-B.

1	Angle	E5347001121200	Item 32

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 32, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 32, refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAE Sheet 04.

26 On the Frame 59 flange, at STGR 36 LH, remove:

1	Angle	E5347001121200	Item 32

27 Clean and deburr the new fastener holes in the Frame 59, STGR 36 LH and angle, Item 32, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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28 On the Frame 59 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section B-B.

1	Angle	E5347001121200	Item 32	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D6-07	Item 667	

29 On the Frame 59 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section C-C.

1	Support	D5347032201000	Item (106)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Bolt	EN6115K3-5	Item 365	
3	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
3	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	

30 On the Frame 59 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBKAE Sheet 02, View C.

1	Angle	D5347046821000	Item (127)	Retained at removal
	with			

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-5X	Item 765
1	Pin	DAN5-6-5Y	Item 785
2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

31 On the Frame 59 flange, at STGR 39 LH, refer to Fig. A-GBKAE Sheet 03, Section D-D, countersink the one fastener hole.

32 On the Frame 59 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBKAE Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 59 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section D-D.

1	Angle	E5347001124600	Item 72

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 72, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 72, refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBKAE Sheet 04.

35 On the Frame 59 flange, at STGR 39 LH, remove:

1	Angle	E5347001124600	Item 72

36 Clean and deburr the new fastener holes in the Frame 59, STGR 39 LH and angle, Item 72, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

37 On the Frame 59 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section D-D.

1	Angle	E5347001124600	Item 72

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

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(13) Subtask 531364-831-213-011 - Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 60 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D05R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
34	E5347001024200	1	WEB	
38	E5347001121600	1	ANGLE	
40	E5347001121800	1	ANGLE	
86	E5347001125600	1	ANGLE	
363	EN6115K3-3	5	BOLT	
365	EN6115K3-5	8	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	3	RIVET	
567	EN6069D6-07	20	RIVET	
656	EN6081D5-06	43	RIVET	
666	EN6081D6-06	27	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	4	RIVET	(2)
764	DAN5-6-4X	5	PIN	
765	DAN5-6-5X	1	PIN	
806	NSA5075-6	5	COLLAR	
807	DAN11-6X	6	COLLAR	
808	ASNA2528-3	14	NUT	
963	DAN5-6-3	5	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBLAE Replacement of Webs and Angles at Frame 60	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBLAE Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 60, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347085020000	Item (21)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 60, at STGR 35 LH and from the frame flange between STGR 34 LH and STGR 35 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 60, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347085120000	Item (22)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 60, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347093121000	Item (23)	Discard
1	Support	D5347032201200	Item (108)	Retain
1	Angle	D5347046821200	Item (128)	Retain
	with			
63	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 60.

Refer to NTM 51-10-01.

Refer to Fig. A-GBLAE Sheet 02, Views C and D.

1 On Frame 60, at STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 60, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 60, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBLAE Sheet 02 thru Fig. A-GBLAE Sheet 04.

1 On Frame 60, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBLAE Sheet 02, View C.

1	Shear Web	E5347001024200	Item 34

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 60 to the shear web, Item 34.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAE Sheet 04.

4 Drill the additional 38 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBLAE Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBLAE Sheet 02.

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NOTE: For the hole diameters, refer to the table on Fig. A-GBLAE Sheet 04.

5 Transfer drill the tack hole from the Frame 60 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 60 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 60, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024200	Item 34

8 Clean and deburr the new fastener holes in Frame 60 and the shear web, Item 34, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBLAE Sheet 02, Views C and D.

a On Frame 60, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBLAE Sheet 02, View C.

1	Shear Web	E5347001024200	Item 34

b On Frame 60, at STGR 35 LH, cold expand the 4 holes for the fasteners, Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAE Sheet 02, View C.

c On Frame 60, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAE Sheet 02, View C.

d On the top flange of Frame 60, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAE Sheet 02, View D.

10 On Frame 60, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024200	Item 34

11 Clean and deburr the cold expansion fastener holes in Frame 60 and the shear web, Item 34, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 60, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBLAE Sheet 02, View C.

1	Shear Web	E5347001024200	Item 34

with

5	Bolt	EN6115K3-3	Item 363
20	Rivet	EN6069D6-07	Item 567
37	Rivet	EN6081D5-06	Item 656
25	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
4	Pin	DAN5-6-4X	Item 764
4	Collar	DAN11-6X	Item 807
5	Nut	ASNA2528-3	Item 808

use

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 On the top flange of Frame 60, at STGR 35 LH, install:

Refer to Fig. A-GBLAE Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

14 On the Frame 60 flange, at STGR 35 LH, refer to Fig. A-GBLAE Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 60 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBLAE Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 60 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBLAE Sheet 02, View C and Fig. A-GBLAE Sheet 03, Section A-A.

1	Angle	E5347001121600	Item 38

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 38, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH to the angle, Item 38, refer to Fig. A-GBLAE Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAE Sheet 04.

18 On the Frame 60 flange, at STGR 35 LH, remove:

1	Angle	E5347001121600	Item 38

19 Clean and deburr the new fastener holes in the STGR 35 LH and the angle, Item 38, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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	Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 60 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBLAE Sheet 02, View C and Fig. A-GBLAE Sheet 03, Section A-A.

1	Angle	E5347001121600	Item 38
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
4	Bolt	EN6115K3-5	Item 365
2	Rivet	EN6081D5-06	Item 656
4	Nut	ASNA2528-3	Item 808

21 On the Frame 60 flange, at STGR 36 LH, refer to Fig. A-GBLAE Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 60 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBLAE Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 60 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBLAE Sheet 02, View C and Fig. A-GBLAE Sheet 03, Section B-B.

1	Angle	E5347001121800	Item 40

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 40, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 40, refer to Fig. A-GBLAE Sheet 02, View C and Fig. A-GBLAE Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAE Sheet 04.

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25 On the Frame 60 flange, at STGR 36 LH, remove:

1	Angle	E5347001121800	Item 40	

26 Clean and deburr the new fastener holes in the Frame 60, STGR 36 LH and angle, Item 40, Item 40, use:

Textile - Lint Free Cotton	14SBA1	As required	

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required	

27 On the Frame 60 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBLAE Sheet 02, View C and Fig. A-GBLAE Sheet 03, Section B-B.

1	Angle	E5347001121800	Item 40	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D6-07	Item 667	

28 On the Frame 60 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBLAE Sheet 02, View C and Fig. A-GBLAE Sheet 03, Section C-C.

1	Support	D5347032201200	Item (108)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	
5	Collar	NSA5075-6	Item 806	

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4	Nut	ASNA2528-3	Item 808	
5	Pin	DAN5-6-3	Item 963	

29 On the aft side of the Frame 60 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBLAE Sheet 02, View C.

1	Angle	D5347046821200	Item (128)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

30 On the Frame 60 flange, at STGR 39 LH, refer to Fig. A-GBLAE Sheet 03, Section D-D, countersink the one fastener hole.

31 On the Frame 60 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBLAE Sheet 03, Section D-D.

1	Rivet	EN6069D5-05	Item 555	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

32 On the Frame 60 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBLAE Sheet 02, View C and Fig. A-GBLAE Sheet 03, Section D-D.

1	Angle	E5347001125600	Item 86	

33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 86, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 86, refer to Fig. A-GBLAE Sheet 02, View C and Fig. A-GBLAE Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAE Sheet 04.

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34 On the Frame 60 flange, at STGR 39 LH, remove:

1	Angle	E5347001125600	Item 86

35 Clean and deburr the new fastener holes in the Frame 60, STGR 39 LH and angle, Item 86, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

36 On the Frame 60 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBLAE Sheet 02, View C and Fig. A-GBLAE Sheet 03, Section D-D.

1	Angle	E5347001125600	Item 86

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

1	Pin	DAN5-6-4X	Item 764
1	Collar	DAN11-6X	Item 807
2	Rivet	EN6081D6-06	Item 666
2	Rivet	EN6081D5-06	Item 656

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

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Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(14) Subtask 531364-831-214-011 - Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 61 from Stringer 33 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D05R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
42	E5347001022000	1	WEB	
44	E5347001122000	1	ANGLE	
46	E5347001122200	1	ANGLE	
48	E5347001122400	1	ANGLE	
74	E5347001124800	1	ANGLE	
363	EN6115K3-3	6	BOLT	
364	EN6115K3-4	3	BOLT	
365	EN6115K3-5	4	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	4	RIVET	
567	EN6069D6-07	24	RIVET	
656	EN6081D5-06	36	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	23	RIVET	
667	EN6081D6-07	10	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	6	RIVET	(2)
763	DAN5-6-3X	4	PIN	
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
807	DAN11-6X	13	COLLAR	
808	ASNA2528-3	14	NUT	

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NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBMAE Replacement of Webs and Angles at Frame 61	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBMAE Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 61, between STGR 33 LH and STGR 34 LH, remove:

1	Clip	D5347091620200	Item (24)	Discard
	with			
12	Rivet		Item (100)	Discard
	or			
13	Rivet		Item (100)	Discard

NOTE: Depending on installation on aircraft.

2 From Frame 61, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347090620000	Item (25)	Discard
	with			
13	Rivet		Item (100)	Discard

3 From the top flange of Frame 61, between STGR 34 LH and STGR 35 LH and from the frame flange between STGR 34 LH and STGR 35 LH, remove:

11	Rivet		Item (100)	Discard

4 From Frame 61, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347090720000	Item (26)	Discard
	with			
13	Rivet		Item (100)	Discard

5 From Frame 61, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347090821000	Item (27)	Discard
1	Support	D5347032201600	Item (109)	Retain
1	Angle	D5347046821400	Item (130)	Retain

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with

65	Rivet	Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 61.

Refer to NTM 51-10-01.

Refer to Fig. A-GBMAE Sheet 02, Views C and E.

1 On Frame 61, at STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 61, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 61, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBMAE Sheet 02 thru Fig. A-GBMAE Sheet 04.

1 On Frame 61, between STGR 33 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBMAE Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

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2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 61 to the shear web, Item 42.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAE Sheet 04.

4 Drill the additional 31 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBMAE Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBMAE Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAE Sheet 04.

5 Transfer drill the tack hole from the Frame 61 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 61 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 61, between STGR 33 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022000	Item 42

8 Clean and deburr the new fastener holes in Frame 61 and the shear web, Item 42, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBMAE Sheet 02, Views C and E.

a On Frame 61, between STGR 33 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBMAE Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

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b On Frame 61, at STGR 35 LH, cold expand the 4 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAE Sheet 02, View C.

c On Frame 61, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAE Sheet 02, View C.

d On the top flange of Frame 61, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAE Sheet 02, View E.

10 On Frame 61, between STGR 33 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022000	Item 42

11 Clean and deburr the cold expansion fastener holes in Frame 61 and the shear web, Item 42, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 61, between STGR 33 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBMAE Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

with

6	Bolt	EN6115K3-3	Item 363

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3	Bolt	EN6115K3-4	Item 364
24	Rivet	EN6069D6-07	Item 567
28	Rivet	EN6081D5-06	Item 656
22	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
6	Collar	DAN11-6X	Item 807
9	Nut	ASNA2528-3	Item 808

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 On the top flange of Frame 61, at STGR 35 LH, install:

Refer to Fig. A-GBMAE Sheet 02, View E.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

14 On the Frame 61 flange, at STGR 34 LH, refer to Fig. A-GBMAE Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 61 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBMAE Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 61 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section A-A.

1	Angle	E5347001122000	Item 44

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17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 44, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH and the three holes from the Frame to the angle, Item 44, refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAE Sheet 04.

18 On the Frame 61 flange, at STGR 34 LH, remove:

1	Angle	E5347001122000	Item 44

19 Clean and deburr the new fastener holes in the Frame 61, STGR 34 LH and angle, Item 44, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 61 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section A-A.

1	Angle	E5347001122000	Item 44

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

If necessary, close the rivet hole in the frame flange at STGR 34 LH with:

1	Rivet	EN6081D6-06	Item 666

NOTE: Depending on installation on aircraft.

21 On the Frame 61 flange, at STGR 35 LH, refer to Fig. A-GBMAE Sheet 03, Section B-B, countersink the one fastener hole.

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22 On the Frame 61 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBMAE Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 61 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section B-B.

1	Angle	E5347001122200	Item 46

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 46, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the four holes from the Frame to the angle, Item 46, refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAE Sheet 04.

25 On the Frame 61 flange, at STGR 35 LH, remove:

1	Angle	E5347001122200	Item 46

26 Clean and deburr the new fastener holes in the Frame 61, STGR 35 LH and angle, Item 46, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 61 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section B-B.

1	Angle	E5347001122200	Item 46

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656
4	Rivet	EN6081D6-07	Item 667

28 On the Frame 61 flange, at STGR 36 LH, refer to Fig. A-GBMAE Sheet 03, Section C-C, countersink the one fastener hole.

29 On the Frame 61 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBMAE Sheet 03, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

30 On the Frame 61 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section C-C.

1	Angle	E5347001122400	Item 48

31 Transfer drill and ream one new hole from the pilot hole of the angle, Item 48, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 48, refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAE Sheet 04.

32 On the Frame 61 flange, at STGR 36 LH, remove:

1	Angle	E5347001122400	Item 48

33 Clean and deburr the new fastener holes in the Frame 61, STGR 36 LH and angle, Item 48, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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34 On the Frame 61 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section C-C.

1	Angle	E5347001122400	Item 48	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

35 On the Frame 61 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section D-D.

1	Support	D5347032201600	Item (109)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	
4	Pin	DAN5-6-3X	Item 763	
4	Collar	DAN11-6X	Item 807	
4	Nut	ASNA2528-3	Item 808	

36 On the Frame 61 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBMAE Sheet 02, View C.

1	Angle	D5347046821400	Item (130)	Retained at removal
	with			

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

3	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

37 On the Frame 61 flange, at STGR 39 LH, refer to Fig. A-GBMAE Sheet 03, Section E-E, countersink the one fastener hole.

38 On the Frame 61 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section E-E.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

39 On the Frame 61 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section E-E.

1	Angle	E5347001124800	Item 74

40 Transfer drill and ream one new hole from the pilot hole of the angle, Item 74, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the four holes from the Frame to the angle, Item 74, refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section E-E.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAE Sheet 04.

41 On the Frame 61 flange, at STGR 39 LH, remove:

1	Angle	E5347001124800	Item 74

42 Clean and deburr the new fastener holes in the Frame 61, STGR 39 LH and angle, Item 74, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

43 On the Frame 61 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section E-E.

1	Angle	E5347001124800	Item 74

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

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(15) Subtask 531364-831-215-011 - Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 62 from Stringer 32 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D05R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
50	E5347001022200	1	WEB	
52	E5347001122600	1	ANGLE	
54	E5347001122800	1	ANGLE	
56	E5347001123000	1	ANGLE	
58	E5347001123200	1	ANGLE	
76	E5347001125000	1	ANGLE	
363	EN6115K3-3	6	BOLT	
364	EN6115K3-4	3	BOLT	
365	EN6115K3-5	4	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	5	RIVET	
567	EN6069D6-07	28	RIVET	
568	EN6069D6-08	1	RIVET	
656	EN6081D5-06	45	RIVET	
657	EN6081D5-07	7	RIVET	
666	EN6081D6-06	21	RIVET	
667	EN6081D6-07	7	RIVET	
668	EN6081D6-08	16	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	5	PIN	
765	DAN5-6-5X	3	PIN	
806	NSA5075-6	9	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	14	NUT	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	
965	DAN5-6-5	1	PIN	

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NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBNAE Replacement of Webs and Angles at Frame 62	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBNAE Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 62, between STGR 32 LH and STGR 33 LH, remove:

1	Clip	D5347093420200	Item (28)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From Frame 62, between STGR 33 LH and STGR 34 LH, remove:

1	Clip	D5347084020000	Item (29)	Discard
	with			
13	Rivet		Item (100)	Discard

3 From Frame 62, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347084120000	Item (30)	Discard
	with			
11	Rivet		Item (100)	Discard

4 From the top flange of Frame 62, at STGR 34 LH and from the frame flange between STGR 32 LH and STGR 35 LH, remove:

13	Rivet		Item (100)	Discard
	or			
14	Rivet		Item (100)	Discard

NOTE: Depending on installation on aircraft.

5 From Frame 62, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347084220000	Item (31)	Discard
	with			

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11	Rivet		Item (100)	Discard

6 From Frame 62, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347084820800	Item (32)	Discard
1	Support	D5347032201800	Item (111)	Retain
1	Angle	D5347046821600	Item (131)	Retain
	with			
58	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 62.

Refer to NTM 51-10-01.

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 03, View F.

1 On Frame 62, between STGR 34 LH and STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 62, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

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5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBNAE Sheet 02 thru Fig. A-GBNAE Sheet 06.

1 On Frame 62, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBNAE Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 62 to the shear web, Item 50.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAE Sheet 06.

4 On Frame 62, between STGR 34 LH and STGR 37 LH, drill the additional 42 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBNAE Sheet 03, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBNAE Sheet 03.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAE Sheet 06.

5 On Frame 62, between STGR 38 LH and STGR 39 LH, drill the additional rivet hole to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBNAE Sheet 03, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBNAE Sheet 03.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAE Sheet 06.

6 Transfer drill the tack hole from the Frame 62 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

7 Transfer drill the tack hole from the Frame 62 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

8 On Frame 62, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022200	Item 50

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9 Clean and deburr the new fastener holes in Frame 62 and the shear web, Item 50, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

10 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 03, View F.

a On Frame 62, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBNAE Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

b On Frame 62, between STGR 34 LH and STGR 35 LH, cold expand the 4 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAE Sheet 02, View C.

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c On Frame 62, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAE Sheet 02, View C.

d On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAE Sheet 03, View F.

11 On Frame 62, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022200	Item 50

12 Clean and deburr the cold expansion fastener holes in Frame 62 and the shear web, Item 50, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

13 On the shear web, Item 50, at Frame 62, between STGR 32 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBNAE Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

with

6	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
28	Rivet	EN6069D6-07	Item 567
1	Rivet	EN6069D6-08	Item 568
35	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D5-07	Item 657
20	Rivet	EN6081D6-06	Item 666
13	Rivet	EN6081D6-08	Item 668
5	Pin	DAN5-6-4X	Item 764
4	Collar	NSA5075-6	Item 806
5	Collar	DAN11-6X	Item 807
9	Nut	ASNA2528-3	Item 808
1	Pin	DAN5-6-3	Item 963

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3	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

14 On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBNAE Sheet 03, View F.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

15 On the Frame 62 flange, at STGR 33 LH, refer to Fig. A-GBNAE Sheet 04, Section A-A, countersink the one fastener hole.

16 On the Frame 62 flange, at STGR 33 LH, close the rivet hole in STGR 33 LH with:

Refer to Fig. A-GBNAE Sheet 04, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 62 flange, at STGR 33 LH, put in position:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section A-A.

1	Angle	E5347001122600	Item 52

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 52, to the STGR 33 LH, then transfer drill and ream the other hole from STGR 33 LH and the three holes from the Frame to the angle, Item 52, refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAE Sheet 06.

19 On the Frame 62 flange, at STGR 33 LH, remove:

1	Angle	E5347001122600	Item 52

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20 Clean and deburr the new fastener holes in the Frame 62, STGR 33 LH and angle, Item 52, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 62 flange, at STGR 33 LH, wet install:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section A-A.

1	Angle	E5347001122600	Item 52

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Collar	NSA5075-6	Item 806
1	Pin	DAN5-6-5	Item 965

If necessary, close the rivet hole in the frame flange at STGR 33 LH with:

1	Rivet	EN6081D6-06	Item 666

NOTE: Depending on installation on aircraft.

22 On the Frame 62 flange, at STGR 34 LH, refer to Fig. A-GBNAE Sheet 04, Section B-B, countersink the one fastener hole.

23 On the Frame 62 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBNAE Sheet 04, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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24 On the Frame 62 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section B-B.

1	Angle	E5347001122800	Item 54

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 54, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH and the three holes from the Frame to the angle, Item 54, refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAE Sheet 06.

26 On the Frame 62 flange, at STGR 34 LH, remove:

1	Angle	E5347001122800	Item 54

27 Clean and deburr the new fastener holes in the Frame 62, STGR 34 LH and angle, Item 54, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 62 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section B-B.

1	Angle	E5347001122800	Item 54

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

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29 On the Frame 62 flange, at STGR 34 LH, install:

Refer to Fig. A-GBNAE Sheet 02, View C.

1	Rivet	EN6081D6-07	Item 667

30 On the Frame 62 flange, at STGR 35 LH, refer to Fig. A-GBNAE Sheet 04, Section C-C, countersink the one fastener hole.

31 On the Frame 62 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBNAE Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

32 On the Frame 62 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section C-C.

1	Angle	E5347001123000	Item 56

33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 56, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the five holes from the Frame to the angle, Item 56, refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAE Sheet 06.

34 On the Frame 62 flange, at STGR 35 LH, remove:

1	Angle	E5347001123000	Item 56

35 Clean and deburr the new fastener holes in the Frame 62, STGR 35 LH and angle, Item 56, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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36 On the Frame 62 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section C-C.

1	Angle	E5347001123000	Item 56
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

37 On the Frame 62 flange, at STGR 36 LH, refer to Fig. A-GBNAE Sheet 04, Section D-D, countersink the one fastener hole.

38 On the Frame 62 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBNAE Sheet 04, Section D-D.

1	Rivet	EN6069D5-05	Item 555
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

39 On the Frame 62 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section D-D.

1	Angle	E5347001123200	Item 58

40 Transfer drill and ream one new hole from the pilot hole of the angle, Item 58, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes form the Frame to the angle, Item 58, refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAE Sheet 06.

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41 On the Frame 62 flange, at STGR 36 LH, remove:

1	Angle	E5347001123200	Item 58	

42 Clean and deburr the new fastener holes in the Frame 62, STGR 36 LH and angle, Item 58, use:

Textile - Lint Free Cotton	14SBA1	As required	

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required	

43 On the Frame 62 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section D-D.

1	Angle	E5347001123200	Item 58	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	

44 On the Frame 62 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 05, Section E-E.

1	Support	D5347032201800	Item (111)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	

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4	Collar	NSA5075-6	Item 806	
4	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	

45 On the aft side of the Frame 62 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBNAE Sheet 02, View C.

1	Angle	D5347046821600	Item (131)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

3	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

46 On the Frame 62 flange, at STGR 39 LH, refer to Fig. A-GBNAE Sheet 05, Section F-F, countersink the one fastener hole.

47 On the Frame 62 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBNAE Sheet 05, Section F-F.

1	Rivet	EN6069D5-05	Item 555	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

48 On the Frame 62 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 05, Section F-F.

1	Angle	E5347001125000	Item 76	

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49 Transfer drill and ream one new hole from the pilot hole of the angle, Item 76, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes form the Frame to the angle, Item 76, refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 05, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBNAE Sheet 04.

50 On the Frame 62 flange, at STGR 39 LH, remove:

1	Angle	E5347001125000	Item 76

51 Clean and deburr the new fastener holes in the Frame 62, STGR 39 LH and angle, Item 76, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

52 On the Frame 62 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 05, Section F-F.

1	Angle	E5347001125000	Item 76

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(16) Subtask 531364-831-216-011 - Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 63 from Stringer 32 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D05R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
60	E5347001022400	1	WEB	
62	E5347001123400	1	ANGLE	
64	E5347001123600	2	ANGLE	
78	E5347001125200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
365	EN6115K3-5	8	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	4	RIVET	
567	EN6069D6-07	23	RIVET	
568	EN6069D6-08	1	RIVET	
656	EN6081D5-06	43	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	22	RIVET	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
667	EN6081D6-07	6	RIVET	
668	EN6081D6-08	12	RIVET	(1)
669	EN6081D6-09	7	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	8	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	13	NUT	
963	DAN5-6-3	8	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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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.

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBPAE Replacement of Webs and Angles at Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBPAE Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 63, at STGR 33 LH, remove:

1	Shim	D5347032020200	Item (132)	Retain
1	Sheet-Support	D5347109620000	Item (133)	Retain
	with			
7	Rivet		Item (100)	Discard

2 From Frame 63, between STGR 32 LH and STGR 34 LH, remove:

1	Clip	D5347082820000	Item (33)	Discard
	with			
21	Rivet		Item (100)	Discard

3 From the top flange of Frame 63, at STGR 34 LH and from the frame flange between STGR 33 LH and STGR 34 LH, remove:

5	Rivet		Item (100)	Discard

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4 From Frame 63, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347079220000	Item (34)	Discard
	with			
10	Rivet		Item (100)	Discard

5 From Frame 63, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347079920000	Item (35)	Discard
	with			
11	Rivet		Item (100)	Discard

6 From Frame 63, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347082920600	Item (36)	Discard
1	Support	D5347032202000	Item (114)	Retain
1	Angle	D5347046821800	Item (115)	Retain
	with			
54	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 63.

Refer to NTM 51-10-01.

Refer to Fig. A-GBPAE Sheet 02, Views C and D.

1 On Frame 63, at STGR 34 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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2 On Frame 63, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 8 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 63, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBPAE Sheet 02 thru Fig. A-GBPAE Sheet 06.

1 On Frame 63, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBPAE Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 63 to the shear web, Item 60.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAE Sheet 06.

4 On Frame 63, between STGR 34 LH and STGR 37 LH, drill the additional 41 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBPAE Sheet 03, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBPAE Sheet 03.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAE Sheet 06.

5 Transfer drill the tack hole from the Frame 63 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 63 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

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7 On Frame 63, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022400	Item 60

8 Clean and deburr the new fastener holes in Frame 63 and the shear web, Item 60, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBPAE Sheet 02, Views C and D.

a On Frame 63, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBPAE Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

b On Frame 63, at STGR 34 LH, cold expand the 4 holes for the fasteners, Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAE Sheet 02, View C.

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c On Frame 63, between STGR 36 LH and STGR 37 LH, cold expand the 8 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAE Sheet 02, View C.

d On the top flange of Frame 63, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAE Sheet 02, View D.

10 On Frame 63, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022400	Item 60

11 Clean and deburr the cold expansion fastener holes in Frame 63 and the shear web, Item 60, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 63, between STGR 32 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBPAE Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

with

4	Bolt	EN6115K3-3	Item 363
23	Rivet	EN6069D6-07	Item 567
1	Rivet	EN6069D6-08	Item 568
35	Rivet	EN6081D5-06	Item 656
22	Rivet	EN6081D6-06	Item 666
10	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
6	Collar	DAN11-6X	Item 807
4	Nut	ASNA2528-3	Item 808

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 On the Frame 63 flange, at STGR 33 LH, wet install:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 04, Section A-A.

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1	Shim	D5347032020200	Item (132)	Retained at removal
1	Sheet-Support	D5347109620000	Item (133)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

3	Rivet	EN6081D6-09	Item 669
4	Collar	NSA5075-6	Item 806
4	Pin	DAN5-6-3	Item 963

14 On the Frame 63 flange, at STGR 34 LH, refer to Fig. A-GBPAE Sheet 04, Section B-B, countersink the one fastener hole.

15 On the Frame 63 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBPAE Sheet 04, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 63 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 04, Section B-B.

1	Angle	E5347001123400	Item 62

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 62, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH to the angle, Item 62, refer to Fig. A-GBPAE Sheet 04, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAE Sheet 06.

18 On the Frame 63 flange, at STGR 34 LH, remove:

1	Angle	E5347001123400	Item 62

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19 Clean and deburr the new fastener holes in the STGR 34 LH and angle, Item 62, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 63 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 04, Section B-B.

1	Angle	E5347001123400	Item 62

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
2	Rivet	EN6081D5-06	Item 656
4	Nut	ASNA2528-3	Item 808

21 On the top flange of Frame 63, at STGR 35 LH, install:

Refer to Fig. A-GBPAE Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

22 On the Frame 63 flange, at STGR 35 LH, refer to Fig. A-GBPAE Sheet 04, Section C-C, countersink the one fastener hole.

23 On the Frame 63 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBPAE Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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24 On the Frame 63 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 64, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the five holes from the Frame to the angle, Item 64, refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAE Sheet 06.

26 On the Frame 63 flange, at STGR 35 LH, remove:

1	Angle	E5347001123600	Item 64

27 Clean and deburr the new fastener holes in the Frame 63, STGR 35 LH and angle, Item 64, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 63 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

29 On the Frame 63 flange, at STGR 36 LH, refer to Fig. A-GBPAE Sheet 04, Section C-C, countersink the one fastener hole.

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30 On the Frame 63 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBPAE Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

31 On the Frame 63 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

32 Transfer drill and ream one new hole from the pilot hole of the angle, Item 64, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 64, refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAE Sheet 06.

33 On the Frame 63 flange, at STGR 36 LH, remove:

1	Angle	E5347001123600	Item 64

34 Clean and deburr the new fastener holes in the Frame 63, STGR 36 LH and angle, Item 64, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

35 On the Frame 63 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	

36 On the Frame 63 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 05, Section D-D.

1	Support	D5347032202000	Item (114)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
4	Rivet	EN6081D6-09	Item 669
4	Collar	NSA5075-6	Item 806
4	Nut	ASNA2528-3	Item 808
4	Pin	DAN5-6-3	Item 963

37 On the Frame 63 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBPAE Sheet 02, View C.

1	Angle	D5347046821800	Item (115)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

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38 On the Frame 63 flange, at STGR 39 LH, refer to Fig. A-GBPAE Sheet 05, Section E-E, countersink the one fastener hole.

39 On the Frame 63 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBPAE Sheet 05, Section E-E.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

40 On the Frame 63 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 05, Section E-E.

1	Angle	E5347001125200	Item 78

41 Transfer drill and ream one new hole from the pilot hole of the angle, Item 78, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 78, refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 05, Section E-E.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAE Sheet 06.

42 On the Frame 63 flange, at STGR 39 LH, remove:

1	Angle	E5347001125200	Item 78

43 Clean and deburr the new fastener holes in the Frame 63, STGR 39 LH and angle, Item 78, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

44 On the Frame 63 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 05, Section E-E.

1	Angle	E5347001125200	Item 78

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(17) Subtask 531364-831-217-011 - Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 Stringer 38 LH
To	160	Work location	from Frame 60 to Frame 63 Stringer 38 LH

Manpower Resources	
Manhours	6.50
Minimum number of person	2
Subtask elapsed time	6.50
Skills	AIRFRAME

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Material necessary to do the job

Kit 531364D05R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
544	EN6069D4-04	4	RIVET	
545	EN6069D4-05	52	RIVET	
655	EN6081D5-05	15	RIVET	
656	EN6081D5-06	189	RIVET	
657	EN6081D5-07	59	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	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12 53-41-14
Fig. A-GBQAE Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Install the shear plates.

Refer to Fig. A-GBQAE Sheet 01 thru Fig. A-GBQAE Sheet 06.

1 Between Frame 49 and Frame 50, on STGR 38 LH and on the bracket, Item 66, put in position:

Refer to Fig. A-GBQAE Sheet 02, View D.

1	Plate-Shear	D5347471500000	Item (139)	Retained at removal

2 Transfer drill and ream the three holes from the shear plate, Item (139), to the bracket, Item 66, refer to Fig. A-GBQAE Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAE Sheet 06.

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3 Between Frame 49 and Frame 50, on STGR 38 LH, remove:

1	Plate-Shear	D5347471500000	Item (139)	Retain

4 Between Frame 49 and Frame 50, on STGR 38 LH, clean and deburr the new fastener holes in the bracket, Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

5 Between Frame 49 and Frame 50, on STGR 38 LH and on the bracket, Item 66, wet install:

Refer to Fig. A-GBQAE Sheet 02, View D.

1	Plate-Shear	D5347471500000	Item (139)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545
6	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D5-07	Item 657

6 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item 66, put in position:

Refer to Fig. A-GBQAE Sheet 02, View D.

1	Plate-Shear	D5347471500200	Item (117)	Retained at removal

7 Transfer drill and ream the six holes from the shear plate, Item (117), to the brackets, Item 65 and Item 66, refer to Fig. A-GBQAE Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAE Sheet 06.

8 Between Frame 50 and Frame 51, on STGR 38 LH, remove:

1	Plate-Shear	D5347471500200	Item (117)	Retain

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9 Between Frame 50 and Frame 51, on STGR 38 LH, clean and deburr the new fastener holes in the brackets, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

10 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item 66, wet install:

Refer to Fig. A-GBQAE Sheet 02, View D.

1	Plate-Shear	D5347471500200	Item (117)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545
6	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D5-07	Item 657

11 Between Frame 51 and Frame 52, on STGR 38 LH and on the brackets, Item 65 and Item (140), put in position:

Refer to Fig. A-GBQAE Sheet 02, View D.

1	Plate-Shear	D5347471502800	Item (180)	Retained at removal

12 Transfer drill and ream the three holes from the shear plate, Item (180), to the bracket, Item 65, refer to Fig. A-GBQAE Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAE Sheet 06.

13 Between Frame 51 and Frame 52, on STGR 38 LH, remove:

1	Plate-Shear	D5347471502800	Item (180)	Retain

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14 Between Frame 51 and Frame 52, on STGR 38 LH, clean and deburr the new fastener holes in the bracket, Item 65, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

15 Between Frame 51 and Frame 52, on STGR 38 LH and on the brackets, Item 65 and Item (140), wet install:

Refer to Fig. A-GBQAE Sheet 02, View D.

1	Plate-Shear	D5347471502800	Item (180)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545
6	Rivet	EN6081D5-06	Item 656
19	Rivet	EN6081D5-07	Item 657

16 Between Frame 52 and Frame 53, on STGR 38 LH and on the brackets, Item (116) and Item 68, put in position:

Refer to Fig. A-GBQAE Sheet 03, View F.

1	Plate-Shear	D5347471503000	Item (190)	Retained at removal

17 Transfer drill and ream the three holes from the shear plate, Item (190), to the bracket, Item 68, refer to Fig. A-GBQAE Sheet 03, View F.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAE Sheet 06.

18 Between Frame 52 and Frame 53, on STGR 38 LH, remove:

1	Plate-Shear	D5347471503000	Item (190)	Retain

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19 Between Frame 52 and Frame 53, on STGR 38 LH, clean and deburr the new fastener holes in the bracket, Item 68, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 Between Frame 52 and Frame 53, on STGR 38 LH and on the brackets, Item (116) and Item 68, wet install:

Refer to Fig. A-GBQAE Sheet 03, View F.

1	Plate-Shear	D5347471503000	Item (190)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545
27	Rivet	EN6081D5-06	Item 656

21 Between Frame 53 and Frame 54, on STGR 38 LH and on the brackets, Item 80 and Item 82, put in position:

Refer to Fig. A-GBQAE Sheet 03, View F.

1	Plate-Shear	D5347471501000	Item (141)	Retained at removal

22 Transfer drill and ream the six holes from the shear plate, Item (141), to the brackets, Item 80 and Item 82, refer to Fig. A-GBQAE Sheet 03, View F.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAE Sheet 06.

23 Between Frame 53 and Frame 54, on STGR 38 LH, remove:

1	Plate-Shear	D5347471501000	Item (141)	Retain

24 Between Frame 53 and Frame 54, on STGR 38 LH, clean and deburr the new fastener holes in the brackets, Item 80 and Item 82, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

25 Between Frame 53 and Frame 54, on STGR 38 LH and on the brackets, Item 80 and Item 82, wet install:

Refer to Fig. A-GBQAE Sheet 03, View F.

1	Plate-Shear	D5347471501000	Item (141)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545	
26	Rivet	EN6081D5-06	Item 656	

26 Between Frame 54 and Frame 55, on STGR 38 LH and on the brackets, Item 84 and Item (120), put in position:

Refer to Fig. A-GBQAE Sheet 03, View F.

1	Plate Assy-Shear	D5347048800400	Item (122)	Retained at removal

27 Transfer drill and ream the three holes from the shear plate, Item (122), to the bracket, Item 84, refer to Fig. A-GBQAE Sheet 03, View F.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAE Sheet 06.

28 Between Frame 54 and Frame 55, on STGR 38 LH, remove:

1	Plate Assy-Shear	D5347048800400	Item (122)	Retain

29 Between Frame 54 and Frame 55, on STGR 38 LH, clean and deburr the new fastener holes in the bracket, Item 84, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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30 Between Frame 54 and Frame 55, on STGR 38 LH and on the brackets, Item 84 and Item (120), wet install:

Refer to Fig. A-GBQAE Sheet 03, View F.

1	Plate Assy-Shear	D5347048800400	Item (122)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
14	Rivet	EN6069D4-05	Item 545	
26	Rivet	EN6081D5-06	Item 656	

31 Between Frame 56 and Frame 57, on STGR 38 LH and on the brackets, Item (121) and Item (118), wet install:

Refer to Fig. A-GBQAE Sheet 04, View H.

1	Plate Assy-Shear	D5347048900000	Item (124)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
14	Rivet	EN6069D4-05	Item 545	
26	Rivet	EN6081D5-06	Item 656	

32 Between Frame 58 and Frame 59, on STGR 38 LH and on the brackets, Item (125) and Item (127), wet install:

Refer to Fig. A-GBQAE Sheet 05, View K.

1	Plate-Shear	D5347049200200	Item (126)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			

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14	Rivet	EN6069D4-05	Item 545	
26	Rivet	EN6081D5-06	Item 656	

33 Between Frame 60 and Frame 61, on STGR 38 LH and on the brackets, Item (128) and Item (130), wet install:

Refer to Fig. A-GBQAE Sheet 05, View M.

1	Plate-Shear	D5347049300200	Item (129)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-04	Item 544	
8	Rivet	EN6081D5-05	Item 655	
20	Rivet	EN6081D5-06	Item 656	

34 Between Frame 62 and Frame 63, on STGR 38 LH and on the brackets, Item (131) and Item (115), wet install:

Refer to Fig. A-GBQAE Sheet 06, View P.

1	Plate-Shear	D5347049400000	Item (123)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-04	Item 544	
7	Rivet	EN6081D5-05	Item 655	
20	Rivet	EN6081D5-06	Item 656	

(b) Install the corner profiles.

In accordance with SRM 53-41-14.

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1 Between Frame 48 thru Frame 63, at STGR 38 LH, install the corner profiles, if removed in accordance with SRM 53-41-14 C2 Identification - Floor Structure - Cargo Compartment.

(c) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(18) Subtask 531364-831-218-002 - Install new Surface Protection on Frame 50 thru Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 from Stringer 31 to Stringer 39
To	160	Work location	from Frame 60 to Frame 63 from Stringer 31 to Stringer 39

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	NON SPECIFIC

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	04JME4	As required	
	Coating - Flexible Structure	04QAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound	12ADB1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

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References	
Structural Repair Manual (SRM)	51-23-12

(a) Clean the working area with:

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

(b) Apply sealant beads around the edges of all new and reinstalled structure parts with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(c) Apply to all sealant beads:

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(d) Apply to all sealant beads:

Top Coat Polyurethane	04JME4	As required
and		
Coating - Flexible Structure	04QAB2	As required

(e) Install new water repellent protection on Frame 50 thru Frame 63.

1 Protect the Frame 50 thru Frame 63, STGR 31 LH thru STGR 39 LH and the re-installed shear plates with:

In accordance with SRM 51-23-12.

Corrosion Preventive Compound	12ADB1	As required

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**CONF 006

(1) **Subtask 531364-831-201-013 - Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63**

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 Stringer 38 LH
To	160	Work location	from Frame 60 to Frame 63 Stringer 38 LH

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

Material necessary to do the job

Consumable CMLD01				
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)	53-41-14
Fig. A-GBQAF Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

CAUTION: AIRBUS CONSIDERS IT IS TECHNICALLY ACCEPTABLE TO REWORK EVERY THIRD FRAME AT THE SAME TIME (I.E. LEAVE TWO FRAMES INTACT AND REWORK ONE) TO KEEP THE FUSELAGE STRUCTURE INTEGRITY.

(a) Remove the corner profiles.

In accordance with SRM 53-41-14 C2 Ident.-Floor Structure-Cargo Compartment.

1 Between Frame 48 thru Frame 63, at STGR 38 LH, remove the corner profiles, if necessary in accordance with SRM 53-41-14 C2 Identification - Floor Structure - Cargo Compartment.

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(b) Remove the shear plates.

Refer to Fig. A-GBQAF Sheet 01 thru Fig. A-GBQAF Sheet 06.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 Between Frame 49 and Frame 50, from STGR 38 LH and from the bracket at Frame 49 and bracket, Item (140), remove:

Refer to Fig. A-GBQAF Sheet 02, View C.

1	Plate-Shear	D5347471500000	Item (139)	Retain
	with			
26	Rivet		Item (100)	Discard

2 Between Frame 51 and Frame 53, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAF Sheet 03, View E.

1	Plate-Shear	D5347471500600	Item (137)	Retain
1	Plate-Shear	D5347471500800	Item (119)	Retain
1	Section-Connecting	D5347065020200	Item (135)	Retain
	with			
61	Rivet		Item (100)	Discard

3 Between Frame 53 and Frame 54, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAF Sheet 04, View G.

1	Plate-Shear	D5347471501000	Item (141)	Retain
	with			
28	Rivet		Item (100)	Discard

4 Between Frame 54 and Frame 55, from STGR 38 LH and from the brackets, Item (121) and Item (120), remove:

Refer to Fig. A-GBQAF Sheet 04, View G.

1	Plate Assy-Shear	D5347048800400	Item (122)	Retain
	with			

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40	Rivet		Item (100)	Discard

5 Between Frame 56 and Frame 57, from STGR 38 LH and from the brackets, Item (121) and Item (118), remove:

Refer to Fig. A-GBQAF Sheet 05, View J.

1	Plate Assy-Shear	D5347048900000	Item (124)	Retain

with

40	Rivet		Item (100)	Discard

6 Between Frame 58 and Frame 59, from STGR 38 LH and from the brackets, Item (125) and Item (127), remove:

Refer to Fig. A-GBQAF Sheet 05, View L.

1	Plate-Shear	D5347049200000	Item (126)	Retain

with

40	Rivet		Item (100)	Discard

7 Between Frame 60 and Frame 61, from STGR 38 LH and from the brackets, Item (128) and Item (130), remove:

Refer to Fig. A-GBQAF Sheet 06, View N.

1	Plate-Shear	D5347049300000	Item (129)	Retain
1	Section-Connecting	D5347065420400	Item (136)	Retain

with

45	Rivet		Item (100)	Discard

8 Between Frame 62 and Frame 63, from STGR 38 LH and from the brackets, Item (131) and Item (115), remove:

Refer to Fig. A-GBQAF Sheet 06, View Q.

1	Plate-Shear	D5347049400000	Item (123)	Retain

with

29	Rivet		Item (100)	Discard

(c) Clean the contact surfaces and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

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Textile - Lint Free Cotton	14SBA1	As required

(2) Subtask 531364-831-202-003 - Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 from Stringer 33 LH to Stringer 34 LH from Stringer 36 LH to Stringer 37 LH
To	160	Work location	from Frame 60 to Frame 62 from Stringer 32 LH to Stringer 33 LH from Stringer 36 LH to Stringer 37 LH Frame 63 from Stringer 31 LH to Stringer 32 LH from Stringer 36 LH to Stringer 37 LH

Manpower Resources	
Manhours	5.00
Minimum number of person	1
Subtask elapsed time	5.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

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 Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane	04JME4	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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

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For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00
Fig. A-GBRAA Cold Expansion of Holes in Frame 50 thru Frame 63	Sheet 01 Sheet 02 Sheet 03

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

(a) Inspect the holes for cracks from Frame 50 thru Frame 55 and from Frame 57 thru Frame 59.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 33 LH and STGR 34 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(b) Cold expand the holes from Frame 50 thru Frame 55 and from Frame 57 thru Frame 59.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

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1 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 33 LH and STGR 34 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 02, View C.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

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(c) Inspect the holes for cracks at Frame 56.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 At Frame 56, between STGR 33 LH and STGR 34 LH and between STGR 35 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(d) Cold expand the holes at Frame 56.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 At Frame 56, between STGR 33 LH and STGR 34 LH and between STGR 35 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 02, View D.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

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2 Clean the area of the expanded holes with:

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

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(e) Inspect the holes for cracks from Frame 60 thru Frame 62.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

1 From Frame 60 thru Frame 62, between STGR 32 LH and STGR 33 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(f) Cold expand the holes from Frame 60 thru Frame 62.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

1 From Frame 60 thru Frame 62, between STGR 32 LH and STGR 33 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 03, View E.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(g) Inspect the holes for cracks at Frame 63.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

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1 At Frame 63, between STGR 31 LH and STGR 32 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frame, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(h) Cold expand the holes at Frame 63.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

1 At Frame 63, between STGR 31 LH and STGR 32 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frame. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 03, View F.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

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and

Textile - Lint Free Cotton	14SBA1	As required

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(3) Subtask 531364-831-203-014 - Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 50 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D06R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
4	E5347001024400	1	WEB	
36	E5347001124200	1	ANGLE	
65	E5347001420200	1	ANGLE	
66	E5347001420000	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	11	RIVET	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
668	EN6081D6-08	11	RIVET	(1)
764	DAN5-6-4X	15	PIN	
765	DAN5-6-5X	13	PIN	
766	DAN5-6-6X	6	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	13	PIN	
785	DAN5-6-5Y	3	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	49	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

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NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBAAD Replacement of Webs and Angles at Frame 50	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBAAD Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 50, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
17	Rivet		Item (100)	Discard

2 From the top flange of Frame 50, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

6	Rivet		Item (100)	Discard

3 From Frame 50, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347073420200	Item (1)	Discard
	with			

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18	Rivet		Item (100)	Discard

4 From Frame 50, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072820600	Item (2)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347470120200	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard

with

66	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 50.

Refer to NTM 51-10-01.

Refer to Fig. A-GBAAD Sheet 02, View C.

1 On Frame 50, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 50, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

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(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBAAD Sheet 02 thru Fig. A-GBAAD Sheet 04.

1 On Frame 50, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBAAD Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 50 to the shear web, Item 4.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAD Sheet 04.

4 Transfer drill the tack hole from the Frame 50 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

5 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBAAD Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBAAD Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAD Sheet 04.

6 On Frame 50, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

7 Clean and deburr the new fastener holes in Frame 50 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBAAD Sheet 02, View C.

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a On Frame 50, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBAAD Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

b On Frame 50, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAD Sheet 02, View C.

c On Frame 50, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAD Sheet 02, View C.

d On Frame 50, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAD Sheet 02, View C.

9 On Frame 50, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

10 Clean and deburr the cold expansion fastener holes in Frame 50 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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11 At Frame 50, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBAAD Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4
	with		
3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
11	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
11	Rivet	EN6081D6-08	Item 668
15	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-5X	Item 765
11	Pin	DAN5-6-8X	Item 768
3	Pin	DAN5-6-5Y	Item 785
36	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809
5	Nut	ASNA2528-3A	Item 908

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 50, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBAAD Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373

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1	Nut	ASNA2528-3A	Item 908

13 On the Frame 50 flange, at STGR 35 LH, refer to Fig. A-GBAAD Sheet 03, Section C-C, countersink the one fastener hole.

14 On the Frame 50 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBAAD Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 50 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBAAD Sheet 02, View C and Fig. A-GBAAD Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBAAD Sheet 02, View C and Fig. A-GBAAD Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAD Sheet 04.

17 On the Frame 50 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 50, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 50 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBAAD Sheet 02, View C and Fig. A-GBAAD Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

20 On the Frame 50 flange, at STGR 36 LH, refer to Fig. A-GBAAD Sheet 03, Section D-D, countersink the one fastener hole.

21 On the Frame 50 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBAAD Sheet 03, Section D-D

1	Rivet	EN6069D5-06	Item 556

22 On the Frame 50 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBAAD Sheet 02, View C and Fig. A-GBAAD Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBAAD Sheet 02, View C and Fig. A-GBAAD Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAD Sheet 04.

24 On the Frame 50 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

25 Clean and deburr the new fastener holes in the Frame 50, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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26 On the Frame 50 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBAAD Sheet 02, View C and Fig. A-GBAAD Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

27 On the Frame 50 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBAAD Sheet 02, View C and Fig. A-GBAAD Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Pin	DAN5-6-6X	Item 766	
2	Pin	DAN5-6-7X	Item 767	
4	Collar	NSA5075-6	Item 806	
6	Collar	DAN11-6X	Item 807	
4	Pin	DAN5-6-3	Item 963	

28 On the Frame 50 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBAAD Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

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29 Transfer drill and ream the three holes from the Frame to the angles, Item 65 and Item 66, refer to Fig. A-GBAAD Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAD Sheet 04.

30 On the Frame 50 flange, at STGR 38 LH, remove:

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

31 Clean and deburr the new fastener holes in the Frame 50 and angles, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

32 On the Frame 50 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBAAD Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-8X	Item 768
1	Pin	DAN5-6-6Y	Item 786
2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

33 On the Frame 50 flange, at STGR 39 LH, refer to Fig. A-GBAAD Sheet 03, Section F-F, countersink the one fastener hole.

34 On the Frame 50 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBAAD Sheet 03, Section F-F.

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1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

35 On the Frame 50 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBAAD Sheet 02, View C and Fig. A-GBAAD Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

36 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBAAD Sheet 02, View C and Fig. A-GBAAD Sheet 03, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAD Sheet 04.

37 On the Frame 50 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

38 Clean and deburr the new fastener holes in the Frame 50, STGR 39 LH and angle, Item 39, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

39 On the Frame 50 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBAAD Sheet 02, View C and Fig. A-GBAAD Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657

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2	Pin	DAN5-6-6X	Item 766
2	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(4) Subtask 531364-831-204-013 - Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 51 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D06R06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
4	E5347001024400	1	WEB	
36	E5347001124200	1	ANGLE	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
65	E5347001420200	1	ANGLE	
66	E5347001420000	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	3	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	4	RIVET	(2)
764	DAN5-6-4X	14	PIN	
765	DAN5-6-5X	13	PIN	
766	DAN5-6-6X	6	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	2	PIN	
785	DAN5-6-5Y	3	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	37	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

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Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

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NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBBAD Replacement of Webs and Angles at Frame 51	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBBAD Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 51, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
17	Rivet		Item (100)	Discard

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2 From the top flange of Frame 51, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

6	Rivet		Item (100)	Discard

3 From Frame 51, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347073420200	Item (1)	Discard
	with			
18	Rivet		Item (100)	Discard

4 From Frame 51, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072820600	Item (2)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347470120200	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard
	with			
66	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 51.

Refer to NTM 51-10-01.

Refer to Fig. A-GBBAD Sheet 02, View C.

1 On Frame 51, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

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2 On Frame 51, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBBAD Sheet 02 thru Fig. A-GBBAD Sheet 04.

1 On Frame 51, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBBAD Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 51 to the shear web, Item 4.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAD Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBBAD Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBBAD Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAD Sheet 04.

5 Transfer drill the tack hole from the Frame 51 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 51, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

7 Clean and deburr the new fastener holes in Frame 51 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBBAD Sheet 02, View C.

a On Frame 51, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBBAD Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

b On Frame 51, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAD Sheet 02, View C.

c On Frame 51, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAD Sheet 02, View C.

d On Frame 51, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAD Sheet 02, View C.

9 On Frame 51, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

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10 Clean and deburr the cold expansion fastener holes in Frame 51 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 51, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBBAD Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

with

3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
19	Rivet	EN6081D6-08	Item 668
4	Rivet	EN6081D6-09	Item 669
14	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-5X	Item 765
3	Pin	DAN5-6-5Y	Item 785
24	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809
5	Nut	ASNA2528-3A	Item 908

use

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 51, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBBAD Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

13 On the Frame 51 flange, at STGR 35 LH, refer to Fig. A-GBBAD Sheet 03, Section C-C, countersink the one fastener hole.

14 On the Frame 51 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBBAD Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 51 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAD Sheet 04.

17 On the Frame 51 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in Frame 51, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 51 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

20 On the Frame 51 flange, at STGR 36 LH, refer to Fig. A-GBBAD Sheet 03, Section D-D, countersink the one fastener hole.

21 On the Frame 51 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBBAD Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 51 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAD

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Sheet 04.

24 On the Frame 51 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2	

25 Clean and deburr the new fastener holes in the Frame 51, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required	

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required	

26 On the Frame 51 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

27 On the Frame 51 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

4	Pin	DAN5-6-6X	Item 766	
2	Pin	DAN5-6-7X	Item 767	

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4	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
4	Pin	DAN5-6-3	Item 963

28 On the Frame 51 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBBAD Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

29 Transfer drill and ream the three holes from the Frame to the angles, Item 65 and Item 66, refer to Fig. A-GBBAD Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAD Sheet 04.

30 On the Frame 51 flange, at STGR 38 LH, remove:

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

31 Clean and deburr the new fastener holes in the Frame 51 and angles, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

32 On the Frame 51 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBBAD Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

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2	Pin	DAN5-6-8X	Item 768
1	Pin	DAN5-6-6Y	Item 786
2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

33 On the Frame 51 flange, at STGR 39 LH, refer to Fig. A-GBBAD Sheet 03, Section F-F, countersink the one fastener hole.

34 On the Frame 51 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBBAD Sheet 03, Section F-F.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

35 On the Frame 51 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

36 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAD Sheet 04.

37 On the Frame 51 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

38 Clean and deburr the new fastener holes in the Frame 51, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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39 On the Frame 51 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBBAD Sheet 02, View C and Fig. A-GBBAD Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-07	Item 657
2	Pin	DAN5-6-6X	Item 766
2	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(5) Subtask 531364-831-205-013 - Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 52 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D06R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
6	E5347001024600	1	WEB	
65	E5347001420200	1	ANGLE	
67	E5347001421200	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	2	RIVET	
567	EN6069D6-07	6	RIVET	
656	EN6081D5-06	6	RIVET	
657	EN6081D5-07	4	RIVET	
667	EN6081D6-07	22	RIVET	
764	DAN5-6-4X	16	PIN	
765	DAN5-6-5X	15	PIN	
766	DAN5-6-6X	10	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	2	PIN	
785	DAN5-6-5Y	3	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	12	COLLAR	
807	DAN11-6X	37	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
865	DAN6-6-5	4	PIN	
866	DAN6-6-6	6	PIN	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	1	PIN	
964	DAN5-6-4	1	PIN	

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBCAF Replacement of Webs and Angles at Frame 52	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBCAF Sheet 01, View B and Sections A-A and B-B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 52, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920200	Item (3)	Discard
	with			
18	Rivet		Item (100)	Discard

2 From the flange of Frame 52, between STGR 35 LH and STGR 36 LH, remove:

6	Rivet		Item (100)	Discard

3 From Frame 52, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
18	Rivet		Item (100)	Discard

4 From Frame 52, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347077420200	Item (5)	Discard
1	Support	D5347032200400	Item (103)	Retain
1	Angle	D5347470120200	Item (116)	Discard
1	Section-Connecting	D5347065020200	Item (135)	Retain
1	Angle	D5347470120000	Item (140)	Discard
1	Shim	D5347044920000	Item (142)	Retain
1	Shim	D5347044920600	Item (143)	Retain
	with			
77	Rivet		Item (100)	Discard

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(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 52.

Refer to NTM 51-10-01.

Refer to Fig. A-GBCAF Sheet 02, View C.

1 On Frame 52, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 52, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBCAF Sheet 02 thru Fig. A-GBCAF Sheet 04.

1 On Frame 52, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBCAF Sheet 02, View C.

1	Shear Web	E5347001024600	Item 6

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 52 to the shear web, Item 6.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAF Sheet 04.

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4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBCAF Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBCAF Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAF Sheet 04.

5 Transfer drill the tack hole from the Frame 52 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 52, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024600	Item 6

7 Clean and deburr the new fastener holes in Frame 52 and the shear web, Item 6, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBCAF Sheet 02, View C.

a On Frame 52, between STGR 34 LH and STGR 39 LH, put in position:

1	Shear Web	E5347001024600	Item 6

b On Frame 52, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAF Sheet 02, View C.

c On Frame 52, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAF Sheet 02, View C.

d On Frame 52, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAF Sheet 02, View C.

9 On Frame 52, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024600	Item 6

10 Clean and deburr the cold expansion fastener holes in Frame 52 and the shear web, Item 6, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 52, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBCAF Sheet 02, View C.

1	Shear Web	E5347001024600	Item 6

with

3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
6	Rivet	EN6069D6-07	Item 567
6	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D6-07	Item 667
15	Pin	DAN5-6-4X	Item 764

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12	Pin	DAN5-6-5X	Item 765
3	Pin	DAN5-6-5Y	Item 785
1	Collar	NSA5075-6	Item 806
19	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809
5	Nut	ASNA2528-3A	Item 908
1	Pin	DAN5-6-3	Item 963

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 52, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBCAF Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

13 On the Frame 52 flange, at STGR 35 LH, refer to Fig. A-GBCAF Sheet 03, Section D-D, countersink the one fastener hole.

14 On the Frame 52 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBCAF Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 52 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBCAF Sheet 02, View C and Fig. A-GBCAF Sheet 03, Section D-D.

1	Angle	E5347001120000	Item 1

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16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole in STGR 35 LH and the three holes in the Frame to the angle, Item 1, refer to Fig. A-GBCAF Sheet 02, View C and Fig. A-GBCAF Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAF Sheet 04.

17 On the Frame 52 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 52, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 52 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBCAF Sheet 02, View C and Fig. A-GBCAF Sheet 03, Section D-D.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

20 On the Frame 52 flange, at STGR 36 LH, refer to Fig. A-GBCAF Sheet 03, Section E-E, countersink the one fastener hole.

21 On the Frame 52 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBCAF Sheet 03, Section E-E.

1	Rivet	EN6069D5-06	Item 556

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 52 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBCAF Sheet 02, View C and Fig. A-GBCAF Sheet 03, Section E-E.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole in STGR 36 LH and the three holes in the Frame to the angle, Item 2, refer to Fig. A-GBCAF Sheet 02, View C and Fig. A-GBCAF Sheet 03, Section E-E.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAF Sheet 04.

24 On the Frame 52 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

25 Clean and deburr the new fastener holes in the Frame 52, STGR 36 LH and the angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 52 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBCAF Sheet 02, View C and Fig. A-GBCAF Sheet 03, Section E-E.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-4	Item 964

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1	Collar	NSA5075-6	Item 806	

27 On the Frame 52 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBCAF Sheet 02, View C and Fig. A-GBCAF Sheet 03, Section F-F.

1	Support	D5347032200400	Item (103)	Retained at removal
1	Section-Connecting	D5347065020200	Item (135)	Retained at removal
1	Shim	D5347044920000	Item (142)	Retained at removal
1	Shim	D5347044920600	Item (143)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

1	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-6X	Item 766
2	Pin	DAN5-6-7X	Item 767
10	Collar	NSA5075-6	Item 806
13	Collar	DAN11-6X	Item 807
4	Pin	DAN6-6-5	Item 865
6	Pin	DAN6-6-6	Item 866

28 On the Frame 52 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBCAF Sheet 02, View C and Section C-C.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001421200	Item 67

29 Transfer drill and ream the three holes in the Frame to the angles, Item 65 and Item 67, refer to Fig. A-GBCAF Sheet 02, View C and Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAF

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Sheet 04.

30 On the Frame 52 flange, at STGR 38 LH, remove:

1	Angle	E5347001420200	Item 65
1	Angle	E5347001421200	Item 67

31 Clean and deburr the new fastener holes in the Frame 52 and the angles, Item 65 and Item 67, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

32 On the Frame 52 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBCAF Sheet 02, View C and Section C-C.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001421200	Item 67

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

1	Pin	DAN5-6-6Y	Item 786
1	Collar	DAN11-6Y	Item 809
2	Pin	DAN5-6-8X	Item 768
2	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

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Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(6) Subtask 531364-831-206-012 - Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 53 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D06R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
8	E5347001029400	1	WEB	
36	E5347001124200	1	ANGLE	
68	E5347001421400	1	ANGLE	
80	E5347001421600	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	15	RIVET	
657	EN6081D5-07	6	RIVET	
667	EN6081D6-07	22	RIVET	
764	DAN5-6-4X	15	PIN	
765	DAN5-6-5X	13	PIN	
766	DAN5-6-6X	6	PIN	
767	DAN5-6-7X	2	PIN	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
768	DAN5-6-8X	2	PIN	
784	DAN5-6-4Y	2	PIN	
785	DAN5-6-5Y	2	PIN	
806	NSA5075-6	6	COLLAR	
807	DAN11-6X	48	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
873	DAN6-6-3X	10	PIN	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	1	PIN	

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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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.

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBDAF Replacement of Webs and Angles at Frame 53	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBDAF Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 53, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
17	Rivet		Item (100)	Discard

2 From the flange of Frame 53, between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 53, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
18	Rivet		Item (100)	Discard

4 From Frame 53, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078320200	Item (6)	Discard
1	Support	D5347032200000	Item (101)	Retain

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1	Angle	D5347470120200	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard
	with			
64	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 53.

Refer to NTM 51-10-01.

Refer to Fig. A-GBDAF Sheet 02, View C.

1 On Frame 53, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 53, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBDAF Sheet 02 thru Fig. A-GBDAF Sheet 04.

1 On Frame 53, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBDAF Sheet 02, View C.

1	Shear Web	E5347001029400	Item 8

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2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 53 to the shear web, Item 8.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAF Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBDAF Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBDAF Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAF Sheet 04.

5 Transfer drill the tack hole from the Frame 53 between STGR 37 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 53, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001029400	Item 8

7 Clean and deburr the new fastener holes in Frame 53 and the shear web, Item 8, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBDAF Sheet 02, View C.

a On Frame 53, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBDAF Sheet 02, View C.

1	Shear Web	E5347001029400	Item 8

b On Frame 53, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

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FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAF Sheet 02, View C.

c On Frame 53, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAF Sheet 02, View C.

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d On Frame 53, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAF Sheet 02, View C.

9 On Frame 53, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001029400	Item 8

10 Clean and deburr the cold expansion fastener holes in Frame 53 and the shear web, Item 8, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 53, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBDAF Sheet 02, View C.

1	Shear Web	E5347001029400	Item 8

with

3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374

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1	Bolt	EN6115K3A5	Item 375
15	Rivet	EN6069D6-07	Item 567
20	Rivet	EN6081D6-07	Item 667
15	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-5X	Item 765
2	Pin	DAN5-6-4Y	Item 784
1	Pin	DAN5-6-5Y	Item 785
1	Collar	NSA5075-6	Item 806
35	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809
10	Pin	DAN6-6-3X	Item 873
5	Nut	ASNA2528-3A	Item 908
1	Pin	DAN5-6-3	Item 963

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 53, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBDAF Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

13 On the Frame 53 flange, at STGR 35 LH, refer to Fig. A-GBDAF Sheet 03, Section C-C, countersink the one fastener hole.

14 On the Frame 53 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBDAF Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 53 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBDAF Sheet 02, View C and Fig. A-GBDAF Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBDAF Sheet 02, View C and Fig. A-GBDAF Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAF Sheet 04.

17 On the Frame 53 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 53, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 53 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBDAF Sheet 02, View C and Fig. A-GBDAF Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765

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3	Collar	DAN11-6X	Item 807

20 On the Frame 53 flange, at STGR 36 LH, refer to Fig. A-GBDAF Sheet 03, Section D-D, countersink the one fastener hole.

21 On the Frame 53 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBDAF Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 53 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBDAF Sheet 02, View C and Fig. A-GBDAF Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes form the Frame to the angle, Item 2, refer to Fig. A-GBDAF Sheet 02, View C and Fig. A-GBDAF Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAF Sheet 04.

24 On the Frame 53 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

25 Clean and deburr the new fastener holes in the Frame 53, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 53 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBDAF Sheet 02, View C and Fig. A-GBDAF Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-4	Item 964	
1	Collar	NSA5075-6	Item 806	

27 On the Frame 53 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBDAF Sheet 02, View C and Fig. A-GBDAF Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Pin	DAN5-6-6X	Item 766
2	Pin	DAN5-6-7X	Item 767
4	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
4	Pin	DAN5-6-3	Item 963

28 On the Frame 53 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBDAF Sheet 02, View C and Section B-B.

1	Angle	E5347001421400	Item 68
1	Angle	E5347001421600	Item 80

29 Transfer drill and ream the three holes form the Frame to the angles, Item 68 and Item 80, refer to Fig. A-GBDAF Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAF

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Sheet 04.

30 On the Frame 53 flange, at STGR 38 LH, remove:

1	Angle	E5347001421400	Item 68
1	Angle	E5347001421600	Item 80

31 Clean and deburr the new fastener holes in the Frame 53 and angles, Item 68 and Item 80, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

32 On the Frame 53 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBDAF Sheet 02, View C and Section B-B.

1	Angle	E5347001421400	Item 68
1	Angle	E5347001421600	Item 80

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

1	Pin	DAN5-6-5Y	Item 785
1	Collar	DAN11-6Y	Item 809
2	Pin	DAN5-6-8X	Item 768
2	Collar	DAN11-6X	Item 807

33 On the Frame 53 flange, at STGR 39 LH, refer to Fig. A-GBDAF Sheet 03, Section F-F, countersink the one fastener hole.

34 On the Frame 53 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBDAF Sheet 03, Section F-F.

1	Rivet	EN6069D5-06	Item 556

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

35 On the Frame 53 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBDAF Sheet 02, View C and Fig. A-GBDAF Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

36 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBDAF Sheet 02, View C and Fig. A-GBDAF Sheet 03, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBDAF Sheet 04.

37 On the Frame 53 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

38 Clean and deburr the new fastener holes in the Frame 53, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

39 On the Frame 53 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBDAF Sheet 02, View C and Fig. A-GBDAF Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Pin	DAN5-6-6X	Item 766
2	Collar	DAN11-6X	Item 807

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(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(7) Subtask 531364-831-207-012 - Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 54 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D06R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
10	E5347001025000	1	WEB	
36	E5347001124200	1	ANGLE	
82	E5347001421800	1	ANGLE	
84	E5347001422000	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	10	RIVET	
657	EN6081D5-07	4	RIVET	
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
764	DAN5-6-4X	15	PIN	
765	DAN5-6-5X	13	PIN	
766	DAN5-6-6X	6	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	2	PIN	
784	DAN5-6-4Y	2	PIN	
785	DAN5-6-5Y	2	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	48	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
873	DAN6-6-3X	10	PIN	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	4	PIN	

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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

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For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBEAF Replacement of Webs and Angles at Frame 54	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBEAF Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 54, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
17	Rivet		Item (100)	Discard

2 From the top flange of Frame 54, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 54, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			

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18	Rivet		Item (100)	Discard

4 From Frame 54, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078520200	Item (7)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046824000	Item (121)	Discard
1	Angle	D5347470120000	Item (140)	Discard

with

68	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 54.

Refer to NTM 51-10-01.

Refer to Fig. A-GBEAF Sheet 02, View C.

1 On Frame 54, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 54, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBEAF Sheet 02 thru Fig. A-GBEAF Sheet 04.

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1 On Frame 54, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBEAF Sheet 02, View C.

1	Shear Web	E5347001025000	Item 10

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 54 to the shear web, Item 10.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAF Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBEAF Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBEAF Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAF Sheet 04.

5 Transfer drill the tack hole from the Frame 54 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 54, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025000	Item 10

7 Clean and deburr the fastener holes in Frame 54 and the shear web, Item 10, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBEAF Sheet 02, View C.

a On Frame 54, between STGR 34 LH and STGR 39 LH, put in position:

1	Shear Web	E5347001025000	Item 10

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b On Frame 54, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAF Sheet 02, View C.

c On Frame 54, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAF Sheet 02, View C.

d On Frame 54, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAF Sheet 02, View C.

9 On Frame 54, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025000	Item 10

10 Clean and deburr the cold expansion fastener holes in Frame 54 and the shear web, Item 10, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 54, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBEAF Sheet 02, View C.

1	Shear Web	E5347001025000	Item 10

with

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3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
15	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-5X	Item 765
2	Pin	DAN5-6-4Y	Item 784
1	Pin	DAN5-6-5Y	Item 785
35	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809
10	Pin	DAN6-6-3X	Item 873
5	Nut	ASNA2528-3A	Item 908

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 54, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBEAF Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

13 On the Frame 54 flange, at STGR 35 LH, refer to Fig. A-GBEAF Sheet 03, Section C-C, countersink the one fastener hole.

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14 On the Frame 54 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBEAF Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 54 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBEAF Sheet 02, View C and Fig. A-GBEAF Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBEAF Sheet 02, View C and Fig. A-GBEAF Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAF Sheet 04.

17 On the Frame 54 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 54, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 54 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBEAF Sheet 02, View C and Fig. A-GBEAF Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

20 On the Frame 54 flange, at STGR 36 LH, refer to Fig. A-GBEAF Sheet 03, Section D-D, countersink the one fastener hole.

21 On the Frame 54 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBEAF Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 54 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBEAF Sheet 02, View C and Fig. A-GBEAF Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole in STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBEAF Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAF Sheet 04.

24 On the Frame 54 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

25 Clean and deburr the new fastener holes in the Frame 54, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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26 On the Frame 54 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBEAF Sheet 02, View C and Fig. A-GBEAF Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

27 On the Frame 54 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBEAF Sheet 02, View C and Fig. A-GBEAF Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Pin	DAN5-6-6X	Item 766	
2	Pin	DAN5-6-7X	Item 767	
4	Collar	NSA5075-6	Item 806	
6	Collar	DAN11-6X	Item 807	
4	Pin	DAN5-6-3	Item 963	

28 On the Frame 54 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBEAF Sheet 02, View C and Section B-B.

1	Angle	E5347001421800	Item 82
1	Angle	E5347001422000	Item 84

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29 Transfer drill and ream the three holes from the Frame to the angles, Item 82 and Item 84, refer to Fig. A-GBEAF Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAF Sheet 04.

30 On the Frame 54 flange, at STGR 38 LH, remove:

1	Angle	E5347001421800	Item 82
1	Angle	E5347001422000	Item 84

31 Clean and deburr the new fastener holes in the Frame 54 and angles, Item 82 and Item 84, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

32 On the Frame 54 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBEAF Sheet 02, View C and Section B-B.

1	Angle	E5347001421800	Item 82
1	Angle	E5347001422000	Item 84

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-8X	Item 768
1	Pin	DAN5-6-5Y	Item 785
2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

33 On the Frame 54 flange, at STGR 39 LH, refer to Fig. A-GBEAF Sheet 03, Section F-F, countersink the one fastener hole.

34 On the Frame 54 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBEAF Sheet 03, Section F-F.

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1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

35 On the Frame 54 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBEAF Sheet 02, View C and Fig. A-GBEAF Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

36 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBEAF Sheet 02, View C and Fig. A-GBEAF Sheet 03, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAF Sheet 04.

37 On the Frame 54 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

38 Clean and deburr the new fastener holes in the Frame 54, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

39 On the Frame 54 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBEAF Sheet 02, View C and Fig. A-GBEAF Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656

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2	Pin	DAN5-6-6X	Item 766
2	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(8) Subtask 531364-831-208-012 - Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 55 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D06R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
12	E5347001020800	1	WEB	
36	E5347001124200	1	ANGLE	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	6	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	16	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	10	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	12	PIN	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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.

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NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBFAD Replacement of Webs and Angles at Frame 55	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBFAD Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 55, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 55, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

10	Rivet		Item (100)	Discard

3 From Frame 55, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard

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with

14	Rivet		Item (100)	Discard

4 From Frame 55, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072120600	Item (8)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046823800	Item (120)	Retain

with

56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 55.

Refer to NTM 51-10-01.

Refer to Fig. A-GBFAD Sheet 02, Views C, D and F.

1 On Frame 55, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 55, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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4 On the top flange of Frame 55, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBFAD Sheet 02 thru Fig. A-GBFAD Sheet 04.

1 On Frame 55, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBFAD Sheet 02, View C.

1	Shear Web	E5347001020800	Item 12

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 55 to the shear web, Item 12.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAD Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBFAD Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBFAD Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAD Sheet 04.

5 Transfer drill the tack hole from the Frame 55 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 55, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001020800	Item 12

7 Clean and deburr the new fastener holes in Frame 55 and the shear web, Item 12, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBFAD Sheet 02, Views C, D and F.

a On Frame 55, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBFAD Sheet 02, View C.

1	Shear Web	E5347001020800	Item 12

b On Frame 55, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAD Sheet 02, View C.

c On Frame 55, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAD Sheet 02, View C.

d On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAD Sheet 02, View D.

e On the top flange of Frame 55, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

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FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAD Sheet 02, View F.

9 On Frame 55, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001020800	Item 12

10 Clean and deburr the cold expansion fastener holes in Frame 55 and the shear web, Item 12, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 55, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBFAD Sheet 02, View C.

1	Shear Web	E5347001020800	Item 12

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
6	Rivet	EN6081D6-06	Item 666

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17	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
10	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 55, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBFAD Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBFAD Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

14 On the Frame 55 flange, at STGR 35 LH, refer to Fig. A-GBFAD Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 55 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBFAD Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 55 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAD Sheet 04.

18 On the Frame 55 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 55, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 55 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765

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1	Collar	DAN11-6X	Item 807

21 On the Frame 55 flange, at STGR 36 LH, refer to Fig. A-GBFAD Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 55 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBFAD Sheet 03, Section B-B.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 55 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole form STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAD Sheet 04.

25 On the Frame 55 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 55, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 55 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

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with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

28 On the Frame 55 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal

with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 55 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBFAD Sheet 02, View C.

1	Angle	D5347046823800	Item (120)	Retained at removal

with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Pin	DAN5-6-5X	Item 765	
1	Pin	DAN5-6-5Y	Item 785	
2	Collar	DAN11-6X	Item 807	

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1	Collar	DAN11-6Y	Item 809

30 On the Frame 55 flange, at STGR 39 LH, refer to Fig. A-GBFAD Sheet 03, Section D-D, countersink the one fastener hole.

31 On the Frame 55 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBFAD Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

32 On the Frame 55 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAD Sheet 04.

34 On the Frame 55 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

35 Clean and deburr the new fastener holes in the Frame 55, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

36 On the Frame 55 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBFAD Sheet 02, View C and Fig. A-GBFAD Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

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with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(9) Subtask 531364-831-209-012 - Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 56 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D06R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
14	E5347001021000	1	WEB	
16	E5347001120400	1	ANGLE	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	10	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	9	RIVET	
668	EN6081D6-08	24	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	2	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	24	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	10	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	17	PIN	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	2	PIN	
965	DAN5-6-5	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBGAD Replacement of Webs and Angles at Frame 56	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBGAD Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 56, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347078720000	Item (9)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 56, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 34 LH and STGR 36 LH, remove:

12	Rivet		Item (100)	Discard

3 From Frame 56, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347078820000	Item (10)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 56, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078620200	Item (11)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046820600	Item (121)	Retain
1	Support	D5347068520100	Item (134)	Retain
	with			
64	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 56.

Refer to NTM 51-10-01.

Refer to Fig. A-GBGAD Sheet 02, Views C, D and F.

1 On Frame 56, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 56, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 56, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBGAD Sheet 02 thru Fig. A-GBGAD Sheet 04.

1 On Frame 56, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBGAD Sheet 02, View C.

1	Shear Web	E5347001021000	Item 14

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 56 to the shear web, Item 14.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAD

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Sheet 04.

4 Drill the additional 6 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBGAD Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBGAD Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAD Sheet 04.

5 Transfer drill the tack hole from the Frame 56 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 56, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021000	Item 14

7 Clean and deburr the new fastener holes in Frame 56 and the shear web, Item 14, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBGAD Sheet 02, Views C, D and F.

a On Frame 56, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBGAD Sheet 02, View C.

1	Shear Web	E5347001021000	Item 14

b On Frame 56, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAD Sheet 02, View C.

c On Frame 56, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAD Sheet 02, View C.

d On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAD Sheet 02, View D.

e On the top flange of Frame 56, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAD Sheet 02, View F.

9 On Frame 56, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021000	Item 14

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10 Clean and deburr the cold expansion fastener holes in Frame 56 and the shear web, Item 14, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 56, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBGAD Sheet 02, View C.

1	Shear Web	E5347001021000	Item 14

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
10	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
9	Rivet	EN6081D6-06	Item 666
19	Rivet	EN6081D6-08	Item 668
7	Pin	DAN5-6-4X	Item 764
17	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
15	Pin	DAN6-6-3	Item 863
2	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 56, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBGAD Sheet 02, View C.

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1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBGAD Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

14 On the Frame 56 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBGAD Sheet 02, View C and Fig. A-GBGAD Sheet 03, Section A-A.

1	Angle	E5347001120400	Item 16

15 Transfer drill and ream the holes from the Frame 56 and from STGR 35 LH to the angle, Item 16, refer to Fig. A-GBGAD Sheet 02, View C and Fig. A-GBGAD Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAD Sheet 04.

16 On the Frame 56 flange, at STGR 35 LH, remove:

1	Angle	E5347001120400	Item 16

17 Clean and deburr the new fastener holes in the Frame 56, STGR 35 LH and angle, Item 16, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

18 On the Frame 56 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBGAD Sheet 02, View C and Fig. A-GBGAD Sheet 03, Section A-A.

1	Angle	E5347001120400	Item 16

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
2	Rivet	EN6081D6-09	Item 669	
1	Collar	NSA5075-6	Item 806	
1	Pin	DAN5-6-5	Item 965	

19 On the Frame 56 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBGAD Sheet 02, View C and Fig. A-GBGAD Sheet 03, Section B-B.

1	Support	D5347068520100	Item (134)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D6-08	Item 668	

20 On the Frame 56 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBGAD Sheet 02, View C and Fig. A-GBGAD Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

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21 On the aft side of the Frame 56 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBGAD Sheet 02, View C.

1	Angle	D5347046820600	Item (121)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-5X	Item 765	
1	Pin	DAN5-6-5Y	Item 785	
2	Collar	DAN11-6X	Item 807	
1	Collar	DAN11-6Y	Item 809	

22 On the Frame 56 flange, at STGR 39 LH, refer to Fig. A-GBGAD Sheet 03, Section D-D, countersink the one fastener hole.

23 On the Frame 56 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBGAD Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 56 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBGAD Sheet 02, View C and Fig. A-GBGAD Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBGAD Sheet 02, View C and Fig. A-GBGAD Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAD Sheet 04.

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26 On the Frame 56 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

27 Clean and deburr the new fastener holes in the Frame 56, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 56 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBGAD Sheet 02, View C and Fig. A-GBGAD Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

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(10) Subtask 531364-831-210-012 - Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 57 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D06R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
18	E5347001021200	1	WEB	
20	E5347001123800	1	ANGLE	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	1	RIVET	
668	EN6081D6-08	17	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	19	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	10	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	11	PIN	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	

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NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBHAD Replacement of Webs and Angles at Frame 57	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBHAD Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 57, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347081820000	Item (12)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 57, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

8	Rivet		Item (100)	Discard

3 From Frame 57, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347081720000	Item (13)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 57, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347081620400	Item (14)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046820200	Item (118)	Retain
	with			
57	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 57.

Refer to NTM 51-10-01.

Refer to Fig. A-GBHAD Sheet 02, Views C, D and F.

1 On Frame 57, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 57, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 57, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBHAD Sheet 02 thru Fig. A-GBHAD Sheet 04.

1 On Frame 57, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBHAD Sheet 02, View C.

1	Shear Web	E5347001021200	Item 18

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 57 to the shear web, Item 18.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAD

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Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBHAD Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBHAD Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAD Sheet 04.

5 Transfer drill the tack hole from the Frame 57 between STGR 36 LH and STGR 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 57, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021200	Item 18

7 Clean and deburr the new fastener holes in Frame 57 and the shear web, Item 18, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBHAD Sheet 02, Views C, D and F.

a On Frame 57, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBHAD Sheet 02, View C.

1	Shear Web	E5347001021200	Item 18

b On Frame 57, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAD Sheet 02, View C.

c On Frame 57, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAD Sheet 02, View C.

d On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAD Sheet 02, View D.

e On the top flange of Frame 57, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAD Sheet 02, View F.

9 On Frame 57, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021200	Item 18

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10 Clean and deburr the cold expansion fastener holes in Frame 57 and the shear web, Item 18, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 57, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBHAD Sheet 02, View C.

1	Shear Web	E5347001021200	Item 18

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
13	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863
1	Pin	DAN5-6-3	Item 963
2	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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12 Install 1 fastener in the flange of Frame 57, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBHAD Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBHAD Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

14 On the Frame 57 flange, at STGR 35 LH, refer to Fig. A-GBHAD Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 57 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 57 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAD Sheet 04.

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18 On the Frame 57 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 57, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 57 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

21 On the Frame 57 flange, at STGR 36 LH, refer to Fig. A-GBHAD Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 57 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBHAD Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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23 On the Frame 57 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section B-B.

1	Angle	E5347001123800	Item 20

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 20, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the two holes from the Frame to the angle, Item 20, refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAD Sheet 04.

25 On the Frame 57 flange, at STGR 36 LH, remove:

1	Angle	E5347001123800	Item 20

26 Clean and deburr the new fastener holes in the Frame 57, STGR 36 LH and angle, Item 20, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 57 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section B-B.

1	Angle	E5347001123800	Item 20

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-07	Item 667
1	Collar	NSA5075-6	Item 806
1	Pin	DAN5-6-4	Item 964

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28 On the Frame 57 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 57 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBHAD Sheet 02, View C.

1	Angle	D5347046820200	Item (118)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-5X	Item 765	
1	Pin	DAN5-6-5Y	Item 785	
2	Collar	DAN11-6X	Item 807	
1	Collar	DAN11-6Y	Item 809	

30 On the Frame 57 flange, at STGR 39 LH, refer to Fig. A-GBHAD Sheet 03, Section D-D, countersink the one fastener hole.

31 On the Frame 57 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBHAD Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

32 On the Frame 57 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBHAD Sheet 04.

34 On the Frame 57 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

35 Clean and deburr the new fastener holes in the Frame 57, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

36 On the Frame 57 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBHAD Sheet 02, View C and Fig. A-GBHAD Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668

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(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(11) Subtask 531364-831-211-012 - Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 58 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D06R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
22	E5347001021400	1	WEB	
24	E5347001120600	1	ANGLE	
26	E5347001120800	1	ANGLE	
70	E5347001124400	1	ANGLE	
363	EN6115K3-3	5	BOLT	
364	EN6115K3-4	3	BOLT	
374	EN6115K3A4	2	BOLT	
463	EN6114K3-3	1	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
555	EN6069D5-05	2	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	14	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	3	RIVET	
666	EN6081D6-06	2	RIVET	
667	EN6081D6-07	4	RIVET	
668	EN6081D6-08	4	RIVET	(1)
670	EN6081D7-10	4	RIVET	
678	EN6081D7-08	6	RIVET	
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	20	COLLAR	
807	DAN11-6X	10	COLLAR	
808	ASNA2528-3	9	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	9	PIN	
908	ASNA2528-3A	2	NUT	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	5	PIN	
965	DAN5-6-5	2	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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.

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NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBJAD Replacement of Webs and Angles at Frame 58	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBJAD Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 58, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347082420000	Item (15)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 58, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 58, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347080520000	Item (16)	Discard

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with

13	Rivet		Item (100)	Discard

4 From Frame 58, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347083020400	Item (17)	Discard
1	Support	D5347032200600	Item (104)	Retain
1	Angle	D5347046820800	Item (125)	Retain

with

47	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 58.

Refer to NTM 51-10-01.

Refer to Fig. A-GBJAD Sheet 02, Views C, D and F.

1 On Frame 58, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 58, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 7 holes for the fasteners, Item 363, Item 364 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 On the top flange of Frame 58, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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4 On the top flange of Frame 58, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBJAD Sheet 02 thru Fig. A-GBJAD Sheet 04.

1 On Frame 58, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBJAD Sheet 02, View C.

1	Shear Web	E5347001021400	Item 22

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 58 to the shear web, Item 22.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAD Sheet 04.

4 Drill the additional 10 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBJAD Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBJAD Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAD Sheet 04.

5 Transfer drill the tack hole from the Frame 58 between STGR 36 LH and STGR 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 58, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021400	Item 22

7 Clean and deburr the new fastener holes in Frame 58 and the shear web, Item 22, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBJAD Sheet 02, Views C, D and F.

a On Frame 58, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBJAD Sheet 02, View C.

1	Shear Web	E5347001021400	Item 22

b On Frame 58, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAD Sheet 02, View C.

c On Frame 58, between STGR 36 LH and STGR 37 LH, cold expand the 5 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAD Sheet 02, View C.

d On Frame 58, between STGR 36 LH and STGR 37 LH, cold expand the 2 holes for the fasteners, Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAD Sheet 02, View C.

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e On the top flange of Frame 58, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAD Sheet 02, View D.

f On the top flange of Frame 58, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAD Sheet 02, View F.

9 On Frame 58, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021400	Item 22

10 Clean and deburr the cold expansion fastener holes in Frame 58 and the shear web, Item 22, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 58, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBJAD Sheet 02, View C.

1	Shear Web	E5347001021400	Item 22

with

4	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
2	Bolt	EN6115K3A4	Item 374
14	Rivet	EN6069D6-07	Item 567
7	Pin	DAN5-6-4X	Item 764
8	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-06	Item 666
4	Rivet	EN6081D6-08	Item 668
6	Rivet	EN6081D7-08	Item 678
13	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
7	Nut	ASNA2528-3	Item 808
8	Pin	DAN6-6-3	Item 863
2	Nut	ASNA2528-3A	Item 908

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5	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 58, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBJAD Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 58, at STGR 35 LH, install:

Refer to Fig. A-GBJAD Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

14 On the Frame 58 flange, at STGR 35 LH, refer to Fig. A-GBJAD Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 58 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBJAD Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 58 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBJAD Sheet 02, View C and Fig. A-GBJAD Sheet 03, Section A-A.

1	Angle	E5347001120600	Item 24

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17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 24, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 24, refer to Fig. A-GBJAD Sheet 02, View C and Fig. A-GBJAD Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAD Sheet 04.

18 On the Frame 58 flange, at STGR 35 LH, remove:

1	Angle	E5347001120600	Item 24

19 Clean and deburr the new fastener holes in the Frame 58, STGR 35 LH and angle, Item 24, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 58 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBJAD Sheet 02, View C and Fig. A-GBJAD Sheet 03, Section A-A.

1	Angle	E5347001120600	Item 24

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-06	Item 656
1	Pin	DAN5-6-5X	Item 765
2	Collar	NSA5075-6	Item 806
1	Collar	DAN11-6X	Item 807
2	Pin	DAN5-6-5	Item 965

21 On the Frame 58 flange, at STGR 36 LH, refer to Fig. A-GBJAD Sheet 03, Section B-B, countersink the one fastener hole.

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22 On the Frame 58 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBJAD Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 58 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBJAD Sheet 02, View C and Fig. A-GBJAD Sheet 03, Section B-B.

1	Angle	E5347001120800	Item 26

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 26, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH to the angle, Item 26, refer to Fig. A-GBJAD Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAD Sheet 04.

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 26, to the Frame 58 flange, at STGR 36 LH, then transfer drill and ream the two holes from the Frame to the angle, Item 26, refer to Fig. A-GBJAD Sheet 03, View E.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAD Sheet 04.

26 On the Frame 58 flange, at STGR 36 LH, remove:

1	Angle	E5347001120800	Item 26

27 Clean and deburr the new fastener holes in the Frame 58, STGR 36 LH and angle, Item 26, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 58 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBJAD Sheet 02, View C and Fig. A-GBJAD Sheet 03, Section B-B.

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1	Angle	E5347001120800	Item 26	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
1	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	

29 On the Frame 58 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBJAD Sheet 02, View C and Fig. A-GBJAD Sheet 03, Section C-C.

1	Support	D5347032200600	Item (104)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Rivet	EN6081D7-10	Item 670	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

30 On the aft side of the Frame 58 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBJAD Sheet 02, View C.

1	Angle	D5347046820800	Item (125)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-5X	Item 765	

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1	Pin	DAN5-6-5Y	Item 785
2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

31 On the Frame 58 flange, at STGR 39 LH, refer to Fig. A-GBJAD Sheet 03, Section D-D, countersink the one fastener hole.

32 On the Frame 58 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBJAD Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 58 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBJAD Sheet 02, View C and Fig. A-GBJAD Sheet 03, Section D-D.

1	Angle	E5347001124400	Item 70

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 70, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 70, refer to Fig. A-GBJAD Sheet 02, View C and Fig. A-GBJAD Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBJAD Sheet 04.

35 On the Frame 58 flange, at STGR 39 LH, remove:

1	Angle	E5347001124400	Item 70

36 Clean and deburr the new fastener holes in the Frame 58, STGR 39 LH and angle, Item 70, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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37 On the Frame 58 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBJAD Sheet 02, View C and Fig. A-GBJAD Sheet 03, Section D-D.

1	Angle	E5347001124400	Item 70
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(12) Subtask 531364-831-212-013 - Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 59 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D06R06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
28	E5347001021600	1	WEB	
30	E5347001121000	1	ANGLE	
32	E5347001121200	1	ANGLE	
72	E5347001124600	1	ANGLE	
363	EN6115K3-3	5	BOLT	
364	EN6115K3-4	2	BOLT	
365	EN6115K3-5	3	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	20	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	20	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	7	RIVET	(1)
669	EN6081D6-09	3	RIVET	(2)
764	DAN5-6-4X	3	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	21	COLLAR	
807	DAN11-6X	6	COLLAR	
808	ASNA2528-3	11	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	8	PIN	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	6	PIN	
965	DAN5-6-5	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBKAD Replacement of Webs and Angles at Frame 59	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBKAD Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 59, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347089120000	Item (18)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 59, at STGR 35 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

5	Rivet		Item (100)	Discard

3 From Frame 59, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347089020000	Item (19)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 59, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347088920400	Item (20)	Discard
1	Support	D5347032201000	Item (106)	Retain
1	Angle	D5347046821000	Item (127)	Retain
	with			
59	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 59.

Refer to NTM 51-10-01.

Refer to Fig. A-GBKAD Sheet 02, Views C and D.

1 On Frame 59, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 59, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 7 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 59, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBKAD Sheet 02 thru Fig. A-GBKAD Sheet 04.

1 On Frame 59, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBKAD Sheet 02, View C.

1	Shear Web	E5347001021600	Item 28

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 59 to the shear web, Item 28.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAD Sheet 04.

4 Drill the additional 17 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBKAD Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBKAD Sheet

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02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAD Sheet 04.

5 Transfer drill the tack hole from the Frame 59 between STGR 36 LH and STGR 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 59, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021600	Item 28

7 Clean and deburr the new fastener hole in Frame 59 and the shear web, Item 28, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBKAD Sheet 02, Views C and D.

a On Frame 59, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBKAD Sheet 02, View C.

1	Shear Web	E5347001021600	Item 28

b On Frame 59, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAD Sheet 02, View C.

c On Frame 59, between STGR 36 LH and STGR 37 LH, cold expand the 7 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAD Sheet 02, View C.

d On the top flange of Frame 59, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAD Sheet 02, View D.

9 On Frame 59, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021600	Item 28

10 Clean and deburr the cold expansion fastener hole in Frame 59 and the shear web, Item 28, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 59, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBKAD Sheet 02, View C.

1	Shear Web	E5347001021600	Item 28

with

4	Bolt	EN6115K3-3	Item 363
2	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
16	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D6-06	Item 666
5	Rivet	EN6081D6-08	Item 668
3	Pin	DAN5-6-4X	Item 764
14	Collar	NSA5075-6	Item 806
3	Collar	DAN11-6X	Item 807

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6	Nut	ASNA2528-3	Item 808
8	Pin	DAN6-6-3	Item 863
6	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 59, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBKAD Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 59, at STGR 35 LH, install:

Refer to Fig. A-GBKAD Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

14 On the Frame 59 flange, at STGR 35 LH, refer to Fig. A-GBKAD Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 59 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBKAD Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 59 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section A-A.

1	Angle	E5347001121000	Item 30

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17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 30, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 30, refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAD Sheet 04.

18 On the Frame 59 flange, at STGR 35 LH, remove:

1	Angle	E5347001121000	Item 30

19 Clean and deburr the new fastener holes in the Frame 59, STGR 35 LH and angle, Item 30, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 59 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section A-A.

1	Angle	E5347001121000	Item 30

with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Collar	NSA5075-6	Item 806
3	Pin	DAN5-6-5	Item 965

21 On the Frame 59 flange, at STGR 36 LH, refer to Fig. A-GBKAD Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 59 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBKAD Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 59 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section B-B.

1	Angle	E5347001121200	Item 32

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 32, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 32, refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAD Sheet 04.

25 On the Frame 59 flange, at STGR 36 LH, remove:

1	Angle	E5347001121200	Item 32

26 Clean and deburr the new fastener holes in the Frame 59, STGR 36 LH and angle, Item 32, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 59 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section B-B.

1	Angle	E5347001121200	Item 32

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D6-07	Item 667

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28 On the Frame 59 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section C-C.

1	Support	D5347032201000	Item (106)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Bolt	EN6115K3-5	Item 365	
3	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
3	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 59 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBKAD Sheet 02, View C.

1	Angle	D5347046821000	Item (127)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-5X	Item 765	
1	Pin	DAN5-6-5Y	Item 785	
2	Collar	DAN11-6X	Item 807	
1	Collar	DAN11-6Y	Item 809	

30 On the Frame 59 flange, at STGR 39 LH, refer to Fig. A-GBKAD Sheet 03, Section D-D, countersink the one fastener hole.

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31 On the Frame 59 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBKAD Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

32 On the Frame 59 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section D-D.

1	Angle	E5347001124600	Item 72

33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 72, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 72, refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBKAD Sheet 04.

34 On the Frame 59 flange, at STGR 39 LH, remove:

1	Angle	E5347001124600	Item 72

35 Clean and deburr the new fastener holes in the Frame 59, STGR 39 LH and angle, Item 72, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

36 On the Frame 59 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBKAD Sheet 02, View C and Fig. A-GBKAD Sheet 03, Section D-D.

1	Angle	E5347001124600	Item 72

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(13) Subtask 531364-831-213-012 - Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 60 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D06R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
34	E5347001021800	1	WEB	
38	E5347001121600	1	ANGLE	
40	E5347001121800	1	ANGLE	
363	EN6115K3-3	5	BOLT	
365	EN6115K3-5	8	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
567	EN6069D6-07	20	RIVET	
656	EN6081D5-06	41	RIVET	
666	EN6081D6-06	25	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	4	RIVET	(2)
764	DAN5-6-4X	4	PIN	
765	DAN5-6-5X	1	PIN	
806	NSA5075-6	19	COLLAR	
807	DAN11-6X	5	COLLAR	
808	ASNA2528-3	14	NUT	
864	DAN6-6-4	5	PIN	
865	DAN6-6-5	5	PIN	
963	DAN5-6-3	1	PIN	
964	DAN5-6-4	4	PIN	
965	DAN5-6-5	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)

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ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBLAD Replacement of Webs and Angles at Frame 60	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBLAD Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural

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parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 60, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347085020000	Item (21)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 60, at STGR 35 LH and from the frame flange between STGR 34 LH and STGR 35 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 60, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347085120000	Item (22)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 60, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347093120600	Item (23)	Discard
1	Support	D5347032201200	Item (108)	Retain
1	Angle	D5347046821200	Item (128)	Retain
1	Section-Connecting	D5347065420400	Item (136)	Retain
1	Shim	D5347044920000	Item (142)	Retain
1	Shim	D5347044920600	Item (143)	Retain
	with			
77	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 60.

Refer to NTM 51-10-01.

Refer to Fig. A-GBLAD Sheet 02, Views C and D.

1 On Frame 60, at STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 60, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 60, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBLAD Sheet 02 thru Fig. A-GBLAD Sheet 04.

1 On Frame 60, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBLAD Sheet 02, View C.

1	Shear Web	E5347001021800	Item 34

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 60 to the shear web, Item 34.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAD Sheet 04.

4 Drill the additional 38 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBLAD Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBLAD Sheet 02.

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NOTE: For the hole diameters, refer to the table on Fig. A-GBLAD Sheet 04.

5 Transfer drill the tack hole from the Frame 60 between STGR 36 LH and STGR 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 60, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021800	Item 34

7 Clean and deburr the new fastener holes in Frame 60and the shear web, Item 34, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBLAD Sheet 02, Views C and D.

a On Frame 60, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBLAD Sheet 02, View C.

1	Shear Web	E5347001021800	Item 34

b On Frame 60, at STGR 35 LH, cold expand the 4 holes for the fasteners, Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAD Sheet 02, View C.

c On Frame 60, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAD Sheet 02, View C.

d On the top flange of Frame 60, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAD Sheet 02, View D.

9 On Frame 60, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021800	Item 34

10 Clean and deburr the cold expansion fastener holes in Frame 60and the shear web, Item 34, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 60, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBLAD Sheet 02, View C.

1	Shear Web	E5347001021800	Item 34

with

5	Bolt	EN6115K3-3	Item 363
20	Rivet	EN6069D6-07	Item 567
37	Rivet	EN6081D5-06	Item 656
25	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
4	Pin	DAN5-6-4X	Item 764
4	Collar	DAN11-6X	Item 807
5	Nut	ASNA2528-3	Item 808

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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12 On the top flange of Frame 60, at STGR 35 LH, install:

Refer to Fig. A-GBLAD Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

13 On the Frame 60 flange, at STGR 35 LH, refer to Fig. A-GBLAD Sheet 03, Section B-B, countersink the one fastener hole.

14 On the Frame 60 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBLAD Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 60 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBLAD Sheet 02, View C and Fig. A-GBLAD Sheet 03, Section B-B.

1	Angle	E5347001121600	Item 38

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 38, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH to the angle, Item 38, refer to Fig. A-GBLAD Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAD Sheet 04.

17 On the Frame 60 flange, at STGR 35 LH, remove:

1	Angle	E5347001121600	Item 38

18 Clean and deburr the new fastener holes in the STGR 35 LH and angle, Item 38, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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19 On the Frame 60 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBLAD Sheet 02, View C and Fig. A-GBLAD Sheet 03, Section B-B.

1	Angle	E5347001121600	Item 38
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
4	Bolt	EN6115K3-5	Item 365
2	Rivet	EN6081D5-06	Item 656
4	Nut	ASNA2528-3	Item 808

20 On the Frame 60 flange, at STGR 36 LH, refer to Fig. A-GBLAD Sheet 03, Section C-C, countersink the one fastener hole.

21 On the Frame 60 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBLAD Sheet 03, Section C-C.

1	Rivet	EN6069D5-05	Item 555
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 60 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBLAD Sheet 02, View C and Fig. A-GBLAD Sheet 03, Section C-C.

1	Angle	E5347001121800	Item 40

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 40, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 40, refer to Fig. A-GBLAD Sheet 02, View C and Fig. A-GBLAD Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAD Sheet 04.

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24 On the Frame 60 flange, at STGR 36 LH, remove:

1	Angle	E5347001121800	Item 40

25 Clean and deburr the new fastener holes in the Frame 60, STGR 36 LH and angle, Item 40, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 60 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBLAD Sheet 02, View C and Fig. A-GBLAD Sheet 03, Section C-C.

1	Angle	E5347001121800	Item 40

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D6-07	Item 667

27 On the Frame 60 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBLAD Sheet 02, View C and Fig. A-GBLAD Sheet 03, Section D-D.

1	Support	D5347032201200	Item (108)	Retained at removal
1	Section-Connecting	D5347065420400	Item (136)	Retained at removal
1	Shim	D5347044920000	Item (142)	Retained at removal
1	Shim	D5347044920600	Item (143)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	
19	Collar	NSA5075-6	Item 806	
4	Nut	ASNA2528-3	Item 808	
5	Pin	DAN6-6-4	Item 864	
5	Pin	DAN6-6-5	Item 865	
1	Pin	DAN5-6-3	Item 963	
4	Pin	DAN5-6-4	Item 964	
4	Pin	DAN5-6-5	Item 965	

28 On the aft side of the Frame 60 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBLAD Sheet 02, View C.

1	Angle	D5347046821200	Item (128)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(14) Subtask 531364-831-214-012 - Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 61 from Stringer 33 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D06R06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
42	E5347001022000	1	WEB	
44	E5347001122000	1	ANGLE	
46	E5347001122200	1	ANGLE	
48	E5347001122400	1	ANGLE	
74	E5347001124800	1	ANGLE	
363	EN6115K3-3	6	BOLT	
364	EN6115K3-4	3	BOLT	
365	EN6115K3-5	4	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	4	RIVET	
567	EN6069D6-07	24	RIVET	
656	EN6081D5-06	36	RIVET	
657	EN6081D5-07	2	RIVET	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
666	EN6081D6-06	23	RIVET	
667	EN6081D6-07	10	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	6	RIVET	(2)
763	DAN5-6-3X	4	PIN	
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
807	DAN11-6X	13	COLLAR	
808	ASNA2528-3	14	NUT	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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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.

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBMAD Replacement of Webs and Angles at Frame 61	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBMAD Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 61, between STGR 33 LH and STGR 34 LH, remove:

1	Clip	D5347091620200	Item (24)	Discard
	with			
12	Rivet		Item (100)	Discard
	or			
13	Rivet		Item (100)	Discard

NOTE: Depending on installation on aircraft.

2 From Frame 61, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347090620000	Item (25)	Discard
	with			
13	Rivet		Item (100)	Discard

3 From the top flange of Frame 61, between STGR 34 LH and STGR 35 LH and from the frame flange between STGR 34 LH and STGR 35 LH, remove:

11	Rivet		Item (100)	Discard

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4 From Frame 61, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347090720000	Item (26)	Discard
	with			
13	Rivet		Item (100)	Discard

5 From Frame 61, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347090820400	Item (27)	Discard
1	Support	D5347032201600	Item (109)	Retain
1	Angle	D5347046821400	Item (130)	Retain
	with			
65	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 61.

Refer to NTM 51-10-01.

Refer to Fig. A-GBMAD Sheet 02, Views C and E.

1 On Frame 61, at STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 61, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 61, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBMAD Sheet 02 thru Fig. A-GBMAD Sheet 04.

1 On Frame 61, between STGR 33 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBMAD Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 61 to the shear web, Item 42.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAD Sheet 04.

4 Drill the additional 31 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBMAD Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBMAD Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAD Sheet 04.

5 Transfer drill the tack hole from the Frame 61 between STGR 36 LH and STGR 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 61, between STGR 33 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022000	Item 42

7 Clean and deburr the new fastener holes in Frame 61 and the shear web, Item 42, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

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Refer to Fig. A-GBMAD Sheet 02, Views C and E.

a On Frame 61, between STGR 33 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBMAD Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

b On Frame 61, at STGR 35 LH, cold expand the 4 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAD Sheet 02, View E.

c On Frame 61, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAD Sheet 02, View C.

d On the top flange of Frame 61, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAD Sheet 02, View E.

9 On Frame 61, between STGR 33 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022000	Item 42

10 Clean and deburr the cold expansion fastener holes in Frame 61 and the shear web, Item 42, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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11 At Frame 61, between STGR 33 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBMAD Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42
	with		
5	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
24	Rivet	EN6069D6-07	Item 567
28	Rivet	EN6081D5-06	Item 656
22	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
	use		
Polysulfide Sealant - General Purpose Brushable		06AAA1	As required

12 On the flange of Frame 61, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBMAD Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 61, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBMAD Sheet 02, View E.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

14 On the Frame 61 flange, at STGR 34 LH, refer to Fig. A-GBMAD Sheet 03, Section A-A, countersink the one fastener hole.

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15 On the Frame 61 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBMAD Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 61 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section A-A.

1	Angle	E5347001122000	Item 44

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 44, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH and the three holes from the Frame to the angle, Item 44, refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAD Sheet 04.

18 On the Frame 61 flange, at STGR 34 LH, remove:

1	Angle	E5347001122000	Item 44

19 Clean and deburr the new fastener holes in the Frame 61, STGR 34 LH and angle, Item 44, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 61 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section A-A.

1	Angle	E5347001122000	Item 44

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

If necessary, close the rivet hole in the frame flange at STGR 34 LH with:

1	Rivet	EN6081D6-06	Item 666

NOTE: Depending on installation on aircraft.

21 On the Frame 61 flange, at STGR 35 LH, refer to Fig. A-GBMAD Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 61 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBMAD Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 61 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section B-B.

1	Angle	E5347001122200	Item 46

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 46, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the four holes from the Frame to the angle, Item 46, refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAD Sheet 04.

25 On the Frame 61 flange, at STGR 35 LH, remove:

1	Angle	E5347001122200	Item 46

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26 Clean and deburr the new fastener holes in the Frame 61, STGR 35 LH and angle, Item 46, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 61 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section B-B.

1	Angle	E5347001122200	Item 46

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
4	Rivet	EN6081D6-07	Item 667

28 On the Frame 61 flange, at STGR 36 LH, refer to Fig. A-GBMAD Sheet 03, Section C-C, countersink the one fastener hole.

29 On the Frame 61 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBMAD Sheet 03, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

30 On the Frame 61 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section C-C.

1	Angle	E5347001122400	Item 48

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31 Transfer drill and ream one new hole from the pilot hole of the angle, Item 48, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 48, refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAD Sheet 04.

32 On the Frame 61 flange, at STGR 36 LH, remove:

1	Angle	E5347001122400	Item 48

33 Clean and deburr the new fastener holes in Frame 61, STGR 36 LH and angle, Item 48, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

34 On the Frame 61 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section C-C.

1	Angle	E5347001122400	Item 48

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D5-07	Item 657
3	Rivet	EN6081D6-07	Item 667

35 On the Frame 61 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section D-D.

1	Support	D5347032201600	Item (109)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	
4	Pin	DAN5-6-3X	Item 763	
4	Collar	DAN11-6X	Item 807	
4	Nut	ASNA2528-3	Item 808	

36 On the Frame 61 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBMAD Sheet 02, View C.

1	Angle	D5347046821400	Item (130)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

37 On the Frame 61 flange, at STGR 39 LH, refer to Fig. A-GBMAD Sheet 03, Section E-E, countersink the one fastener hole.

38 On the Frame 61 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBMAD Sheet 03, Section E-E.

1	Rivet	EN6069D5-05	Item 555	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

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39 On the Frame 61 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section E-E.

1	Angle	E5347001124800	Item 74

40 Transfer drill and ream one new hole from the pilot hole of the angle, Item 74, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the four holes from the Frame to the angle, Item 74, refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section E-E.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAD Sheet 04.

41 On the Frame 61 flange, at STGR 39 LH, remove:

1	Angle	E5347001124800	Item 74

42 Clean and deburr the new fastener holes in the Frame 61, STGR 39 LH and angle, Item 74, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

43 On the Frame 61 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBMAD Sheet 02, View C and Fig. A-GBMAD Sheet 03, Section E-E.

1	Angle	E5347001124800	Item 74

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

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(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(15) Subtask 531364-831-215-012 - Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 62 from Stringer 32 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D06R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
50	E5347001022200	1	WEB	
52	E5347001122600	1	ANGLE	
54	E5347001122800	1	ANGLE	
56	E5347001123000	1	ANGLE	
58	E5347001123200	1	ANGLE	
76	E5347001125000	1	ANGLE	
363	EN6115K3-3	6	BOLT	
364	EN6115K3-4	3	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
365	EN6115K3-5	4	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	5	RIVET	
567	EN6069D6-07	28	RIVET	
568	EN6069D6-08	1	RIVET	
656	EN6081D5-06	45	RIVET	
657	EN6081D5-07	7	RIVET	
666	EN6081D6-06	21	RIVET	
667	EN6081D6-07	7	RIVET	
668	EN6081D6-08	16	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	5	PIN	
765	DAN5-6-5X	3	PIN	
806	NSA5075-6	9	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	14	NUT	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	
965	DAN5-6-5	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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.

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NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBNAD Replacement of Webs and Angles at Frame 62	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBNAD Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 62, between STGR 32 LH and STGR 33 LH, remove:

1	Clip	D5347093420200	Item (28)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From Frame 62, between STGR 33 LH and STGR 34 LH, remove:

1	Clip	D5347084020000	Item (29)	Discard
	with			
13	Rivet		Item (100)	Discard

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3 From Frame 62, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347084120000	Item (30)	Discard
	with			
11	Rivet		Item (100)	Discard

4 From the top flange of Frame 62, at STGR 34 LH and from the frame flange between STGR 32 LH and STGR 35 LH, remove:

13	Rivet		Item (100)	Discard

5 From Frame 62, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347084220000	Item (31)	Discard
	with			
11	Rivet		Item (100)	Discard

6 From Frame 62, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347084820400	Item (32)	Discard
1	Support	D5347032201800	Item (111)	Retain
1	Angle	D5347046821600	Item (131)	Retain
	with			
58	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 62.

Refer to NTM 51-10-01.

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 03, View F.

1 On Frame 62, between STGR 34 LH and STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM

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51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 62, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBNAD Sheet 02 thru Fig. A-GBNAD Sheet 06.

1 On Frame 62, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBNAD Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 62 to the shear web, Item 50.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAD Sheet 06.

4 On Frame 62, between STGR 34 LH and STGR 37 LH, drill the additional 42 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBNAD Sheet 03, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBNAD Sheet 03.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAD Sheet 06.

5 On Frame 62, between STGR 38 LH and STGR 39 LH, drill the additional rivet hole to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBNAD Sheet 03, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBNAD Sheet

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03.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAD Sheet 06.

6 Transfer drill the tack hole from the Frame 62 between STGR 36 LH and STGR 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

7 On Frame 62, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022200	Item 50

8 Clean and deburr the new fastener holes in Frame 62 and the shear web, Item 50, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 03, View F.

a On Frame 62, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBNAD Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

b On Frame 62, between STGR 34 LH and STGR 35 LH, cold expand the 4 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAD Sheet 02, View C.

c On Frame 62, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAD Sheet 02, View C.

d On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAD Sheet 03, View F.

10 On Frame 62, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022200	Item 50

11 Clean and deburr the cold expansion fastener holes in Frame 62 and the shear web, Item 50, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 62, between STGR 32 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBNAD Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

with

5	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
28	Rivet	EN6069D6-07	Item 567
1	Rivet	EN6069D6-08	Item 568
35	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D5-07	Item 657
20	Rivet	EN6081D6-06	Item 666
13	Rivet	EN6081D6-08	Item 668
5	Pin	DAN5-6-4X	Item 764

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4	Collar	NSA5075-6	Item 806
5	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
1	Pin	DAN5-6-3	Item 963
3	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 On the flange of Frame 62, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBNAD Sheet 03, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBNAD Sheet 03, View F.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

15 On the Frame 62 flange, at STGR 33 LH, refer to Fig. A-GBNAD Sheet 04, Section A-A, countersink the one fastener hole.

16 On the Frame 62 flange, at STGR 33 LH, close the rivet hole in STGR 33 LH with:

Refer to Fig. A-GBNAD Sheet 04, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 62 flange, at STGR 33 LH, put in position:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section A-A.

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1	Angle	E5347001122600	Item 52

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 52, to the STGR 33 LH, then transfer drill and ream the other hole from STGR 33 LH and the three holes from the Frame to the angle, Item 52, refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAD Sheet 06.

19 On the Frame 62 flange, at STGR 33 LH, remove:

1	Angle	E5347001122600	Item 52

20 Clean and deburr the new fastener holes in the Frame 62, STGR 33 LH and angle, Item 52, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 62 flange, at STGR 33 LH, wet install:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section A-A.

1	Angle	E5347001122600	Item 52

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Collar	NSA5075-6	Item 806
1	Pin	DAN5-6-5	Item 965

If necessary, close the rivet hole in the frame flange at STGR 34 LH with:

1	Rivet	EN6081D6-06	Item 666

NOTE: Depending on installation on aircraft.

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22 On the Frame 62 flange, at STGR 34 LH, refer to Fig. A-GBNAD Sheet 04, Section B-B, countersink the one fastener hole.

23 On the Frame 62 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBNAD Sheet 04, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 62 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section B-B.

1	Angle	E5347001122800	Item 54

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 54, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH and the three holes from the Frame to the angle, Item 54, refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAD Sheet 06.

26 On the Frame 62 flange, at STGR 34 LH, remove:

1	Angle	E5347001122800	Item 54

27 Clean and deburr the new fastener holes in the Frame 62, STGR 34 LH and angle, Item 54, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 62 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section B-B.

1	Angle	E5347001122800	Item 54

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

29 On the Frame 62 flange, at STGR 34 LH, install:

Refer to Fig. A-GBNAD Sheet 02, View C.

1	Rivet	EN6081D6-07	Item 667

30 On the Frame 62 flange, at STGR 35 LH, refer to Fig. A-GBNAD Sheet 04, Section C-C, countersink the one fastener hole.

31 On the Frame 62 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBNAD Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

32 On the Frame 62 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section C-C.

1	Angle	E5347001123000	Item 56

33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 56, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the five holes from the Frame to the angle, Item 56, refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAD Sheet 06.

34 On the Frame 62 flange, at STGR 35 LH, remove:

1	Angle	E5347001123000	Item 56

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35 Clean and deburr the new fastener holes in the Frame 62, STGR 35 LH and angle, Item 56, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

36 On the Frame 62 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section C-C.

1	Angle	E5347001123000	Item 56

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

37 On the Frame 62 flange, at STGR 36 LH, refer to Fig. A-GBNAD Sheet 04, Section D-D, countersink the one fastener hole.

38 On the Frame 62 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBNAD Sheet 04, Section D-D.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

39 On the Frame 62 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section D-D.

1	Angle	E5347001123200	Item 58

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40 Transfer drill and ream one new hole from the pilot hole of the angle, Item 58, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 58, refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAD Sheet 06.

41 On the Frame 62 flange, at STGR 36 LH, remove:

1	Angle	E5347001123200	Item 58

42 Clean and deburr the new fastener holes in the Frame 62, STGR 36 LH and angle, Item 58, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

43 On the Frame 62 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 04, Section D-D.

1	Angle	E5347001123200	Item 58

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

44 On the Frame 62 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 05, Section E-E.

1	Support	D5347032201800	Item (111)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	

45 On the aft side of the Frame 62 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBNAD Sheet 02, View C.

1	Angle	D5347046821600	Item (131)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

46 On the Frame 62 flange, at STGR 39 LH, refer to Fig. A-GBNAD Sheet 05, Section F-F, countersink the one fastener hole.

47 On the Frame 62 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBNAD Sheet 05, Section F-F.

1	Rivet	EN6069D5-05	Item 555	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

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48 On the Frame 62 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 05, Section F-F.

1	Angle	E5347001125000	Item 76

49 Transfer drill and ream one new hole from the pilot hole of the angle, Item 76, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 76, refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 05, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBNAD Sheet 06.

50 On the Frame 62 flange, at STGR 39 LH, remove:

1	Angle	E5347001125000	Item 76

51 Clean and deburr the new fastener holes in the Frame 62, STGR 39 LH and angle, Item 76, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

52 On the Frame 62 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBNAD Sheet 02, View C and Fig. A-GBNAD Sheet 05, Section F-F.

1	Angle	E5347001125000	Item 76

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

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(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(16) Subtask 531364-831-216-012 - Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 63 from Stringer 32 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D06R06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
60	E5347001022400	1	WEB	
62	E5347001123400	1	ANGLE	
64	E5347001123600	2	ANGLE	
78	E5347001125200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
365	EN6115K3-5	8	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	4	RIVET	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
567	EN6069D6-07	23	RIVET	
568	EN6069D6-08	1	RIVET	
656	EN6081D5-06	43	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	22	RIVET	
667	EN6081D6-07	6	RIVET	
668	EN6081D6-08	12	RIVET	(1)
669	EN6081D6-09	7	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	8	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	13	NUT	
963	DAN5-6-3	8	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

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NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBPAD Replacement of Webs and Angles at Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBPAD Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 63, at STGR 33 LH, remove:

1	Shim	D5347032020200	Item (132)	Retain
1	Sheet-Support	D5347109620000	Item (133)	Retain
	with			
7	Rivet		Item (100)	Discard

2 From Frame 63, between STGR 32 LH and STGR 34 LH, remove:

1	Clip	D5347082820000	Item (33)	Discard
	with			
21	Rivet		Item (100)	Discard

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3 From the top flange of Frame 63, at STGR 34 LH and from the frame flange between STGR 33 LH and STGR 34 LH, remove:

5	Rivet		Item (100)	Discard

4 From Frame 63, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347079220000	Item (34)	Discard
	with			
10	Rivet		Item (100)	Discard

5 From Frame 63, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347079920000	Item (35)	Discard
	with			
11	Rivet		Item (100)	Discard

6 From Frame 63, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347082920200	Item (36)	Discard
1	Support	D5347032202000	Item (114)	Retain
1	Angle	D5347046821800	Item (115)	Retain
	with			
54	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 63.

Refer to NTM 51-10-01.

Refer to Fig. A-GBPAD Sheet 02, Views C and D.

1 On Frame 63, at STGR 34 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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2 On Frame 63, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 8 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 63, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBPAD Sheet 02 thru Fig. A-GBPAD Sheet 06.

1 On Frame 63, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBPAD Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 63 to the shear web, Item 60.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAD Sheet 06.

4 On Frame 63, between STGR 34 LH and STGR 37 LH, drill the additional 41 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBPAD Sheet 03, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBPAD Sheet 03.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAD Sheet 06.

5 Transfer drill the tack hole from the Frame 63 between STGR 36 LH and STGR 37 LH, to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 63, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022400	Item 60

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7 Clean and deburr the new fastener holes in Frame 63 and the shear web, Item 60, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBPAD Sheet 02, Views C and D.

a On Frame 63, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBPAD Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

b On Frame 63, at STGR 34 LH, cold expand the 4 holes for the fasteners, Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAD Sheet 02, View C.

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c On Frame 63, between STGR 36 LH and STGR 37 LH, cold expand the 8 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAD Sheet 02, View C.

d On the top flange of Frame 63, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAD Sheet 02, View D.

9 On Frame 63, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022400	Item 60

10 Clean and deburr the cold expansion fastener holes in Frame 63 and the shear web, Item 60, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 63, between STGR 32 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBPAD Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

with

4	Bolt	EN6115K3-3	Item 363
23	Rivet	EN6069D6-07	Item 567
1	Rivet	EN6069D6-08	Item 568
35	Rivet	EN6081D5-06	Item 656
22	Rivet	EN6081D6-06	Item 666
10	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
6	Collar	DAN11-6X	Item 807
4	Nut	ASNA2528-3	Item 808

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 On the Frame 63 flange, at STGR 33 LH, wet install:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 04, Section A-A.

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1	Shim	D5347032020200	Item (132)	Retained at removal
1	Sheet-Support	D5347109620000	Item (133)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

3	Rivet	EN6081D6-09	Item 669
4	Collar	NSA5075-6	Item 806
4	Pin	DAN5-6-3	Item 963

13 On the Frame 63 flange, at STGR 34 LH, refer to Fig. A-GBPAD Sheet 04, Section B-B, countersink the one fastener hole.

14 On the Frame 63 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBPAD Sheet 04, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

15 On the Frame 63 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 04, Section B-B.

1	Angle	E5347001123400	Item 62

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 62, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH to the angle, Item 62, refer to Fig. A-GBPAD Sheet 04, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAD Sheet 06.

17 On the Frame 63 flange, at STGR 34 LH, remove:

1	Angle	E5347001123400	Item 62

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18 Clean and deburr the new fastener holes in the STGR 34 LH and angle, Item 62, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 63 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 04, Section B-B.

1	Angle	E5347001123400	Item 62

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
2	Rivet	EN6081D5-06	Item 656
4	Nut	ASNA2528-3	Item 808

20 On the top flange of Frame 63, at STGR 35 LH, install:

Refer to Fig. A-GBPAD Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

21 On the Frame 63 flange, at STGR 35 LH, refer to Fig. A-GBPAD Sheet 04, Section C-C, countersink the one fastener hole.

22 On the Frame 63 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBPAD Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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23 On the Frame 63 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 64, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the five holes from the Frame to the angle, Item 64, refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAD Sheet 06.

25 On the Frame 63 flange, at STGR 35 LH, remove:

1	Angle	E5347001123600	Item 64

26 Clean and deburr the new fastener holes in the Frame 63, STGR 35 LH and angle, Item 64, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 63 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

28 On the Frame 63 flange, at STGR 36 LH, refer to Fig. A-GBPAD Sheet 04, Section C-C, countersink the one fastener hole.

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29 On the Frame 63 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBPAD Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

30 On the Frame 63 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

31 Transfer drill and ream one new hole from the pilot hole of the angle, Item 64, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 64, refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAD Sheet 06.

32 On the Frame 63 flange, at STGR 36 LH, remove:

1	Angle	E5347001123600	Item 64

33 Clean and deburr the new fastener holes in the Frame 63, STGR 36 LH and angle, Item 64, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

34 On the Frame 63 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	

35 On the Frame 63 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 05, Section D-D.

1	Support	D5347032202000	Item (114)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
4	Rivet	EN6081D6-09	Item 669
4	Collar	NSA5075-6	Item 806
4	Nut	ASNA2528-3	Item 808
4	Pin	DAN5-6-3	Item 963

36 On the Frame 63 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBPAD Sheet 02, View C.

1	Angle	D5347046821800	Item (115)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

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37 On the Frame 63 flange, at STGR 39 LH, refer to Fig. A-GBPAD Sheet 05, Section E-E, countersink the one fastener hole.

38 On the Frame 63 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBPAD Sheet 05, Section E-E.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

39 On the Frame 63 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 05, Section E-E.

1	Angle	E5347001125200	Item 78

40 Transfer drill and ream one new hole from the pilot hole of the angle, Item 78, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 78, refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 05, Section E-E.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAD Sheet 06.

41 On the Frame 63 flange, at STGR 39 LH, remove:

1	Angle	E5347001125200	Item 78

42 Clean and deburr the new fastener holes in the Frame 63, STGR 39 LH and angle, Item 78, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

43 On the Frame 63 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBPAD Sheet 02, View C and Fig. A-GBPAD Sheet 05, Section E-E.

1	Angle	E5347001125200	Item 78

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(17) Subtask 531364-831-217-012 - Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 Stringer 38 LH
To	160	Work location	from Frame 60 to Frame 63 Stringer 38 LH

Manpower Resources	
Manhours	6.50
Minimum number of person	2
Subtask elapsed time	6.50
Skills	AIRFRAME

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Material necessary to do the job

Kit 531364D06R06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
544	EN6069D4-04	4	RIVET	
545	EN6069D4-05	52	RIVET	
655	EN6081D5-05	15	RIVET	
656	EN6081D5-06	183	RIVET	
657	EN6081D5-07	55	RIVET	
764	DAN5-6-4X	4	PIN	
765	DAN5-6-5X	4	PIN	
784	DAN5-6-4Y	2	PIN	
786	DAN5-6-6Y	6	PIN	
806	NSA5075-6	10	COLLAR	
807	DAN11-6X	8	COLLAR	
809	DAN11-6Y	18	COLLAR	
864	DAN6-6-4	3	PIN	
865	DAN6-6-5	7	PIN	
885	DAN6-6-5Y	4	PIN	
886	DAN6-6-6Y	3	PIN	
887	DAN6-6-7Y	3	PIN	

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	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12 53-41-14
Fig. A-GBQAF Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

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(a) Install the shear plates.

Refer to Fig. A-GBQAF Sheet 01 thru Fig. A-GBQAF Sheet 06.

1 Between Frame 49 and Frame 50, on STGR 38 LH and on the bracket at Frame 49 and bracket, Item 66, put in position:

Refer to Fig. A-GBQAF Sheet 02, View D.

1	Plate-Shear	D5347471500000	Item (139)	Retained at removal

2 Transfer drill and ream the three holes from the shear plate, Item (139), to the bracket, Item 66, refer to Fig. A-GBQAF Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAF Sheet 07.

3 Between Frame 49 and Frame 50, on STGR 38 LH, remove:

1	Plate-Shear	D5347471500000	Item (139)	Retain

4 Between Frame 49 and Frame 50, on STGR 38 LH, clean and deburr the new fastener holes in the bracket, Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

5 Between Frame 49 and Frame 50, on STGR 38 LH and on the bracket at Frame 49 and bracket, Item 66, wet install:

Refer to Fig. A-GBQAF Sheet 02, View D.

1	Plate-Shear	D5347471500000	Item (139)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545
6	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D5-07	Item 657

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6 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item 66, put in position:

Refer to Fig. A-GBQAF Sheet 02, View D.

1	Plate-Shear	D5347471500200	Item (117)	Retained at removal

7 Transfer drill and ream the six holes from the shear plate, Item (117), to the brackets, Item 65 and Item 66, refer to Fig. A-GBQAF Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAF Sheet 07.

8 Between Frame 50 and Frame 51, on STGR 38 LH, remove:

1	Plate-Shear	D5347471500200	Item (117)	Retain

9 Between Frame 50 and Frame 51, on STGR 38 LH, clean and deburr the new fastener holes in the brackets, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

10 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item 66, wet install:

Refer to Fig. A-GBQAF Sheet 02, View D.

1	Plate-Shear	D5347471500200	Item (117)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545
20	Rivet	EN6081D5-07	Item 657
6	Rivet	EN6081D5-06	Item 656

11 Between Frame 51 and Frame 53, on STGR 38 LH and on the brackets, Items 65, Item 67 and Item 68, put in position:

Refer to Fig. A-GBQAF Sheet 03, View F.

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1	Plate-Shear	D5347471500600	Item (137)	Retained at removal
1	Plate Assy-Shear	D5347049100000	Item (119)	Retained at removal

12 Transfer drill and ream the six holes from the shear plate, Item (137), to the brackets, Item 65 and Item 67, refer to Fig. A-GBQAF Sheet 03, View F.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAF Sheet 07.

13 Transfer drill and ream the six holes from the shear plate, Item (119), to the brackets, Item 65 and Item 68, refer to Fig. A-GBQAF Sheet 03, View F.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAF Sheet 07.

14 Between Frame 51 and Frame 53, on STGR 38 LH, remove:

1	Plate-Shear	D5347471500600	Item (137)	Retain
1	Plate Assy-Shear	D5347049100000	Item (119)	Retain

15 Between Frame 51 and Frame 53, on STGR 38 LH, clean and deburr the new fastener holes in the brackets, Items 65, Item 67 and Item 68, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

16 Between Frame 51 and Frame 53, on STGR 38 LH and on the brackets, Items 65, Item 67 and Item 68, wet install:

Refer to Fig. A-GBQAF Sheet 03, View F.

1	Plate-Shear	D5347471500600	Item (137)	Retained at removal
1	Plate Assy-Shear	D5347049100000	Item (119)	Retained at removal
1	Section-Connecting	D5347065020200	Item (135)	Retained at removal

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

4	Rivet	EN6069D4-05	Item 545	
30	Rivet	EN6081D5-06	Item 656	
15	Rivet	EN6081D5-07	Item 657	
2	Pin	DAN5-6-4Y	Item 784	
6	Pin	DAN5-6-6Y	Item 786	
18	Collar	DAN11-6Y	Item 809	
4	Pin	DAN6-6-5Y	Item 885	
3	Pin	DAN6-6-6Y	Item 886	
3	Pin	DAN6-6-7Y	Item 887	

17 Between Frame 53 and Frame 54, on STGR 38 LH and on the brackets, Item 80 and Item 82, put in position:

Refer to Fig. A-GBQAF Sheet 04, View H.

1	Plate-Shear	D5347471501000	Item (141)	Retained at removal

18 Transfer drill and ream the six holes from the shear plate, Item (141), to the brackets, Item 80 and Item 82, refer to Fig. A-GBQAF Sheet 04, View H.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAF Sheet 07.

19 Between Frame 53 and Frame 54, on STGR 38 LH, remove:

1	Plate-Shear	D5347471501000	Item (141)	Retain

20 Between Frame 53 and Frame 54, on STGR 38 LH, clean and deburr the new fastener holes in the brackets, Item 80 and Item 82, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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21 Between Frame 53 and Frame 54, on STGR 38 LH and on the brackets, Item 80 and Item 82, wet install:

Refer to Fig. A-GBQAF Sheet 04, View H.

1	Plate-Shear	D5347471501000	Item (141)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545	
26	Rivet	EN6081D5-06	Item 656	

22 Between Frame 54 and Frame 55, on STGR 38 LH and on the brackets, Item 84 and Item (120), put in position:

Refer to Fig. A-GBQAF Sheet 04, View H.

1	Plate Assy-Shear	D5347048800400	Item (122)	Retained at removal

23 Transfer drill and ream the three holes from the shear plate, Item (122), to the brackets, Item 84, refer to Fig. A-GBQAF Sheet 04, View H.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAF Sheet 07.

24 Between Frame 54 and Frame 55, on STGR 38 LH, remove:

1	Plate Assy-Shear	D5347048800400	Item (122)	Retain

25 Between Frame 54 and Frame 55, on STGR 38 LH, clean and deburr the new fastener holes in the bracket, Item 84, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 Between Frame 54 and Frame 55, on STGR 38 LH and on the brackets, Item 84 and Item (120), wet install:

Refer to Fig. A-GBQAF Sheet 04, View H.

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1	Plate Assy-Shear	D5347048800400	Item (122)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
14	Rivet	EN6069D4-05	Item 545	
26	Rivet	EN6081D5-06	Item 656	

27 Between Frame 56 and Frame 57, on STGR 38 LH and on the brackets, Item (121) and Item (118), wet install:

Refer to Fig. A-GBQAF Sheet 05, View K.

1	Plate Assy-Shear	D5347048900000	Item (124)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
14	Rivet	EN6069D4-05	Item 545	
26	Rivet	EN6081D5-06	Item 656	

28 Between Frame 58 and Frame 59, on STGR 38 LH and on the brackets, Item (125) and Item (127), wet install:

Refer to Fig. A-GBQAF Sheet 05, View M.

1	Plate-Shear	D5347049200000	Item (126)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
14	Rivet	EN6069D4-05	Item 545	
26	Rivet	EN6081D5-06	Item 656	

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29 Between Frame 60 and Frame 61, on STGR 38 LH and on the brackets, Item (128) and Item (130), wet install:

Refer to Fig. A-GBQAF Sheet 06, View P.

1	Plate-Shear	D5347049300000	Item (129)	Retained at removal
1	Section-Connecting	D5347065420400	Item (136)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-04	Item 544
8	Rivet	EN6081D5-05	Item 655
17	Rivet	EN6081D5-06	Item 656
4	Pin	DAN5-6-4X	Item 764
4	Pin	DAN5-6-5X	Item 765
10	Collar	NSA5075-6	Item 806
8	Collar	DAN11-6X	Item 807
3	Pin	DAN6-6-4	Item 864
7	Pin	DAN6-6-5	Item 865

30 Between Frame 62 and Frame 63, on STGR 38 LH and on the brackets, Item (131) and Item (115), wet install:

Refer to Fig. A-GBQAF Sheet 06, View R.

1	Plate-Shear	D5347049400000	Item (123)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-04	Item 544

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7	Rivet	EN6081D5-05	Item 655
20	Rivet	EN6081D5-06	Item 656

(b) Install the corner profiles.

In accordance with SRM 53-41-14.

1 Between Frame 48 thru Frame 63, at STGR 38 LH, install the corner profiles, if removed in accordance with SRM 53-41-14 C2 Identification - Floor Structure - Cargo Compartment.

(c) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(18) Subtask 531364-831-218-002 - Install new Surface Protection on Frame 50 thru Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 from Stringer 31 to Stringer 39
To	160	Work location	from Frame 60 to Frame 63 from Stringer 31 to Stringer 39

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	NON SPECIFIC

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	04JME4	As required	
	Coating - Flexible Structure	04QAB2	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	
	Corrosion Preventive Compound	12ADB1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12

(a) Clean the working area with:

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

(b) Apply sealant beads around the edges of all new and reinstalled structure parts with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(c) Apply to all sealant beads:

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(d) Apply to all sealant beads:

Top Coat Polyurethane	04JME4	As required
and		
Coating - Flexible Structure	04QAB2	As required

(e) Install new water repellent protection on Frame 50 thru Frame 63.

1 Protect the Frame 50 thru Frame 63, STGR 31 LH thru STGR 39 LH and the re-installed shear plates with:

In accordance with SRM 51-23-12.

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Corrosion Preventive Compound	12ADB1	As required

**CONF 007

(1) Subtask 531364-831-201-014 - Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 Stringer 38 LH
To	160	Work location	from Frame 60 to Frame 63 Stringer 38 LH

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

Material necessary to do the job

Consumable CMLD01				
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)	53-41-14
Fig. A-GBQAG Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

CAUTION: AIRBUS CONSIDERS IT IS TECHNICALLY ACCEPTABLE TO REWORK EVERY THIRD FRAME AT THE SAME TIME (I.E. LEAVE TWO FRAMES INTACT AND REWORK ONE) TO KEEP THE FUSELAGE STRUCTURE INTEGRITY.

(a) Remove the corner profiles.

In accordance with SRM 53-41-14 C2 Ident.-Floor Structure-Cargo Compartment.

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1 Between Frame 48 thru Frame 63, at STGR 38 LH, remove the corner profiles, if necessary in accordance with SRM 53-41-14 C2 Identification - Floor Structure - Cargo Compartment.

(b) Remove the shear plates.

Refer to Fig. A-GBQAG Sheet 01 thru Fig. A-GBQAG Sheet 06.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 Between Frame 49 and Frame 50, from STGR 38 LH and from the bracket at Frame 49 and bracket, Item (140), remove:

Refer to Fig. A-GBQAG Sheet 02, View C.

1	Plate-Shear	D5347471500000	Item (139)	Retain
	with			
28	Rivet		Item (100)	Discard

2 Between Frame 50 and Frame 51, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAG Sheet 02, View C.

1	Plate-Shear	D5347471500200	Item (117)	Retain
	with			
28	Rivet		Item (100)	Discard

3 Between Frame 51 and Frame 52, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAG Sheet 02, View C.

1	Plate-Shear	D5347471502800	Item (180)	Retain
	with			
28	Rivet		Item (100)	Discard

4 Between Frame 52 and Frame 53, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAG Sheet 03, View E.

1	Plate-Shear	D5347471503000	Item (190)	Retain
	with			

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29	Rivet		Item (100)	Discard

5 Between Frame 53 and Frame 54, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAG Sheet 03, View E.

1	Plate-Shear	D5347471501000	Item (141)	Retain

with

28	Rivet		Item (100)	Discard

6 Between Frame 54 and Frame 55, from STGR 38 LH and from the brackets, Item (161) and Item (120), remove:

Refer to Fig. A-GBQAG Sheet 03, View E.

1	Plate Assy-Shear	D5347048800400	Item (122)	Retain

with

40	Rivet		Item (100)	Discard

7 Between Frame 56 and Frame 57, from STGR 38 LH and from the brackets, Item (121) and Item (118), remove:

Refer to Fig. A-GBQAG Sheet 04, View G.

1	Plate Assy-Shear	D5347048900000	Item (124)	Retain

with

40	Rivet		Item (100)	Discard

8 Between Frame 58 and Frame 59, from STGR 38 LH and from the brackets, Item (125) and Item (127), remove:

Refer to Fig. A-GBQAG Sheet 05, View J.

1	Plate-Shear	D5347049200200	Item (126)	Retain

with

40	Rivet		Item (100)	Discard

9 Between Frame 60 and Frame 61, from STGR 38 LH and from the brackets, Item (128) and Item (130), remove:

Refer to Fig. A-GBQAG Sheet 05, View L.

1	Plate-Shear	D5347049300200	Item (129)	Retain

with

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30	Rivet		Item (100)	Discard

10 Between Frame 62 and Frame 63, from STGR 38 LH and from the brackets, Item (131) and Item (115), remove:

Refer to Fig. A-GBQAG Sheet 06, View N.

1	Plate-Shear	D5347049400000	Item (123)	Retain

with

29	Rivet		Item (100)	Discard

(c) Clean the contact surfaces and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

(2) Subtask 531364-831-202-006 - Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 55 from Stringer 33 LH to Stringer 34 LH from Stringer 36 LH to Stringer 37 LH Frame 56 from Stringer 33 LH to Stringer 34 LH from Stringer 35 LH to Stringer 37 LH from Frame 57 to Frame 59 from Stringer 33 LH to Stringer 34 LH from Stringer 36 LH to Stringer 37 LH
To	160	Work location	from Frame 60 to Frame 62 from Stringer 32 LH to Stringer 33 LH from Stringer 36 LH to Stringer 37 LH Frame 63 from Stringer 31 LH to Stringer 32 LH from Stringer 36 LH to Stringer 37 LH

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Manpower Resources	
Manhours	5.00
Minimum number of person	1
Subtask elapsed time	5.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

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 Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane	04JME4	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00

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References	
Fig. A-GBRAB Cold Expansion of Holes in Frame 50 thru Frame 63	Sheet 01 Sheet 02 Sheet 03

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

(a) Inspect the holes for cracks from Frame 50 thru Frame 55 and from Frame 57 thru Frame 59.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 02.

1 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 33 LH and STGR 34 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(b) Cold expand the holes from Frame 50 thru Frame 55 and from Frame 57 thru Frame 59.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 02.

1 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 33 LH and STGR 34 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1 Capital Tooling 1

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DK-A320531364-1 Durable Tooling 1

EK-A320531364-1 Expendable Tooling 1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1 Capital Tooling 1

DK-A320531364-1 Durable Tooling 1

EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 02, View C.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1 Capital Tooling 1

DK-A320531364-1 Durable Tooling 1

EK-A320531364-1 Expendable Tooling 1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1 Capital Tooling 1

DK-A320531364-1 Durable Tooling 1

EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 02, View C.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

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3 Clean the area of the expanded holes with:

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

4 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(c) Inspect the holes for cracks at Frame 56.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 02.

1 At Frame 56, between STGR 33 LH and STGR 34 LH and between STGR 35 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 At Frame 56, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Cold expand the holes at Frame 56.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 02.

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1 At Frame 56, between STGR 33 LH and STGR 34 LH and between STGR 35 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 02, View D.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 At Frame 56, between STGR 37 LH and STGR 38 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 02, View D.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 Clean the area of the expanded holes with:

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

4 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(e) Inspect the holes for cracks from Frame 60 thru Frame 62.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 02.

1 From Frame 60 thru Frame 62, between STGR 32 LH and STGR 33 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 From Frame 60 thru Frame 62, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

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3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(f) Cold expand the holes from Frame 60 thru Frame 62.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 02.

1 From Frame 60 thru Frame 62, between STGR 32 LH and STGR 33 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 02, View E.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 From Frame 60 thru Frame 62, between STGR 37 LH and STGR 38 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 02, View E.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

4 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(g) Inspect the holes for cracks at Frame 63.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 03.

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1 At Frame 63, between STGR 31 LH and STGR 32 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frame, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 At Frame 63, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(h) Cold expand the holes at Frame 63.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 03.

1 At Frame 63, between STGR 31 LH and STGR 32 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frame. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 03, View F.

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NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 At Frame 63, between STGR 37 LH and STGR 38 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 03, View F.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

4 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

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Top Coat Polyurethane	04JME4	As required

(3) Subtask 531364-831-203-015 - Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 50 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D07R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
4	E5347001024400	1	WEB	
36	E5347001124200	1	ANGLE	
65	E5347001420200	1	ANGLE	
66	E5347001420000	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	11	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
668	EN6081D6-08	11	RIVET	(1)
764	DAN5-6-4X	15	PIN	
765	DAN5-6-5X	13	PIN	
766	DAN5-6-6X	6	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	2	PIN	
785	DAN5-6-5Y	3	PIN	
786	DAN5-6-6Y	1	PIN	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	38	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01

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References	
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBAAE Replacement of Webs and Angles at Frame 50	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBAAE Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 50, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
17	Rivet		Item (100)	Discard

2 From the flange of Frame 50, between STGR 35 LH and STGR 36 LH, remove:

6	Rivet		Item (100)	Discard

3 From Frame 50, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347073420200	Item (1)	Discard
	with			
18	Rivet		Item (100)	Discard

4 From Frame 50, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072820600	Item (2)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347470120200	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard
	with			

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66	Rivet	Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 50.

Refer to NTM 51-10-01.

Refer to Fig. A-GBAAE Sheet 02, View C.

1 On Frame 50, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 50, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBAAE Sheet 02 thru Fig. A-GBAAE Sheet 04.

1 On Frame 50, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBAAE Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 50 to the shear web, Item 4.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAE

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Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBAAE Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBAAE Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAE Sheet 04.

5 Transfer drill the tack hole from the Frame 50 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 50 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 50, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

8 Clean and deburr the new fastener holes in Frame 50 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBAAE Sheet 02, View C.

a On Frame 50, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBAAE Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

b On Frame 50, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

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FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAE Sheet 02, View C.

c On Frame 50, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAE Sheet 02, View C.

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d On Frame 50, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAE Sheet 02, View C.

10 On Frame 50, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

11 Clean and deburr the cold expansion fastener holes in Frame 50 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 50, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBAAE Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

with

3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374

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1	Bolt	EN6115K3A5	Item 375
11	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
11	Rivet	EN6081D6-08	Item 668
15	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-5X	Item 765
3	Pin	DAN5-6-5Y	Item 785
25	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809
5	Nut	ASNA2528-3A	Item 908

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 50, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBAAE Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

14 On the Frame 50 flange, at STGR 35 LH, refer to Fig. A-GBAAE Sheet 03, Section C-C, countersink the one fastener hole.

15 On the Frame 50 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBAAE Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 50 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBAAE Sheet 02, View C and Fig. A-GBAAE Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBAAE Sheet 02, View C and Fig. A-GBAAE Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAE Sheet 04.

18 On the Frame 50 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 50, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 50 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBAAE Sheet 02, View C and Fig. A-GBAAE Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

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21 On the Frame 50 flange, at STGR 36 LH, refer to Fig. A-GBAAE Sheet 03, Section D-D, countersink the one fastener hole.

22 On the Frame 50 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBAAE Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 50 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBAAE Sheet 02, View C and Fig. A-GBAAE Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBAAE Sheet 02, View C and Fig. A-GBAAE Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAE Sheet 04.

25 On the Frame 50 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 50, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 50 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBAAE Sheet 02, View C and Fig. A-GBAAE Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

28 On the Frame 50 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBAAE Sheet 02, View C and Fig. A-GBAAE Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Pin	DAN5-6-6X	Item 766	
2	Pin	DAN5-6-7X	Item 767	
4	Collar	NSA5075-6	Item 806	
6	Collar	DAN11-6X	Item 807	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 50 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBAAE Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

30 Transfer drill and ream the three holes from the Frame to the angles, Item 65 and Item 66, refer to Fig. A-GBAAE Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAE Sheet 04.

31 On the Frame 50 flange, at STGR 38 LH, remove:

1	Angle	E5347001420200	Item 65

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1	Angle	E5347001420000	Item 66

32 Clean and deburr the new fastener holes in the Frame 50 and angles, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

33 On the Frame 50 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBAAE Sheet 02, View C and Section B-B.

1	Angle	E5347001420000	Item 66
1	Angle	E5347001420200	Item 65

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-8X	Item 768
1	Pin	DAN5-6-6Y	Item 786
2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

34 On the Frame 50 flange, at STGR 39 LH, refer to Fig. A-GBAAE Sheet 03, Section F-F, countersink the one fastener hole.

35 On the Frame 50 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBAAE Sheet 03, Section F-F.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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36 On the Frame 50 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBAAE Sheet 02, View C and Fig. A-GBAAE Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

37 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBAAE Sheet 02, View C and Fig. A-GBAAE Sheet 03, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAE Sheet 04.

38 On the Frame 50 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

39 Clean and deburr the new fastener holes in the Frame 50, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

40 On the Frame 50 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBAAE Sheet 02, View C and Fig. A-GBAAE Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Pin	DAN5-6-6X	Item 766
2	Collar	DAN11-6X	Item 807

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(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(4) Subtask 531364-831-204-007 - Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 51 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D07R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
4	E5347001024400	1	WEB	
36	E5347001124200	1	ANGLE	
65	E5347001420200	1	ANGLE	
66	E5347001420000	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	3	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
667	EN6081D6-07	23	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	4	RIVET	(2)
764	DAN5-6-4X	14	PIN	
765	DAN5-6-5X	13	PIN	
766	DAN5-6-6X	6	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	2	PIN	
785	DAN5-6-5Y	3	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	37	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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.

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NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBBAE Replacement of Webs and Angles at Frame 51	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBBAE Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 51, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
17	Rivet		Item (100)	Discard

2 From the flange of Frame 51, between STGR 35 LH and STGR 36 LH, remove:

6	Rivet		Item (100)	Discard

3 From Frame 51, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347073420200	Item (1)	Discard

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with

18	Rivet		Item (100)	Discard

4 From Frame 51, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072820600	Item (2)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347470120200	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard

with

66	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 51.

Refer to NTM 51-10-01.

Refer to Fig. A-GBBAE Sheet 02, View C.

1 On Frame 51, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 51, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

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(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBBAE Sheet 02 thru Fig. A-GBBAE Sheet 04.

1 On Frame 51, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBBAE Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 51 to the shear web, Item 4.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAE Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBBAE Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBBAE Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAE Sheet 04.

5 Transfer drill the tack hole from the Frame 51 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 51 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 51, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

8 Clean and deburr the new fastener holes in Frame 51 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

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Refer to Fig. A-GBBAE Sheet 02, View C.

a On Frame 51, between STGR 34 LH and STGR 39 LH, put in position:

1	Shear Web	E5347001024400	Item 4

b On Frame 51, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAE Sheet 02, View C.

c On Frame 51, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAE Sheet 02, View C.

d On Frame 51, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAE Sheet 02, View C.

10 On Frame 51, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

11 Clean and deburr the cold expansion fastener holes in Frame 51 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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12 At Frame 51, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBBAE Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4
	with		
3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
8	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D6-07	Item 667
19	Rivet	EN6081D6-08	Item 668
4	Rivet	EN6081D6-09	Item 669
14	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-5X	Item 765
3	Pin	DAN5-6-5Y	Item 785
24	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809
5	Nut	ASNA2528-3A	Item 908
	use		
Polysulfide Sealant - General Purpose Brushable		06AAA1	As required

13 Install 1 fastener in the flange of Frame 51, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBBAE Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

14 On the Frame 51 flange, at STGR 35 LH, refer to Fig. A-GBBAE Sheet 03, Section C-C, countersink the one fastener hole.

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15 On the Frame 51 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBBAE Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 51 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAE Sheet 04.

18 On the Frame 51 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 51, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 51 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

21 On the Frame 51 flange, at STGR 36 LH, refer to Fig. A-GBBAE Sheet 03, Section D-D, countersink the one fastener hole.

22 On the Frame 51 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBBAE Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 51 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAE Sheet 04.

25 On the Frame 51 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 51, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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27 On the Frame 51 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

28 On the Frame 51 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Pin	DAN5-6-6X	Item 766	
2	Pin	DAN5-6-7X	Item 767	
4	Collar	NSA5075-6	Item 806	
6	Collar	DAN11-6X	Item 807	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 51 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBBAE Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

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30 Transfer drill and ream the three holes from the Frame to the angles, Item 65 and Item 66, refer to Fig. A-GBBAE Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAE Sheet 04.

31 On the Frame 51 flange, at STGR 38 LH, remove:

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

32 Clean and deburr the new fastener holes in the Frame 51 and angles, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

33 On the Frame 51 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBBAE Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-8X	Item 768
1	Pin	DAN5-6-6Y	Item 786
2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

34 On the Frame 51 flange, at STGR 39 LH, refer to Fig. A-GBBAE Sheet 03, Section F-F, countersink the one fastener hole.

35 On the Frame 51 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBBAE Sheet 03, Section F-F.

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1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

36 On the Frame 51 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

37 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAE Sheet 04.

38 On the Frame 51 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

39 Clean and deburr the new fastener holes in the Frame 51, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

40 On the Frame 51 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBBAE Sheet 02, View C and Fig. A-GBBAE Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657

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2	Pin	DAN5-6-6X	Item 766
2	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(5) Subtask 531364-831-205-014 - Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 52 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D07R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
6	E5347001027000	1	WEB	
65	E5347001420200	1	ANGLE	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
67	E5347001421200	1	ANGLE	
88	E5347001125400	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	6	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
667	EN6081D6-07	22	RIVET	
668	EN6081D6-08	14	RIVET	(1)
764	DAN5-6-4X	15	PIN	
765	DAN5-6-5X	13	PIN	
766	DAN5-6-6X	6	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	2	PIN	
785	DAN5-6-5Y	3	PIN	
786	DAN5-6-6Y	1	PIN	
806	NSA5075-6	6	COLLAR	
807	DAN11-6X	43	COLLAR	
808	ASNA2528-3	8	NUT	
809	DAN11-6Y	4	COLLAR	
873	DAN6-6-3X	5	PIN	
908	ASNA2528-3A	1	NUT	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

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Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

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NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBCAG Replacement of Webs and Angles at Frame 52	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBCAG Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 52, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920200	Item (3)	Discard
	with			
18	Rivet		Item (100)	Discard

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2 From the flange of Frame 52, between STGR 35 LH and STGR 36 LH, remove:

6	Rivet		Item (100)	Discard

3 From Frame 52, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
18	Rivet		Item (100)	Discard

4 From Frame 52, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078320600	Item (5)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347470120200	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard
	with			
64	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 52.

Refer to NTM 51-10-01.

Refer to Fig. A-GBCAG Sheet 02, View C.

1 On Frame 52, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

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2 On Frame 52, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBCAG Sheet 02 thru Fig. A-GBCAG Sheet 04.

1 On Frame 52, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBCAG Sheet 02, View C.

1	Shear Web	E5347001027000	Item 6

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 52 to the shear web, Item 6.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAG Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBCAG Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBCAG Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAG Sheet 04.

5 Transfer drill the tack hole from the Frame 52 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 52 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 52, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001027000	Item 6

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8 Clean and deburr the new fastener holes in the Frame 52 and the shear web, Item 6, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBCAG Sheet 02, View C.

a On Frame 52, between STGR 34 LH and STGR 39 LH, put in position:

1	Shear Web	E5347001027000	Item 6

b On Frame 52, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAG Sheet 02, View C.

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c On Frame 52, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAG Sheet 02, View C.

d On Frame 52, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAG Sheet 02, View C.

10 On Frame 52, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001027000	Item 6

11 Clean and deburr the cold expansion fastener holes in the Frame 52 and the shear web, Item 6, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 52, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBCAG Sheet 02, View C.

1	Shear Web	E5347001027000	Item 6

with

3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
6	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D6-07	Item 667
14	Rivet	EN6081D6-08	Item 668
15	Pin	DAN5-6-4X	Item 764
3	Pin	DAN5-6-5Y	Item 785
10	Pin	DAN5-6-5X	Item 765
1	Collar	NSA5075-6	Item 806
30	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809

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5	Pin	DAN6-6-3X	Item 873
1	Pin	DAN5-6-3	Item 963

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 52, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBCAG Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

14 On the Frame 52 flange, at STGR 35 LH, refer to Fig. A-GBCAG Sheet 03, Section C-C, countersink the one fastener hole.

15 On the Frame 52 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBCAG Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 52 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBCAG Sheet 02, View C and Fig. A-GBCAG Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes in the Frame to the angle, Item 1, refer to Fig. A-GBCAG Sheet 02, View C and Fig. A-GBCAG Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAG Sheet 04.

18 On the Frame 52 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

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19 Clean and deburr the new fastener holes in the Frame 52, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 52 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBCAG Sheet 02, View C and Fig. A-GBCAG Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

21 On the Frame 52 flange, at STGR 36 LH, refer to Fig. A-GBCAG Sheet 03, Section D-D, countersink the one fastener hole.

22 On the Frame 52 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBCAG Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 52 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBCAG Sheet 02, View C and Fig. A-GBCAG Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

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24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBCAG Sheet 02, View C and Fig. A-GBCAG Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAG Sheet 04.

25 On the Frame 52 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 52, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 52 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBCAG Sheet 02, View C and Fig. A-GBCAG Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-4	Item 964
1	Collar	NSA5075-6	Item 806

28 On the Frame 52 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBCAG Sheet 02, View C and Fig. A-GBCAG Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Pin	DAN5-6-6X	Item 766
2	Pin	DAN5-6-7X	Item 767
6	Collar	DAN11-6X	Item 807
4	Collar	NSA5075-6	Item 806
4	Pin	DAN5-6-3	Item 963

29 On the Frame 52 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBCAG Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001421200	Item 67

30 Transfer drill and ream the three holes from the Frame to the angles, Item 65 and Item 67, refer to Fig. A-GBCAG Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAG Sheet 04.

31 On the Frame 52 flange, at STGR 38 LH, remove:

1	Angle	E5347001420200	Item 65
1	Angle	E5347001421200	Item 67

32 Clean and deburr the new fastener holes in the Frame 52 and angles, Item 65 and Item 67, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

33 On the Frame 52 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBCAG Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65

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1	Angle	E5347001421200	Item 67
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
1	Pin	DAN5-6-6Y	Item 786
2	Pin	DAN5-6-8X	Item 768
2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

34 On the Frame 52 flange, at STGR 39 LH, refer to Fig. A-GBCAG Sheet 03, Section F-F, countersink the one fastener hole.

35 On the Frame 52 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBCAG Sheet 03, Section F-F.

1	Rivet	EN6069D5-06	Item 556
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

36 On the Frame 52 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBCAG Sheet 02, View C and Fig. A-GBCAG Sheet 03, Section F-F.

1	Angle	E5347001125400	Item 88

37 Transfer drill and ream one new hole from the pilot hole of the angle, Item 88, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the refer to Fig. A-GBCAG Sheet 02, View C and Fig. A-GBCAG Sheet 03, Section F-F.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAG Sheet 04.

38 On the Frame 52 flange, at STGR 39 LH, remove:

1	Angle	E5347001125400	Item 88

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39 Clean and deburr the new fastener holes in the Frame 52, STGR 39 LH and angle, Item 88, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

40 On the Frame 52 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBCAG Sheet 02, View C and Fig. A-GBCAG Sheet 03, Section F-F.

1	Angle	E5347001125400	Item 88

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-6X	Item 766
2	Rivet	EN6081D5-07	Item 657
2	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

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(6) Subtask 531364-831-206-013 - Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 53 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D07R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
8	E5347001029400	1	WEB	
36	E5347001124200	1	ANGLE	
68	E5347001421400	1	ANGLE	
80	E5347001421600	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
667	EN6081D6-07	22	RIVET	
764	DAN5-6-4X	15	PIN	
765	DAN5-6-5X	13	PIN	
766	DAN5-6-6X	6	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	1	PIN	
784	DAN5-6-4Y	2	PIN	
785	DAN5-6-5Y	2	PIN	
806	NSA5075-6	6	COLLAR	
807	DAN11-6X	47	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
873	DAN6-6-3X	10	PIN	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	1	PIN	

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBDAG Replacement of Webs and Angles at Frame 53	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBDAG Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 53, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
17	Rivet		Item (100)	Discard

2 From the flange of Frame 53, between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 53, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
18	Rivet		Item (100)	Discard

4 From Frame 53, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078320400	Item (6)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347470120200	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard
	with			
68	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required
and		

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Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 53.

Refer to NTM 51-10-01.

Refer to Fig. A-GBDAG Sheet 01, View C.

1 On Frame 53, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 53, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBDAG Sheet 02 thru Fig. A-GBDAG Sheet 04.

1 On Frame 53, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBDAG Sheet 02, View C.

1	Shear Web	E5347001029400	Item 8

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 53 to the shear web, Item 8.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAG Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBDAG Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBDAG Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAG

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Sheet 04.

5 Transfer drill the tack hole from the Frame 53 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 53 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 53, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001029400	Item 8

8 Clean and deburr the new fastener holes in Frame 53 and the shear web, Item 8, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBDAG Sheet 02, View C.

a On Frame 53, between STGR 34 LH and STGR 39 LH, put in position:

1	Shear Web	E5347001029400	Item 8

b On Frame 53, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAG Sheet 02, View C.

c On Frame 53, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAG Sheet 02, View C.

d On Frame 53, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAG Sheet 02, View C.

10 On Frame 53, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001029400	Item 8

11 Clean and deburr the cold expansion fastener holes in Frame 53 and the shear web, Item 8, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 53, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBDAG Sheet 02, View C.

1	Shear Web	E5347001029400	Item 8

with

3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D6-07	Item 667
15	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-5X	Item 765
2	Pin	DAN5-6-4Y	Item 784

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1	Pin	DAN5-6-5Y	Item 785
1	Collar	NSA5075-6	Item 806
35	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809
10	Pin	DAN6-6-3X	Item 873
5	Nut	ASNA2528-3A	Item 908
1	Pin	DAN5-6-3	Item 963

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 53, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBDAG Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

14 On the Frame 53 flange, at STGR 35 LH, refer to Fig. A-GBDAG Sheet 03, Section C-C, countersink the one fastener hole.

15 On the Frame 53 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBDAG Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 53 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBDAG Sheet 02, View C and Fig. A-GBDAG Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

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17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBDAG Sheet 02, View C and Fig. A-GBDAG Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAG Sheet 04.

18 On the Frame 53 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 53, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 53 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBDAG Sheet 02, View C and Fig. A-GBDAG Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

21 On the Frame 53 flange, at STGR 36 LH, refer to Fig. A-GBDAG Sheet 03, Section D-D, countersink the one fastener hole.

22 On the Frame 53 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBDAG Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 53 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBDAG Sheet 02, View C and Fig. A-GBDAG Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBDAG Sheet 02, View C and Fig. A-GBDAG Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAG Sheet 04.

25 On the Frame 53 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 53, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 53 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBDAG Sheet 02, View C and Fig. A-GBDAG Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667
1	Collar	NSA5075-6	Item 806

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1	Pin	DAN5-6-4	Item 964	

28 On the Frame 53 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBDAG Sheet 02, View C and Fig. A-GBDAG Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Pin	DAN5-6-6X	Item 766
2	Pin	DAN5-6-7X	Item 767
4	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
4	Pin	DAN5-6-3	Item 963

29 On the Frame 53 flange, at STGR 38 LH, put in position

Refer to Fig. A-GBDAG Sheet 02, View C and Section B-B.

1	Angle	E5347001421400	Item 68
1	Angle	E5347001421600	Item 80

30 Transfer drill and ream the three holes from the Frame to the angles, Item 68 and Item 80, refer to Fig. A-GBDAG Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAG Sheet 04.

31 On the Frame 53 flange, at STGR 38 LH, remove:

1	Angle	E5347001421400	Item 68
1	Angle	E5347001421600	Item 80

32 Clean and deburr the new fastener holes in the Frame 53 and angles, Item 68 and Item 80, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

33 On the Frame 53 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBDAG Sheet 02, View C and Section B-B.

1	Angle	E5347001421400	Item 68
1	Angle	E5347001421600	Item 80

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

1	Pin	DAN5-6-5Y	Item 785
1	Collar	DAN11-6Y	Item 809
1	Pin	DAN5-6-8X	Item 768
1	Collar	DAN11-6X	Item 807

34 On the Frame 53 flange, at STGR 39 LH, refer to Fig. A-GBDAG Sheet 03, Section F-F, countersink the one fastener hole.

35 On the Frame 53 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBDAG Sheet 03, Section F-F.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

36 On the Frame 53 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBDAG Sheet 02, View C and Fig. A-GBDAG Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

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37 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBDAG Sheet 03, Section F-F

NOTE: For the hole diameters, refer to the table on Fig. A-GBDAG Sheet 04.

38 On the Frame 53 flange, at STGR 39 LH, remove:

7	Angle	E5347001124200	Item 36

39 Clean and deburr the new fastener holes in the Frame 53, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

40 On the Frame 53 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBDAG Sheet 02, View C and Fig. A-GBDAG Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Pin	DAN5-6-6X	Item 766
2	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

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Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(7) Subtask 531364-831-207-013 - Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 54 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D07R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
10	E5347001025000	1	WEB	
36	E5347001124200	1	ANGLE	
82	E5347001421800	1	ANGLE	
84	E5347001422000	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
764	DAN5-6-4X	15	PIN	
765	DAN5-6-5X	13	PIN	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
766	DAN5-6-6X	6	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	2	PIN	
784	DAN5-6-4Y	2	PIN	
785	DAN5-6-5Y	2	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	48	COLLAR	
808	ASNA2528-3	3	NUT	
809	DAN11-6Y	4	COLLAR	
873	DAN6-6-3X	10	PIN	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	4	PIN	

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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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.

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBEAG Replacement of Webs and Angles at Frame 54	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBEAG Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 54, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
17	Rivet		Item (100)	Discard

2 From the flange of Frame 54, between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 54, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
18	Rivet		Item (100)	Discard

4 From Frame 54, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078520400	Item (7)	Discard
1	Support	D5347032200000	Item (101)	Retain

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1	Angle	D5347470120200	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard
	with			
68	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 54.

Refer to NTM 51-10-01.

Refer to Fig. A-GBEAG Sheet 02, Views C.

1 On Frame 54, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 54, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBEAG Sheet 02 thru Fig. A-GBEAG Sheet 04.

1 On Frame 54, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBEAG Sheet 02, View C.

1	Shear Web	E5347001025000	Item 10

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2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 54 to the shear web, Item 10.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAG Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBEAG Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBEAG Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAG Sheet 04.

5 Transfer drill the tack hole from the Frame 54 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 54 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 54, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025000	Item 10

8 Clean and deburr the fastener holes in Frame 54 and the shear web, Item 10, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBEAG Sheet 02, Views C.

a On Frame 54, between STGR 34 LH and STGR 39 LH, put in position:

1	Shear Web	E5347001025000	Item 10

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b On Frame 54, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAG Sheet 02, View C.

c On Frame 54, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAG Sheet 02, View C.

d On Frame 54, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAG Sheet 02, View C.

10 On Frame 54, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025000	Item 10

11 Clean and deburr the cold expansion fastener holes in Frame 54 and the shear web, Item 10, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 54, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBEAG Sheet 02, View C.

1	Shear Web	E5347001025000	Item 10

with

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3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
15	Pin	DAN5-6-4X	Item 764
10	Pin	DAN5-6-5X	Item 765
2	Pin	DAN5-6-4Y	Item 784
1	Pin	DAN5-6-5Y	Item 785
35	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
3	Collar	DAN11-6Y	Item 809
10	Pin	DAN6-6-3X	Item 873
5	Nut	ASNA2528-3A	Item 908

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 54, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBEAG Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

14 On the Frame 54 flange, at STGR 35 LH, refer to Fig. A-GBEAG Sheet 03, Section C-C, countersink the one fastener hole.

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15 On the Frame 54 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBEAG Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 54 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBEAG Sheet 02, View C and Fig. A-GBEAG Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBEAG Sheet 02, View C and Fig. A-GBEAG Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAG Sheet 04.

18 On the Frame 54 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 54, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 54 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBEAG Sheet 02, View C and Fig. A-GBEAG Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

21 On the Frame 54 flange, at STGR 36 LH, refer to Fig. A-GBEAG Sheet 03, Section D-D, countersink the one fastener hole.

22 On the Frame 54 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBEAG Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 54 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBEAG Sheet 02, View C and Fig. A-GBEAG Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBEAG Sheet 02, View C and Fig. A-GBEAG Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAG Sheet 04.

25 On the Frame 54 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 54, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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27 On the Frame 54 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBEAG Sheet 02, View C and Fig. A-GBEAG Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

28 On the Frame 54 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBEAG Sheet 02, View C and Fig. A-GBEAG Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Pin	DAN5-6-6X	Item 766	
2	Pin	DAN5-6-7X	Item 767	
4	Collar	NSA5075-6	Item 806	
6	Collar	DAN11-6X	Item 807	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 54 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBEAG Sheet 02, View C and Section B-B.

1	Angle	E5347001421800	Item 82
1	Angle	E5347001422000	Item 84

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30 Transfer drill and ream the three holes from the Frame to the angles, Item 82 and Item 84, refer to Fig. A-GBEAG Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAG Sheet 04.

31 On the Frame 54 flange, at STGR 38 LH, remove:

1	Angle	E5347001421800	Item 82
1	Angle	E5347001422000	Item 84

32 Clean and deburr the new fastener holes in the Frame 54 and angles, Item 82 and Item 84, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

33 On the Frame 54 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBEAG Sheet 02, View C and Section B-B.

1	Angle	E5347001421800	Item 82
1	Angle	E5347001422000	Item 84

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

1	Pin	DAN5-6-5Y	Item 785
1	Collar	DAN11-6Y	Item 809
2	Pin	DAN5-6-8X	Item 768
2	Collar	DAN11-6X	Item 807

34 On the Frame 54 flange, at STGR 39 LH, refer to Fig. A-GBEAG Sheet 03, Section F-F, countersink the one fastener hole.

35 On the Frame 54 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBEAG Sheet 03, Section F-F.

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1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

36 On the Frame 54 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBEAG Sheet 02, View C and Fig. A-GBEAG Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

37 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two hole from the Frame to the angle, Item 36, refer to Fig. A-GBEAG Sheet 02, View C and Fig. A-GBEAG Sheet 03, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAG Sheet 04.

38 On the Frame 54 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

39 Clean and deburr the new fastener holes in the Frame 54, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

40 On the Frame 54 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBEAG Sheet 02, View C and Fig. A-GBEAG Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657

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2	Pin	DAN5-6-6X	Item 766
2	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(8) Subtask 531364-831-208-013 - Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 55 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D07R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
12	E5347001025400	1	WEB	
36	E5347001124200	1	ANGLE	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	6	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	16	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	10	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	12	PIN	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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.

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NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBFAE Replacement of Webs and Angles at Frame 55	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBFAE Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 55, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 55, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

10	Rivet		Item (100)	Discard

3 From Frame 55, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard

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with

14	Rivet		Item (100)	Discard

4 From Frame 55, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072121000	Item (8)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046823800	Item (120)	Retain

with

56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 55.

Refer to NTM 51-10-01.

Refer to Fig. A-GBFAE Sheet 02, Views C, D and F.

1 On Frame 55, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 55, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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4 On the top flange of Frame 55, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBFAE Sheet 02 thru Fig. A-GBFAE Sheet 04.

1 On Frame 55, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBFAE Sheet 02, View C.

1	Shear Web	E5347001025400	Item 12

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 55 to the shear web, Item 12.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAE Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBFAE Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBFAE Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAE Sheet 04.

5 Transfer drill the tack hole from the Frame 55 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 55 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 55, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025400	Item 12

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8 Clean and deburr the new fastener holes in Frame 55 and the shear web, Item 12, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBFAE Sheet 02, Views C, D and F.

a On Frame 55, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBFAE Sheet 02, View C.

1	Shear Web	E5347001025400	Item 12

b On Frame 55, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAE Sheet 02, View C.

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c On Frame 55, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAE Sheet 02, View C.

d On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAE Sheet 02, View D.

e On the top flange of Frame 55, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAE Sheet 02, View F.

10 On Frame 55, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025400	Item 12

11 Clean and deburr the cold expansion fastener holes in Frame 55 and the shear web, Item 12, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 55, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBFAE Sheet 02, View C.

1	Shear Web	E5347001025400	Item 12

with

3	Bolt	EN6115K3-3	Item 363

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5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
6	Rivet	EN6081D6-06	Item 666
17	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
10	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 55, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBFAE Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBFAE Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

15 On the Frame 55 flange, at STGR 35 LH, refer to Fig. A-GBFAE Sheet 03, Section A-A, countersink the one fastener hole.

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16 On the Frame 55 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBFAE Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 55 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAE Sheet 04.

19 On the Frame 55 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

20 Clean and deburr the new fastener holes in the Frame 55, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 55 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

22 On the Frame 55 flange, at STGR 36 LH, refer to Fig. A-GBFAE Sheet 03, Section B-B, countersink the one fastener hole.

23 On the Frame 55 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBFAE Sheet 03, Section B-B.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 55 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAE Sheet 04.

26 On the Frame 55 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

27 Clean and deburr the new fastener holes in the Frame 55, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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	Non Aqueous Cleaner - General	08BAA9	As required	

28 On the Frame 55 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

29 On the Frame 55 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

30 On the Frame 55 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBFAE Sheet 02, View C.

1	Angle	D5347046823800	Item (120)	Retained at removal
	with			

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-5X	Item 765
1	Pin	DAN5-6-5Y	Item 785
2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

31 On the Frame 55 flange, at STGR 39 LH, refer to Fig. A-GBFAE Sheet 03, Section D-D, countersink the one fastener hole.

32 On the Frame 55 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBFAE Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 55 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAE Sheet 04.

35 On the Frame 55 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

36 Clean and deburr the new fastener holes in the Frame 55, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

37 On the Frame 55 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBFAE Sheet 02, View C and Fig. A-GBFAE Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-08	Item 668
2	Rivet	EN6081D5-07	Item 657

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(9) Subtask 531364-831-209-013 - Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 56 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D07R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
14	E5347001024000	1	WEB	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	10	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	6	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	10	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	21	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	10	NUT	
863	DAN6-6-3	17	PIN	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)

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ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBGAE Replacement of Webs and Angles at Frame 56	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBGAE Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural

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parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 56, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 56, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 34 LH and STGR 36 LH, remove:

10	Rivet		Item (100)	Discard

3 From Frame 56, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 56, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078620400	Item (8)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046820600	Item (121)	Retain
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 56.

Refer to NTM 51-10-01.

Refer to Fig. A-GBGAE Sheet 02, Views C, D and F.

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1 On Frame 56, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 56, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 56, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBGAE Sheet 02 thru Fig. A-GBGAE Sheet 04.

1 On Frame 56, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBGAE Sheet 02, View C.

1	Shear Web	E5347001024000	Item 14

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 56 to the shear web, Item 14.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAE Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBGAE Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBGAE Sheet

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02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAE Sheet 04.

5 Transfer drill the tack hole from the Frame 56 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 56 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 56, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024000	Item 14

8 Clean and deburr the new fastener holes in Frame 56 and the shear web, Item 14, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBGAE Sheet 02, Views C, D and F.

a On Frame 56, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBGAE Sheet 02, View C.

1	Shear Web	E5347001024000	Item 14

b On Frame 56, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAE Sheet 02, View C.

c On Frame 56, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAE Sheet 02, View C.

d On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAE Sheet 02, View D.

e On the top flange of Frame 56, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAE Sheet 02, View F.

10 On Frame 56, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024000	Item 14

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11 Clean and deburr the cold expansion fastener holes in Frame 56 and the shear web, Item 14, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 56, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBGAE Sheet 02, View C.

1	Shear Web	E5347001024000	Item 14

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
10	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
6	Rivet	EN6081D6-06	Item 666
17	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
15	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
15	Pin	DAN6-6-3	Item 863

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 56, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBGAE Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363

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1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBGAE Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

15 On the Frame 56 flange, at STGR 35 LH, refer to Fig. A-GBGAE Sheet 03, Section A-A, countersink the one fastener hole.

16 On the Frame 56 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBGAE Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 56 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAE Sheet 04.

19 On the Frame 56 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

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20 Clean and deburr the new fastener holes in the Frame 56, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 56 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

22 On the Frame 56 flange, at STGR 36 LH, refer to Fig. A-GBGAE Sheet 03, Section B-B. countersink the one fastener hole.

23 On the Frame 56 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBGAE Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 56 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section B-B.

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1	Angle	E5347001120200	Item 2

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section B-B.

NOTE: For the hole diameter, refer to the tables on Fig. A-GBGAE Sheet 04.

26 On the Frame 56 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

27 Clean and deburr the new fastener holes in the Frame 56, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 56 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D6-07	Item 667

29 On the Frame 56 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

30 On the aft side of the Frame 56 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBGAE Sheet 02, View C.

1	Angle	D5347046820600	Item (121)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-09	Item 669	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

31 On the Frame 56 flange, at STGR 39 LH, refer to Fig. A-GBGAE Sheet 03, Section D-D, countersink the one fastener hole.

32 On the Frame 56 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBGAE Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 56 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section D-D.

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1	Angle	E5347001124200	Item 36

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame and the angle, Item 36, refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAE Sheet 04.

35 On the Frame 56 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

36 Clean and deburr the new fastener holes in the Frame 56, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

37 On the Frame 56 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBGAE Sheet 02, View C and Fig. A-GBGAE Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

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for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(10) Subtask 531364-831-210-013 - Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 57 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D07R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
18	E5347001025600	1	WEB	
20	E5347001123800	1	ANGLE	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	1	RIVET	
668	EN6081D6-08	17	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	19	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	10	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	11	PIN	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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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.

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBHAE Replacement of Webs and Angles at Frame 57	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBHAE Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 57, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347081820000	Item (12)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 57, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

8	Rivet		Item (100)	Discard

3 From Frame 57, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347081720000	Item (13)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 57, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347081620600	Item (14)	Discard
1	Support	D5347032200000	Item (101)	Retain

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1	Angle	D5347046820200	Item (118)	Retain
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 57.

Refer to NTM 51-10-01.

Refer to Fig. A-GBHAE Sheet 02, Views C, D and F.

1 On Frame 57, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 57, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 57, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

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(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBHAE Sheet 02 thru Fig. A-GBHAE Sheet 04.

1 On Frame 57, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBHAE Sheet 02, View C.

1	Shear Web	E5347001025600	Item 18

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 57 to the shear web, Item 18.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAE Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBHAE Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBHAE Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAE Sheet 04.

5 Transfer drill the tack hole from the Frame 57 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 57 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 57, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025600	Item 18

8 Clean and deburr the new fastener holes in Frame 57 and the shear web, Item 18, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

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Refer to Fig. A-GBHAE Sheet 02, Views C, D and F.

a On Frame 57, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBHAE Sheet 02, View C.

1	Shear Web	E5347001025600	Item 18

b On Frame 57, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAE Sheet 02, View C.

c On Frame 57, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAE Sheet 02, View C.

d On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAE Sheet 02, View D.

e On the top flange of Frame 57, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAE Sheet 02, View F.

10 On Frame 57, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025600	Item 18

11 Clean and deburr the cold expansion fastener holes in Frame 57 and the shear web, Item 18, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 57, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBHAE Sheet 02, View C.

1	Shear Web	E5347001025600	Item 18

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
13	Collar	NSA5075-6	Item 806

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6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863
1	Pin	DAN5-6-3	Item 963
2	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 57, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBHAE Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBHAE Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

15 On the Frame 57 flange, at STGR 35 LH, refer to Fig. A-GBHAE Sheet 03, Section A-A, countersink the one fastener hole.

16 On the Frame 57 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBHAE Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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17 On the Frame 57 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAE Sheet 04.

19 On the Frame 57 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

20 Clean and deburr the new fastener holes in the Frame 57, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 57 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

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22 On the Frame 57 flange, at STGR 36 LH, refer to Fig. A-GBHAE Sheet 03, Section B-B, countersink the one fastener hole.

23 On the Frame 57 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBHAE Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

24 On the Frame 57 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section B-B.

1	Angle	E5347001123800	Item 20

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 20, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the two holes from the Frame to the angle, Item 20, refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAE Sheet 04.

26 On the Frame 57 flange, at STGR 36 LH, remove:

1	Angle	E5347001123800	Item 20

27 Clean and deburr the new fastener holes in Frame 57, STGR 36 LH and angle, Item 20, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 57 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section B-B.

1	Angle	E5347001123800	Item 20

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
1	Rivet	EN6081D6-07	Item 667	
1	Collar	NSA5075-6	Item 806	
1	Pin	DAN5-6-4	Item 964	

29 On the Frame 57 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

30 On the Frame 57 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBHAE Sheet 02, View C.

1	Angle	D5347046820200	Item (118)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-5X	Item 765	
1	Pin	DAN5-6-5Y	Item 785	

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2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

31 On the Frame 57 flange, at STGR 39 LH, refer to Fig. A-GBHAE Sheet 03, Section D-D, countersink the one fastener hole.

32 On the Frame 57 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBHAE Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 57 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBHAE Sheet 04.

35 On the Frame 57 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

36 On the Frame 57 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBHAE Sheet 02, View C and Fig. A-GBHAE Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

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2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(11) Subtask 531364-831-211-013 - Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 58 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D07R06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
22	E5347001025800	1	WEB	
24	E5347001120600	1	ANGLE	
26	E5347001120800	1	ANGLE	
70	E5347001124400	1	ANGLE	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
363	EN6115K3-3	5	BOLT	
364	EN6115K3-4	3	BOLT	
374	EN6115K3A4	2	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	14	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	3	RIVET	
666	EN6081D6-06	2	RIVET	
667	EN6081D6-07	4	RIVET	
668	EN6081D6-08	4	RIVET	(1)
670	EN6081D7-10	4	RIVET	
678	EN6081D7-08	6	RIVET	
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	20	COLLAR	
807	DAN11-6X	10	COLLAR	
808	ASNA2528-3	9	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	9	PIN	
908	ASNA2528-3A	2	NUT	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	5	PIN	
965	DAN5-6-5	2	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

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Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

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NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBJAE Replacement of Webs and Angles at Frame 58	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBJAE Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 58, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347082420200	Item (15)	Discard
	with			
13	Rivet		Item (100)	Discard

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2 From the top flange of Frame 58, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 58, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347080520000	Item (16)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 58, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347083020600	Item (17)	Discard
1	Support	D5347032200600	Item (104)	Retain
1	Angle	D5347046820800	Item (125)	Retain
	with			
47	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 58.

Refer to NTM 51-10-01.

Refer to Fig. A-GBJAE Sheet 02, Views C, D and F.

1 On Frame 58, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 58, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 7 holes for the fasteners, Item 363, Item 364 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N. and STDN 6-1-

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N

3 On the top flange of Frame 58, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 58, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBJAE Sheet 02 thru Fig. A-GBJAE Sheet 04.

1 On Frame 58, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBJAE Sheet 02, View C.

1	Shear Web	E5347001025800	Item 22

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 58 to the shear web, Item 22.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAE Sheet 04.

4 Drill the additional 10 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBJAE Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBJAE Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAE Sheet 04.

5 Transfer drill the tack hole from the Frame 58 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 58 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

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7 On Frame 58, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025800	Item 22

8 Clean and deburr the new fastener holes in Frame 58 and the shear web, Item 22, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBJAE Sheet 02, Views C, D and F.

a On Frame 58, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBJAE Sheet 02, View C.

1	Shear Web	E5347001025800	Item 22

b On Frame 58, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAE Sheet 02, View C.

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c On Frame 58, between STGR 36 LH and STGR 37 LH, cold expand the 5 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAE Sheet 02, View C.

d On Frame 58, between STGR 36 LH and STGR 37 LH, cold expand the 2 holes for the fasteners, Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAE Sheet 02, View C.

e On the top flange of Frame 58, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAE Sheet 02, View D.

f On the top flange of Frame 58, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAE Sheet 02, View F.

10 On Frame 58, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025800	Item 22

11 Clean and deburr the cold expansion fastener holes in Frame 58 and the shear web, Item 22, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 58, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBJAE Sheet 02, View C.

1	Shear Web	E5347001025800	Item 22

with

4	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
2	Bolt	EN6115K3A4	Item 374
14	Rivet	EN6069D6-07	Item 567
7	Pin	DAN5-6-4X	Item 764
8	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-06	Item 666
4	Rivet	EN6081D6-08	Item 668
6	Rivet	EN6081D7-08	Item 678
13	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
7	Nut	ASNA2528-3	Item 808
8	Pin	DAN6-6-3	Item 863

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2	Nut	ASNA2528-3A	Item 908
5	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 58, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBJAE Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 58, at STGR 35 LH, install:

Refer to Fig. A-GBJAE Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

15 On the Frame 58 flange, at STGR 35 LH, refer to Fig. A-GBJAE Sheet 03, Section A-A, countersink the one fastener hole.

16 On the Frame 58 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBJAE Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 58 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBJAE Sheet 02, View C and Fig. A-GBJAE Sheet 03, Section A-A.

1	Angle	E5347001120600	Item 24

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18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 24, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 24, refer to Fig. A-GBJAE Sheet 02, View C and Fig. A-GBJAE Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAE Sheet 04.

19 On the Frame 58 flange, at STGR 35 LH, remove:

1	Angle	E5347001120600	Item 24

20 Clean and deburr the new fastener holes in the Frame 58, STGR 35 LH and angle, Item 24, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 58 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBJAE Sheet 02, View C and Fig. A-GBJAE Sheet 03, Section A-A.

1	Angle	E5347001120600	Item 24

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
1	Pin	DAN5-6-5X	Item 765
2	Collar	NSA5075-6	Item 806
1	Collar	DAN11-6X	Item 807
2	Pin	DAN5-6-5	Item 965

22 On the Frame 58 flange, at STGR 36 LH, refer to Fig. A-GBJAE Sheet 03, Section B-B, countersink the one fastener hole.

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23 On the Frame 58 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBJAE Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 58 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBJAE Sheet 02, View C and Fig. A-GBJAE Sheet 03, Section B-B.

1	Angle	E5347001120800	Item 26

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 26, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH to the angle, Item 26, refer to Fig. A-GBJAE Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAE Sheet 04.

26 Transfer drill and ream one new hole from the pilot hole of the angle, Item 26, to the Frame 58 flange, at STGR 36 LH, then transfer drill and ream the two holes from the Frame to the angle, Item 26, refer to Fig. A-GBJAE Sheet 02, View E.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAE Sheet 04.

27 On the Frame 58 flange, at STGR 36 LH, remove:

1	Angle	E5347001120800	Item 26

28 Clean and deburr the new fastener holes in the Frame 58, STGR 36 LH and angle, Item 26, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

29 On the Frame 58 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBJAE Sheet 02, View C and Fig. A-GBJAE Sheet 03, Section B-B.

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1	Angle	E5347001120800	Item 26	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
1	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	

30 On the Frame 58 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBJAE Sheet 02, View C and Fig. A-GBJAE Sheet 03, Section C-C.

1	Support	D5347032200600	Item (104)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Rivet	EN6081D7-10	Item 670	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

31 On the aft side of the Frame 58 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBJAE Sheet 02, View C.

1	Angle	D5347046820800	Item (125)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Pin	DAN5-6-5X	Item 765	

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1	Pin	DAN5-6-5Y	Item 785
2	Collar	DAN11-6X	Item 807
1	Collar	DAN11-6Y	Item 809

32 On the Frame 58 flange, at STGR 39 LH, refer to Fig. A-GBJAE Sheet 03, Section D-D, countersink the one fastener hole.

33 On the Frame 58 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBJAE Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

34 On the Frame 58 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBJAE Sheet 02, View C and Fig. A-GBJAE Sheet 03, Section D-D.

1	Angle	E5347001124400	Item 70

35 Transfer drill and ream one new hole from the pilot hole of the angle, Item 70, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 70, refer to Fig. A-GBJAE Sheet 02, View C and Fig. A-GBJAE Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBJAE Sheet 04.

36 On the Frame 58 flange, at STGR 39 LH, remove:

1	Angle	E5347001124400	Item 70

37 Clean and deburr the new fastener holes in the Frame 58, STGR 39 LH and angle, Item 70, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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38 On the Frame 58 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBJAE Sheet 02, View C and Fig. A-GBJAE Sheet 03, Section D-D.

1	Angle	E5347001124400	Item 70
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(12) Subtask 531364-831-212-014 - Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 59 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D07R06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
28	E5347001026000	1	WEB	
30	E5347001121000	1	ANGLE	
32	E5347001121200	1	ANGLE	
72	E5347001124600	1	ANGLE	
363	EN6115K3-3	5	BOLT	
364	EN6115K3-4	2	BOLT	
365	EN6115K3-5	3	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	20	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	20	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	7	RIVET	(1)
669	EN6081D6-09	3	RIVET	(2)
764	DAN5-6-4X	3	PIN	
765	DAN5-6-5X	3	PIN	
785	DAN5-6-5Y	1	PIN	
806	NSA5075-6	21	COLLAR	
807	DAN11-6X	6	COLLAR	
808	ASNA2528-3	11	NUT	
809	DAN11-6Y	1	COLLAR	
863	DAN6-6-3	8	PIN	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	6	PIN	
965	DAN5-6-5	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBKAE Replacement of Webs and Angles at Frame 59	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBKAE Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 59, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347089120000	Item (18)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 59, at STGR 35 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

5	Rivet		Item (100)	Discard

3 From Frame 59, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347089020000	Item (19)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 59, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347088920800	Item (20)	Discard
1	Support	D5347032201000	Item (106)	Retain
1	Angle	D5347046821000	Item (127)	Retain
	with			
59	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 59.

Refer to NTM 51-10-01.

Refer to Fig. A-GBKAE Sheet 02, Views C and D.

1 On Frame 59, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 59, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 7 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 59, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBKAE Sheet 02 thru Fig. A-GBKAE Sheet 04.

1 On Frame 59, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBKAE Sheet 02, View C.

1	Shear Web	E5347001026000	Item 28

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 59 to the shear web, Item 28.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAE Sheet 04.

4 Drill the additional 17 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBKAE Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBKAE Sheet

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02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAE Sheet 04.

5 Transfer drill the tack hole from the Frame 59 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 59 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 59, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001026000	Item 28

8 Clean and deburr the new fastener holes in Frame 59 and the shear web, Item 28, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBKAE Sheet 02, Views C and D.

a On Frame 59, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBKAE Sheet 02, View C.

1	Shear Web	E5347001026000	Item 28

b On Frame 59, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAE Sheet 02, View C.

c On Frame 59, between STGR 36 LH and STGR 37 LH, cold expand the 7 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAE Sheet 02, View C.

d On the top flange of Frame 59, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAE Sheet 02, View D.

10 On Frame 59, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001026000	Item 28

11 Clean and deburr the cold expansion fastener holes in Frame 59 and the shear web, Item 28, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 59, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBKAE Sheet 02, View C.

1	Shear Web	E5347001026000	Item 28

with

4	Bolt	EN6115K3-3	Item 363
2	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
16	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D6-06	Item 666
5	Rivet	EN6081D6-08	Item 668

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3	Pin	DAN5-6-4X	Item 764
14	Collar	NSA5075-6	Item 806
3	Collar	DAN11-6X	Item 807
6	Nut	ASNA2528-3	Item 808
8	Pin	DAN6-6-3	Item 863
6	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 59, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBKAE Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 59, at STGR 35 LH, install:

Refer to Fig. A-GBKAE Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

15 On the Frame 59 flange, at STGR 35 LH, refer to Fig. A-GBKAE Sheet 03, Section A-A, countersink the one fastener hole.

16 On the Frame 59 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBKAE Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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17 On the Frame 59 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section A-A.

1	Angle	E5347001121000	Item 30

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 30, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 30, refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAE Sheet 04.

19 On the Frame 59 flange, at STGR 35 LH, remove:

1	Angle	E5347001121000	Item 30

20 Clean and deburr the new fastener holes in the Frame 59, STGR 35 LH and angle, Item 30, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 59 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section A-A.

1	Angle	E5347001121000	Item 30

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Collar	NSA5075-6	Item 806
3	Pin	DAN5-6-5	Item 965

22 On the Frame 59 flange, at STGR 36 LH, refer to Fig. A-GBKAE Sheet 03, Section B-B, countersink the one fastener hole.

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23 On the Frame 59 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBKAE Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 59 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section B-B.

1	Angle	E5347001121200	Item 32

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 32, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 32, refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAE Sheet 04.

26 On the Frame 59 flange, at STGR 36 LH, remove:

1	Angle	E5347001121200	Item 32

27 Clean and deburr the new fastener holes in the Frame 59, STGR 36 LH and angle, Item 32, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 59 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section B-B.

1	Angle	E5347001121200	Item 32

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D6-07	Item 667	

29 On the Frame 59 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section C-C.

1	Support	D5347032201000	Item (106)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

3	Bolt	EN6115K3-5	Item 365	
3	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
3	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	

30 On the Frame 59 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBKAE Sheet 02, View C.

1	Angle	D5347046821000	Item (127)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-5X	Item 765	
1	Pin	DAN5-6-5Y	Item 785	
2	Collar	DAN11-6X	Item 807	
1	Collar	DAN11-6Y	Item 809	

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31 On the Frame 59 flange, at STGR 39 LH, refer to Fig. A-GBKAE Sheet 03, Section D-D, countersink the one fastener hole.

32 On the Frame 59 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBKAE Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 59 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section D-D.

1	Angle	E5347001124600	Item 72

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 72, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 72, refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBKAE Sheet 04.

35 On the Frame 59 flange, at STGR 39 LH, remove:

1	Angle	E5347001124600	Item 72

36 Clean and deburr the new fastener holes in the Frame 59, STGR 39 LH and angle, Item 72, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

37 On the Frame 59 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBKAE Sheet 02, View C and Fig. A-GBKAE Sheet 03, Section D-D.

1	Angle	E5347001124600	Item 72

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(13) Subtask 531364-831-213-013 - Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 60 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D07R06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
34	E5347001024200	1	WEB	
38	E5347001121600	1	ANGLE	
40	E5347001121800	1	ANGLE	
86	E5347001125600	1	ANGLE	
363	EN6115K3-3	5	BOLT	
365	EN6115K3-5	8	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	3	RIVET	
567	EN6069D6-07	20	RIVET	
656	EN6081D5-06	43	RIVET	
666	EN6081D6-06	25	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	4	RIVET	(2)
764	DAN5-6-4X	4	PIN	
765	DAN5-6-5X	1	PIN	
806	NSA5075-6	5	COLLAR	
807	DAN11-6X	6	COLLAR	
808	ASNA2528-3	14	NUT	
963	DAN5-6-3	5	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	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	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

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NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBLAE Replacement of Webs and Angles at Frame 60	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBLAE Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

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1 From Frame 60, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347085020000	Item (21)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 60, at STGR 35 LH and from the frame flange between STGR 34 LH and STGR 35 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 60, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347085120000	Item (22)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 60, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347093121000	Item (23)	Discard
1	Support	D5347032201200	Item (108)	Retain
1	Angle	D5347046821200	Item (128)	Retain
	with			
65	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 60.

Refer to NTM 51-10-01.

Refer to Fig. A-GBLAE Sheet 02, Views C and D.

1 On Frame 60, at STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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2 On Frame 60, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 60, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBLAE Sheet 02 thru Fig. A-GBLAE Sheet 04.

1 On Frame 60, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBLAE Sheet 02, View C.

1	Shear Web	E5347001024200	Item 34

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 60 to the shear web, Item 34.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAE Sheet 04.

4 Drill the additional 38 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBLAE Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBLAE Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAE Sheet 04.

5 Transfer drill the tack hole from the Frame 60 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 60 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

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7 On Frame 60, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024200	Item 34

8 Clean and deburr the new fastener holes in Frame 60 and the shear web, Item 34, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBLAE Sheet 02, Views C and D.

a On Frame 60, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBLAE Sheet 02, View C.

1	Shear Web	E5347001024200	Item 34

b On Frame 60, at STGR 35 LH, cold expand the 4 holes for the fasteners, Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAE Sheet 02, View C.

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c On Frame 60, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAE Sheet 02, View C.

d On the top flange of Frame 60, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAE Sheet 02, View D.

10 On Frame 60, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024200	Item 34

11 Clean and deburr the cold expansion fastener holes in Frame 60 and the shear web, Item 34, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 60, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBLAE Sheet 02, View C.

1	Shear Web	E5347001024200	Item 34

with

5	Bolt	EN6115K3-3	Item 363
20	Rivet	EN6069D6-07	Item 567
37	Rivet	EN6081D5-06	Item 656
23	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
3	Pin	DAN5-6-4X	Item 764
4	Collar	DAN11-6X	Item 807
5	Nut	ASNA2528-3	Item 808

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 On the top flange of Frame 60, at STGR 35 LH, install:

Refer to Fig. A-GBLAE Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463

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1	Nut	ASNA2528-3	Item 808

14 On the Frame 60 flange, at STGR 35 LH, refer to Fig. A-GBLAE Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 60 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBLAE Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 60 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBLAE Sheet 02, View C and Fig. A-GBLAE Sheet 03, Section A-A.

1	Angle	E5347001121600	Item 38

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 38, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH to the angle, Item 38, refer to Fig. A-GBLAE Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAE Sheet 04.

18 On the Frame 60 flange, at STGR 35 LH, remove:

1	Angle	E5347001121600	Item 38

19 Clean and deburr the new fastener holes in the STGR 35 LH and angle, Item 38, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 60 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBLAE Sheet 02, View C and Fig. A-GBLAE Sheet 03, Section A-A.

1	Angle	E5347001121600	Item 38

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
2	Rivet	EN6081D5-06	Item 656
4	Nut	ASNA2528-3	Item 808

21 On the Frame 60 flange, at STGR 36 LH, refer to Fig. A-GBLAE Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 60 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBLAE Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 60 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBLAE Sheet 02, View C and Fig. A-GBLAE Sheet 03, Section B-B.

1	Angle	E5347001121800	Item 40

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 40, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 40, refer to Fig. A-GBLAE Sheet 02, View C and Fig. A-GBLAE Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAE Sheet 04.

25 On the Frame 60 flange, at STGR 36 LH, remove:

1	Angle	E5347001121800	Item 40

26 Clean and deburr the new fastener holes in the Frame 60, STGR 36 LH and angle, Item 40, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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	Non Aqueous Cleaner - General	08BAA9	As required		

27 On the Frame 60 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBLAE Sheet 02, View C and Fig. A-GBLAE Sheet 03, Section B-B.

1	Angle	E5347001121800	Item 40		
	with				
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required		
	and				
2	Rivet	EN6081D5-06	Item 656		
3	Rivet	EN6081D6-07	Item 667		

28 On the Frame 60 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBLAE Sheet 02, View C and Fig. A-GBLAE Sheet 03, Section C-C.

1	Support	D5347032201200	Item (108)	Retained at removal	
	with				
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required		
	and				
4	Bolt	EN6115K3-5	Item 365		
4	Rivet	EN6081D6-09	Item 669		
5	Collar	NSA5075-6	Item 806		
4	Nut	ASNA2528-3	Item 808		
5	Pin	DAN5-6-3	Item 963		

29 On the aft side of the Frame 60 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBLAE Sheet 02, View C.

1	Angle	D5347046821200	Item (128)	Retained at removal	

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

3	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

30 On the Frame 60 flange, at STGR 39 LH, refer to Fig. A-GBLAE Sheet 03, Section D-D, countersink the one fastener hole.

31 On the Frame 60 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBLAE Sheet 03, Section D-D.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

32 On the Frame 60 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBLAE Sheet 02, View C and Fig. A-GBLAE Sheet 03, Section D-D.

1	Angle	E5347001125600	Item 86

33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 86, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 86, refer to Fig. A-GBLAE Sheet 02, View C and Fig. A-GBLAE Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAE Sheet 04.

34 On the Frame 60 flange, at STGR 39 LH, remove:

1	Angle	E5347001125600	Item 86

35 Clean and deburr the new fastener holes in the Frame 60, STGR 39 LH and angle, Item 86, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

36 On the Frame 60 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBLAE Sheet 02, View C and Fig. A-GBLAE Sheet 03, Section D-D.

1	Angle	E5347001125600	Item 86

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-06	Item 666
1	Pin	DAN5-6-4X	Item 764
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

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(14) Subtask 531364-831-214-013 - Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 61 from Stringer 33 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D07R06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
42	E5347001022000	1	WEB	
44	E5347001122000	1	ANGLE	
46	E5347001122200	1	ANGLE	
48	E5347001122400	1	ANGLE	
74	E5347001124800	1	ANGLE	
363	EN6115K3-3	6	BOLT	
364	EN6115K3-4	3	BOLT	
365	EN6115K3-5	4	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	4	RIVET	
567	EN6069D6-07	24	RIVET	
656	EN6081D5-06	36	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	23	RIVET	
667	EN6081D6-07	10	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	6	RIVET	(2)
763	DAN5-6-3X	4	PIN	
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
807	DAN11-6X	13	COLLAR	
808	ASNA2528-3	14	NUT	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBMAE Replacement of Webs and Angles at Frame 61	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBMAE Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 61, between STGR 33 LH and STGR 34 LH, remove:

1	Clip	D5347091620200	Item (24)	Discard
	with			
12	Rivet		Item (100)	Discard
	or			
13	Rivet		Item (100)	Discard

NOTE: Depending on installation on aircraft.

2 From Frame 61, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347090620000	Item (25)	Discard
	with			
13	Rivet		Item (100)	Discard

3 From the top flange of Frame 61, between STGR 34 LH and STGR 35 LH and from the frame flange between STGR 34 LH and STGR 35 LH, remove:

11	Rivet		Item (100)	Discard

4 From Frame 61, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347090720000	Item (26)	Discard
	with			
13	Rivet		Item (100)	Discard

5 From Frame 61, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347090821000	Item (27)	Discard
1	Support	D5347032201600	Item (109)	Retain
1	Angle	D5347046821400	Item (130)	Retain
	with			

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65	Rivet	Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 61.

Refer to NTM 51-10-01.

Refer to Fig. A-GBMAE Sheet 02, Views C and E.

1 On Frame 61, at STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 61, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 61, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBMAE Sheet 02 thru Fig. A-GBMAE Sheet 04.

1 On Frame 61, between STGR 33 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBMAE Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

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3 Transfer drill the fastener holes from the Frame 61 to the shear web, Item 42.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAE Sheet 04.

4 Drill the additional 31 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBMAE Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBMAE Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAE Sheet 04.

5 Transfer drill the tack hole from the Frame 61 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 61 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 61, between STGR 33 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022000	Item 42

8 Clean and deburr the new fastener holes in Frame 61 and the shear web, Item 42, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBMAE Sheet 02, Views C and E.

a On Frame 61, between STGR 33 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBMAE Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

b On Frame 61, at STGR 35 LH, cold expand the 4 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

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FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAE Sheet 02, View E.

c On Frame 61, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAE Sheet 02, View C.

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d On the top flange of Frame 61, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAE Sheet 02, View E.

10 On Frame 61, between STGR 33 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022000	Item 42

11 Clean and deburr the cold expansion fastener holes in Frame 61 and the shear web, Item 42, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 61, between STGR 33 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBMAE Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

with

5	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364

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24	Rivet	EN6069D6-07	Item 567
28	Rivet	EN6081D5-06	Item 656
22	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 On Frame 61, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBMAE Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 61, at STGR 35 LH, install:

Refer to Fig. A-GBMAE Sheet 02, View E.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

15 On the Frame 61 flange, at STGR 34 LH, refer to Fig. A-GBMAE Sheet 03, Section A-A, countersink the one fastener hole.

16 On the Frame 61 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBMAE Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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17 On the Frame 61 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section A-A.

1	Angle	E5347001122000	Item 44

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 44, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH and the three holes from the Frame to the angle, Item 44, refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAE Sheet 04.

19 On the Frame 61 flange, at STGR 34 LH, remove:

1	Angle	E5347001122000	Item 44

20 Clean and deburr the new fastener holes in the Frame 61, STGR 34 LH and angle, Item 44, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 61 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section A-A.

1	Angle	E5347001122000	Item 44

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

If necessary, close the rivet hole in the frame flange at STGR 34 LH with:

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1	Rivet	EN6081D6-06	Item 666

NOTE: Depending on installation on aircraft.

22 On the Frame 61 flange, at STGR 35 LH, refer to Fig. A-GBMAE Sheet 03, Section B-B, countersink the one fastener hole.

23 On the Frame 61 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBMAE Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 61 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section B-B.

1	Angle	E5347001122200	Item 46

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 46, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the four holes from the Frame to the angle, Item 46, refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAE Sheet 04.

26 On the Frame 61 flange, at STGR 35 LH, remove:

1	Angle	E5347001122200	Item 46

27 Clean and deburr the new fastener holes in the Frame 61, STGR 35 LH and angle, Item 46, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 61 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section B-B.

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1	Angle	E5347001122200	Item 46
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-06	Item 656
4	Rivet	EN6081D6-07	Item 667

29 On the Frame 61 flange, at STGR 36 LH, refer to Fig. A-GBMAE Sheet 03, Section C-C, countersink the one fastener hole.

30 On the Frame 61 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section C-C.

1	Rivet	EN6069D5-05	Item 555
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

31 On the Frame 61 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section C-C.

1	Angle	E5347001122400	Item 48

32 Transfer drill and ream one new hole from the pilot hole of the angle, Item 48, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 48, refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAE Sheet 04.

33 On the Frame 61 flange, at STGR 36 LH, remove:

1	Angle	E5347001122400	Item 48

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34 Clean and deburr the new fastener holes in the Frame 61, STGR 36 LH and angle, Item 48, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

35 On the Frame 61 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section C-C.

1	Angle	E5347001122400	Item 48

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D5-07	Item 657
3	Rivet	EN6081D6-07	Item 667

36 On the Frame 61 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section D-D.

1	Support	D5347032201600	Item (109)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
4	Rivet	EN6081D6-09	Item 669
4	Pin	DAN5-6-3X	Item 763
4	Collar	DAN11-6X	Item 807

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4	Nut	ASNA2528-3	Item 808	

37 On the Frame 61 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBMAE Sheet 02, View C.

1	Angle	D5347046821400	Item (130)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

3	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

38 On the Frame 61 flange, at STGR 39 LH, refer to Fig. A-GBMAE Sheet 03, Section E-E, countersink the one fastener hole.

39 On the Frame 61 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBMAE Sheet 03, Section E-E.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

40 On the Frame 61 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section E-E.

1	Angle	E5347001124800	Item 74

41 Transfer drill and ream one new hole from the pilot hole of the angle, Item 74, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the four holes from the Frame to the angle, Item 74, refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section E-E.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAE Sheet 04.

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42 On the Frame 61 flange, at STGR 39 LH, remove:

1	Angle	E5347001124800	Item 74

43 Clean and deburr the new fastener holes in the Frame 61, STGR 39 LH and angle, Item 74, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

44 On the Frame 61 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBMAE Sheet 02, View C and Fig. A-GBMAE Sheet 03, Section E-E.

1	Angle	E5347001124800	Item 74

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

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Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(15) Subtask 531364-831-215-013 - Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 62 from Stringer 32 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D07R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
50	E5347001022200	1	WEB	
52	E5347001122600	1	ANGLE	
54	E5347001122800	1	ANGLE	
56	E5347001123000	1	ANGLE	
58	E5347001123200	1	ANGLE	
76	E5347001125000	1	ANGLE	
363	EN6115K3-3	6	BOLT	
364	EN6115K3-4	3	BOLT	
365	EN6115K3-5	4	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	5	RIVET	
567	EN6069D6-07	28	RIVET	
568	EN6069D6-08	1	RIVET	
656	EN6081D5-06	45	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	20	RIVET	
667	EN6081D6-07	7	RIVET	
668	EN6081D6-08	16	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	5	PIN	
765	DAN5-6-5X	3	PIN	
806	NSA5075-6	9	COLLAR	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	13	NUT	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	
965	DAN5-6-5	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

Kit 531364D09R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
808	ASNA2528-3	1	NUT	

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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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.

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBNAE Replacement of Webs and Angles at Frame 62	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBNAE Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 62, between STGR 32 LH and STGR 33 LH, remove:

1	Clip	D5347093420200	Item (28)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From Frame 62, between STGR 33 LH and STGR 34 LH, remove:

1	Clip	D5347084020000	Item (29)	Discard
	with			
13	Rivet		Item (100)	Discard

3 From Frame 62, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347084120000	Item (30)	Discard
	with			
11	Rivet		Item (100)	Discard

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4 From the top flange of Frame 62, at STGR 34 LH and from the frame flange between STGR 32 LH and STGR 35 LH, remove:

13	Rivet		Item (100)	Discard

5 From Frame 62, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347084220000	Item (31)	Discard
	with			
11	Rivet		Item (100)	Discard

6 From Frame 62, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347084820800	Item (32)	Discard
1	Support	D5347032201800	Item (111)	Retain
1	Angle	D5347046821600	Item (131)	Retain
	with			
58	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 62.

Refer to NTM 51-10-01.

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 03, View F.

1 On Frame 62, between STGR 34 LH and STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 62, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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3 On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBNAE Sheet 02 thru Fig. A-GBNAE Sheet 06.

1 On Frame 62, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBNAE Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 62 to the shear web, Item 50.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAE Sheet 06.

4 On Frame 62, between STGR 34 LH and STGR 37 LH, drill the additional 42 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBNAE Sheet 03, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBNAE Sheet 03.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAE Sheet 06.

5 On Frame 62, between STGR 38 LH and STGR 39 LH, drill the additional rivet hole to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBNAE Sheet 03, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBNAE Sheet 03.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAE Sheet 06.

6 Transfer drill the tack hole from the Frame 62 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

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7 Transfer drill the tack hole from the Frame 62 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

8 On Frame 62, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022200	Item 50

9 Clean and deburr the new fastener holes in Frame 62 and the shear web, Item 50, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

10 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBNAE Sheet 02, Views C and D.

a On Frame 62, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBNAE Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

b On Frame 62, between STGR 34 LH and STGR 35 LH, cold expand the 4 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAE Sheet 02, View C.

c On Frame 62, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAE Sheet 02, View C.

d On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAE Sheet 03, View F.

11 On Frame 62, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022200	Item 50

12 Clean and deburr the cold expansion fastener holes in Frame 62 and the shear web, Item 50, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

13 At Frame 62, between STGR 32 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBNAE Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

with

5	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
28	Rivet	EN6069D6-07	Item 567
1	Rivet	EN6069D6-08	Item 568
35	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D6-06	Item 666
13	Rivet	EN6081D6-08	Item 668
5	Pin	DAN5-6-4X	Item 764
4	Collar	NSA5075-6	Item 806
5	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808

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1	Pin	DAN5-6-3	Item 963
3	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

14 On Frame 62, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBNAE Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

15 On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBNAE Sheet 03, View F.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

16 On the Frame 62 flange, at STGR 33 LH, refer to Fig. A-GBNAE Sheet 04, Section A-A, countersink the one fastener hole.

17 On the Frame 62 flange, at STGR 33 LH, close the rivet hole in STGR 33 LH with:

Refer to Fig. A-GBNAE Sheet 04, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

18 On the Frame 62 flange, at STGR 33 LH, put in position:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section A-A.

1	Angle	E5347001122600	Item 52

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19 Transfer drill and ream one new hole from the pilot hole of the angle, Item 52, to the STGR 33 LH, then transfer drill and ream the other hole from STGR 33 LH and the three holes from the Frame to the angle, Item 52, refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAE Sheet 06.

20 On the Frame 62 flange, at STGR 33 LH, remove:

1	Angle	E5347001122600	Item 52

21 Clean and deburr the new fastener holes in the Frame 62, STGR 33 LH and angle, Item 52, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

22 On the Frame 62 flange, at STGR 33 LH, wet install:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section A-A.

1	Angle	E5347001122600	Item 52

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Collar	NSA5075-6	Item 806
1	Pin	DAN5-6-5	Item 965

23 On the Frame 62 flange, at STGR 34 LH, refer to Fig. A-GBNAE Sheet 04, Section B-B, countersink the one fastener hole.

24 On the Frame 62 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBNAE Sheet 04, Section B-B.

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1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

25 On the Frame 62 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section B-B.

1	Angle	E5347001122800	Item 54

26 Transfer drill and ream one new hole from the pilot hole of the angle, Item 54, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH and the three holes from the Frame to the angle, Item 54, refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAE Sheet 06.

27 On the Frame 62 flange, at STGR 34 LH, remove:

1	Angle	E5347001122800	Item 54

28 Clean and deburr the new fastener holes in the Frame 62, STGR 34 LH and angle, Item 54, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

29 On the Frame 62 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section B-B.

1	Angle	E5347001122800	Item 54

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656

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2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

30 On the Frame 62 flange, at STGR 34 LH, install:

Refer to Fig. A-GBNAE Sheet 02, View C.

1	Rivet	EN6081D6-07	Item 667

31 On the Frame 62 flange, at STGR 35 LH, refer to Fig. A-GBNAE Sheet 04, Section C-C, countersink the one fastener hole.

32 On the Frame 62 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBNAE Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 62 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section C-C.

1	Angle	E5347001123000	Item 56

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 56, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the five holes from the Frame to the angle, Item 56, refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAE Sheet 06.

35 On the Frame 62 flange, at STGR 35 LH, remove:

1	Angle	E5347001123000	Item 56

36 Clean and deburr the new fastener holes in the Frame 62, STGR 35 LH and angle, Item 56, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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	Non Aqueous Cleaner - General	08BAA9	As required

37 On the Frame 62 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section C-C.

1	Angle	E5347001123000	Item 56
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

38 On the Frame 62 flange, at STGR 36 LH, refer to Fig. A-GBNAE Sheet 04, Section D-D, countersink the one fastener hole.

39 On the Frame 62 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBNAE Sheet 04, Section D-D.

1	Rivet	EN6069D5-05	Item 555
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

40 On the Frame 62 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section D-D.

1	Angle	E5347001123200	Item 58

41 Transfer drill and ream one new hole from the pilot hole of the angle, Item 58, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 58, refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAE Sheet 06.

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42 On the Frame 62 flange, at STGR 36 LH, remove:

1	Angle	E5347001123200	Item 58	

43 Clean and deburr the new fastener holes in the Frame 62, STGR 36 LH and angle, Item 58, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

44 On the Frame 62 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 04, Section D-D.

1	Angle	E5347001123200	Item 58

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

45 On the Frame 62 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 05, Section E-E.

1	Support	D5347032201800	Item (111)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
4	Rivet	EN6081D6-09	Item 669

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4	Collar	NSA5075-6	Item 806	
4	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	

46 On the aft side of the Frame 62 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBNAE Sheet 02, View C.

1	Angle	D5347046821600	Item (131)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

3	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

47 On the Frame 62 flange, at STGR 39 LH, refer to Fig. A-GBNAE Sheet 05, Section F-F, countersink the one fastener hole.

48 On the Frame 62 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBNAE Sheet 05, Section F-F.

1	Rivet	EN6069D5-05	Item 555	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

49 On the Frame 62 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 05, Section F-F.

1	Angle	E5347001125000	Item 76	

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50 Transfer drill and ream one new hole from the pilot hole of the angle, Item 76, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 76, refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 05, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBNAE Sheet 04.

51 On the Frame 62 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBNAE Sheet 02, View C and Fig. A-GBNAE Sheet 05, Section F-F.

1	Angle	E5347001125000	Item 76
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

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(16) Subtask 531364-831-216-013 - Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 63 from Stringer 32 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D07R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
60	E5347001022400	1	WEB	
62	E5347001123400	1	ANGLE	
64	E5347001123600	2	ANGLE	
78	E5347001125200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
365	EN6115K3-5	8	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	4	RIVET	
567	EN6069D6-07	23	RIVET	
568	EN6069D6-08	1	RIVET	
656	EN6081D5-06	43	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	22	RIVET	
667	EN6081D6-07	6	RIVET	
668	EN6081D6-08	12	RIVET	(1)
669	EN6081D6-09	7	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	8	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	13	NUT	
963	DAN5-6-3	8	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBPAE Replacement of Webs and Angles at Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBPAE Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 63, at STGR 33 LH, remove:

1	Shim	D5347032020200	Item (132)	Retain
1	Sheet-Support	D5347109620000	Item (133)	Retain
	with			
7	Rivet		Item (100)	Discard

2 From Frame 63, between STGR 32 LH and STGR 34 LH, remove:

1	Clip	D5347082820000	Item (33)	Discard
	with			
21	Rivet		Item (100)	Discard

3 From the top flange of Frame 63, at STGR 34 LH and from the frame flange between STGR 33 LH and STGR 34 LH, remove:

5	Rivet		Item (100)	Discard

4 From Frame 63, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347079220000	Item (34)	Discard
	with			
10	Rivet		Item (100)	Discard

5 From Frame 63, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347079920000	Item (35)	Discard
	with			
11	Rivet		Item (100)	Discard

6 From Frame 63, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347082920600	Item (36)	Discard
1	Support	D5347032202000	Item (114)	Retain

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1	Angle	D5347046821800	Item (115)	Retain
	with			
54	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 63.

Refer to NTM 51-10-01.

Refer to Fig. A-GBPAE Sheet 02, Views C and D.

1 On Frame 63, at STGR 34 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 63, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 8 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 63, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBPAE Sheet 02 thru Fig. A-GBPAE Sheet 06.

1 On Frame 63, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBPAE Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

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2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 63 to the shear web, Item 60.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAE Sheet 06.

4 On Frame 63, between STGR 34 LH and STGR 37 LH, drill the additional 41 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBPAE Sheet 03, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBPAE Sheet 03.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAE Sheet 06.

5 Transfer drill the tack hole from the Frame 63 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 63 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

7 On Frame 63, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022400	Item 60

8 Clean and deburr the new fastener holes in Frame 63and the shear web, Item 60, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBPAE Sheet 02, Views C and D.

a On Frame 63, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBPAE Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

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b On Frame 63, at STGR 34 LH, cold expand the 4 holes for the fasteners, Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAE Sheet 02, View C.

c On Frame 63, between STGR 36 LH and STGR 37 LH, cold expand the 8 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAE Sheet 02, View C.

d On the top flange of Frame 63, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAE Sheet 02, View D.

10 On Frame 63, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022400	Item 60

11 Clean and deburr the cold expansion fastener holes in Frame 63and the shear web, Item 60, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 63, between STGR 32 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBPAE Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

with

4	Bolt	EN6115K3-3	Item 363

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23	Rivet	EN6069D6-07	Item 567	
1	Rivet	EN6069D6-08	Item 568	
35	Rivet	EN6081D5-06	Item 656	
22	Rivet	EN6081D6-06	Item 666	
10	Rivet	EN6081D6-08	Item 668	
6	Pin	DAN5-6-4X	Item 764	
6	Collar	DAN11-6X	Item 807	
4	Nut	ASNA2528-3	Item 808	

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 On the Frame 63 flange, at STGR 33 LH, wet install:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 04, Section A-A.

1	Shim	D5347032020200	Item (132)	Retained at removal
1	Sheet-Support	D5347109620000	Item (133)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

3	Rivet	EN6081D6-09	Item 669
4	Collar	NSA5075-6	Item 806
4	Pin	DAN5-6-3	Item 963

14 On the Frame 63 flange, at STGR 34 LH, refer to Fig. A-GBPAE Sheet 04, Section B-B, countersink the one fastener hole.

15 On the Frame 63 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBPAE Sheet 04, Section B-B.

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1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 63 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 04, Section B-B.

1	Angle	E5347001123400	Item 62

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 62, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH to the angle, Item 62, refer to Fig. A-GBPAE Sheet 04, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAE Sheet 06.

18 On the Frame 63 flange, at STGR 34 LH, remove:

1	Angle	E5347001123400	Item 62

19 Clean and deburr the new fastener holes in the STGR 34 LH and angle, Item 62, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 63 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 04, Section B-B.

1	Angle	E5347001123400	Item 62

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
2	Rivet	EN6081D5-06	Item 656

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4	Nut	ASNA2528-3	Item 808

21 On the top flange of Frame 63, at STGR 35 LH, install:

Refer to Fig. A-GBPAE Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

22 On the Frame 63 flange, at STGR 35 LH, refer to Fig. A-GBPAE Sheet 04, Section C-C, countersink the one fastener hole.

23 On the Frame 63 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBPAE Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 63 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 64, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the five holes from the Frame to the angle, Item 64, refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAE Sheet 06.

26 On the Frame 63 flange, at STGR 35 LH, remove:

1	Angle	E5347001123600	Item 64

27 Clean and deburr the new fastener holes in the Frame 63, STGR 35 LH and angle, Item 64, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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	Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 63 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

29 On the Frame 63 flange, at STGR 36 LH, refer to Fig. A-GBPAE Sheet 04, Section C-C, countersink the one fastener hole.

30 On the Frame 63 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBPAE Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

31 On the Frame 63 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

32 Transfer drill and ream one new hole from the pilot hole of the angle, Item 64, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 64, refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAE Sheet 06.

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33 On the Frame 63 flange, at STGR 36 LH, remove:

1	Angle	E5347001123600	Item 64	

34 Clean and deburr the new fastener holes in the Frame 63, STGR 36 LH and angle, Item 64, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

35 On the Frame 63 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

36 On the Frame 63 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 05, Section D-D.

1	Support	D5347032202000	Item (114)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
4	Rivet	EN6081D6-09	Item 669

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4	Collar	NSA5075-6	Item 806	
4	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	

37 On the Frame 63 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBPAE Sheet 02, View C.

1	Angle	D5347046821800	Item (115)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

38 On the Frame 63 flange, at STGR 39 LH, refer to Fig. A-GBPAE Sheet 05, Section E-E, countersink the one fastener hole.

39 On the Frame 63 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBPAE Sheet 05, Section E-E.

1	Rivet	EN6069D5-05	Item 555	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

40 On the Frame 63 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 05, Section E-E.

1	Angle	E5347001125200	Item 78	

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41 Transfer drill and ream one new hole from the pilot hole of the angle, Item 78, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 78, refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 05, Section E-E.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAE Sheet 06.

42 On the Frame 63 flange, at STGR 39 LH, remove:

1	Angle	E5347001125200	Item 78

43 Clean and deburr the new fastener holes in the Frame 63, STGR 39 LH and angle, Item 78, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

44 On the Frame 63 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBPAE Sheet 02, View C and Fig. A-GBPAE Sheet 05, Section E-E.

1	Angle	E5347001125200	Item 78

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(17) Subtask 531364-831-217-013 - Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 Stringer 38 LH
To	160	Work location	from Frame 60 to Frame 63 Stringer 38 LH

Manpower Resources	
Manhours	6.50
Minimum number of person	2
Subtask elapsed time	6.50
Skills	AIRFRAME

Material necessary to do the job

Kit 531364D07R06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
544	EN6069D4-04	4	RIVET	
545	EN6069D4-05	52	RIVET	
655	EN6081D5-05	15	RIVET	
656	EN6081D5-06	189	RIVET	
657	EN6081D5-07	59	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	04JME4	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	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12 53-41-14
Fig. A-GBQAG Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Install the shear plates.

Refer to Fig. A-GBQAG Sheet 01 thru Fig. A-GBQAG Sheet 06.

1 Between Frame 49 and Frame 50, from STGR 38 LH and from the bracket at Frame 49 and bracket, Item 66, put in position:

Refer to Fig. A-GBQAG Sheet 02, View D.

1	Plate-Shear	D5347471500000	Item (139)	Retained at removal

2 Transfer drill and ream the three holes from the shear plate, Item (139), to the bracket, Item 66, refer to Fig. A-GBQAG Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAG Sheet 06.

3 Between Frame 49 and Frame 50, from STGR 38 LH, remove:

1	Plate-Shear	D5347471500000	Item (139)	Retain

4 Between Frame 49 and Frame 50, on STGR 38 LH, clean and deburr the new fastener holes in the bracket, Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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5 Between Frame 49 and Frame 50, from STGR 38 LH and from the bracket at Frame 49 and bracket, Item 66, wet install:

Refer to Fig. A-GBQAG Sheet 02, View D.

1	Plate-Shear	D5347471500000	Item (139)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545	
6	Rivet	EN6081D5-06	Item 656	
20	Rivet	EN6081D5-07	Item 657	

6 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item 66, put in position:

Refer to Fig. A-GBQAG Sheet 02, View D.

1	Plate-Shear	D5347471500200	Item (117)	Retained at removal

7 Transfer drill and ream the six holes from the shear plate, Item (117), to the brackets, Item 65 and Item 66, refer to Fig. A-GBQAG Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAG Sheet 06.

8 Between Frame 50 and Frame 51, on STGR 38 LH, remove:

1	Plate-Shear	D5347471500200	Item (117)	Retain

9 Between Frame 50 and Frame 51, on STGR 38 LH, clean and deburr the new fastener holes in the brackets, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

10 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item 66, wet install:

Refer to Fig. A-GBQAG Sheet 02, View D.

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1	Plate-Shear	D5347471500200	Item (117)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545	
6	Rivet	EN6081D5-06	Item 656	
20	Rivet	EN6081D5-07	Item 657	

11 Between Frame 51 and Frame 52, on STGR 38 LH and on the brackets, Item 65 and Item 67, put in position:

Refer to Fig. A-GBQAG Sheet 02, View D.

1	Plate-Shear	D5347471502800	Item (180)	Retained at removal

12 Transfer drill and ream the six holes from the shear plate, Item (180), to the brackets, Item 65 and Item 67, refer to Fig. A-GBQAG Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAG Sheet 06.

13 Between Frame 51 and Frame 52, on STGR 38 LH, remove:

1	Plate-Shear	D5347471502800	Item (180)	Retain

14 Between Frame 51 and Frame 52, on STGR 38 LH, clean and deburr the new fastener holes in the brackets, Item 65 and Item 67, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

15 Between Frame 51 and Frame 52, on STGR 38 LH and on the brackets, Item 65 and Item 67, wet install:

Refer to Fig. A-GBQAG Sheet 02, View D.

1	Plate-Shear	D5347471502800	Item (180)	Retained at removal

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6069D4-05	Item 545	
6	Rivet	EN6081D5-06	Item 656	
19	Rivet	EN6081D5-07	Item 657	

16 Between Frame 52 and Frame 53, on STGR 38 LH and on the brackets, Item 65 and Item 68, put in position:

Refer to Fig. A-GBQAG Sheet 03, View F.

1	Plate-Shear	D5347471503000	Item (190)	Retained at removal

17 Transfer drill and ream the six holes from the shear plate, Item (190), to the brackets, Item 65 and Item 68, refer to Fig. A-GBQAG Sheet 03, View F.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAG Sheet 06.

18 Between Frame 52 and Frame 53, on STGR 38 LH, remove:

1	Plate-Shear	D5347471503000	Item (190)	Retain

19 Between Frame 52 and Frame 53, on STGR 38 LH, clean and deburr the new fastener holes in the brackets, Item 65 and Item 68, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 Between Frame 52 and Frame 53, on STGR 38 LH and on the brackets, Item 65 and Item 68, wet install:

Refer to Fig. A-GBQAG Sheet 03, View F.

1	Plate-Shear	D5347471503000	Item (190)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6069D4-05	Item 545	
27	Rivet	EN6081D5-06	Item 656	

21 Between Frame 53 and Frame 54, on STGR 38 LH and on the brackets, Item 80 and Item 82, put in position:

Refer to Fig. A-GBQAG Sheet 03, View F.

1	Plate-Shear	D5347471501000	Item (141)	Retained at removal

22 Transfer drill and ream the six holes from the shear plate, Item (141), to the brackets, Item 80 and Item 82, refer to Fig. A-GBQAG Sheet 03, View F.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAG Sheet 06.

23 Between Frame 53 and Frame 54, on STGR 38 LH, remove:

1	Plate-Shear	D5347471501000	Item (141)	Retain

24 Between Frame 53 and Frame 54, on STGR 38 LH, clean and deburr the new fastener holes in the brackets, Item 80 and Item 82, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

25 Between Frame 53 and Frame 54, on STGR 38 LH and on the brackets, Item 80 and Item 82, wet install:

Refer to Fig. A-GBQAG Sheet 03, View F.

1	Plate-Shear	D5347471501000	Item (141)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-05	Item 545	
26	Rivet	EN6081D5-06	Item 656	

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26 Between Frame 54 and Frame 55, on STGR 38 LH and on the brackets, Item 84 and Item (120), put in position:

Refer to Fig. A-GBQAG Sheet 03, View F.

1	Plate Assy-Shear	D5347048800400	Item (122)	Retained at removal

27 Transfer drill and ream the three holes from the shear plate, Item (122), to the bracket, Item 84, refer to Fig. A-GBQAG Sheet 03, View F.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAG Sheet 06.

28 Between Frame 54 and Frame 55, on STGR 38 LH, remove:

1	Plate Assy-Shear	D5347048800400	Item (122)	Retain

29 Between Frame 53 and Frame 54, on STGR 38 LH, clean and deburr the new fastener holes in the bracket, Item 84, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

30 Between Frame 54 and Frame 55, on STGR 38 LH and on the brackets, Item 84 and Item (120), wet install:

Refer to Fig. A-GBQAG Sheet 03, View F.

1	Plate Assy-Shear	D5347048800400	Item (122)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

14	Rivet	EN6069D4-05	Item 545
26	Rivet	EN6081D5-06	Item 656

31 Between Frame 56 and Frame 57, on STGR 38 LH and on the brackets, Item (121) and Item (118), wet install:

Refer to Fig. A-GBQAG Sheet 04, View H.

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1	Plate Assy-Shear	D5347048900000	Item (124)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
14	Rivet	EN6069D4-05	Item 545	
26	Rivet	EN6081D5-06	Item 656	

32 Between Frame 58 and Frame 59, on STGR 38 LH and on the brackets, Item (125) and Item (127), wet install:

Refer to Fig. A-GBQAG Sheet 05, View K.

1	Plate-Shear	D5347049200200	Item (126)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
14	Rivet	EN6069D4-05	Item 545	
26	Rivet	EN6081D5-06	Item 656	

33 Between Frame 60 and Frame 61, on STGR 38 LH and on the brackets, Item (128) and Item (130), wet install:

Refer to Fig. A-GBQAG Sheet 05, View M.

1	Plate-Shear	D5347049300200	Item (129)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6069D4-04	Item 544	
8	Rivet	EN6081D5-05	Item 655	

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20	Rivet	EN6081D5-06	Item 656	

34 Between Frame 62 and Frame 63, on STGR 38 LH and on the brackets, Item (131) and Item (115), wet install:

Refer to Fig. A-GBQAG Sheet 06, View P.

1	Plate-Shear	D5347049400000	Item (123)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-04	Item 544	
7	Rivet	EN6081D5-05	Item 655	
20	Rivet	EN6081D5-06	Item 656	

(b) Install the corner profiles.

In accordance with SRM 53-41-14.

1 Between Frame 48 thru Frame 63, at STGR 38 LH, install the corner profiles, if removed in accordance with SRM 53-41-14 C2 Identification - Floor Structure - Cargo Compartment.

(c) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(18) Subtask 531364-831-218-002 - Install new Surface Protection on Frame 50 thru Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 from Stringer 31 to Stringer 39

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To	160	Work location	from Frame 60 to Frame 63 from Stringer 31 to Stringer 39

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	NON SPECIFIC

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	04JME4	As required	
	Coating - Flexible Structure	04QAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound	12ADB1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12

(a) Clean the working area with:

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

(b) Apply sealant beads around the edges of all new and reinstalled structure parts with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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(c) Apply to all sealant beads:

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(d) Apply to all sealant beads:

Top Coat Polyurethane	04JME4	As required

and

Coating - Flexible Structure	04QAB2	As required

(e) Install new water repellent protection on Frame 50 thru Frame 63.

1 Protect the Frame 50 thru Frame 63, STGR 31 LH thru STGR 39 LH and the re-installed shear plates with:

In accordance with SRM 51-23-12.

Corrosion Preventive Compound	12ADB1	As required

**CONF 008

(1) Subtask 531364-831-201-015 - Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 Stringer 38 LH
To	160	Work location	from Frame 60 to Frame 63 Stringer 38 LH

Manpower Resources	
Manhours	4.50
Minimum number of person	1
Subtask elapsed time	4.50
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
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	53-41-14
Fig. A-GBQAA Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

CAUTION: AIRBUS CONSIDERS IT IS TECHNICALLY ACCEPTABLE TO REWORK EVERY THIRD FRAME AT THE SAME TIME (I.E. LEAVE TWO FRAMES INTACT AND REWORK ONE) TO KEEP THE FUSELAGE STRUCTURE INTEGRITY.

(a) Remove the corner profiles.

In accordance with SRM 53-41-14 C2 Ident.-Floor Structure-Cargo Compartment.

1 Between Frame 48 thru Frame 63, at STGR 38 LH, remove the corner profiles, if necessary in accordance with SRM 53-41-14 C2 Identification - Floor Structure - Cargo Compartment.

(b) Remove the shear plates.

Refer to Fig. A-GBQAA Sheet 01 thru Fig. A-GBQAA Sheet 06.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 Between Frame 49 and Frame 50, from STGR 38 LH and from the bracket at Frame 49 and bracket, Item (140), remove:

Refer to Fig. A-GBQAA Sheet 02, View C.

1	Plate-Shear	D5347456300000	Item (139)	Retain
	with			
26	Rivet		Item (100)	Discard

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2 Between Frame 50 and Frame 51, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAA Sheet 02, View C.

1	Plate-Shear	D5347471500200	Item (117)	Retain
	with			
28	Rivet		Item (100)	Discard

3 Between Frame 52 and Frame 53, from STGR 38 LH and from the brackets, Item (116) and Item (120), remove:

Refer to Fig. A-GBQAA Sheet 03, View E.

1	Plate Assy-Shear	D5347049100200	Item (119)	Retain
1	Section-Connecting	D5347065020200	Item (135)	Retain
	with			
42	Rivet		Item (100)	Discard

4 Between Frame 54 and Frame 55, from STGR 38 LH and from the brackets, Item (121) and Item (120), remove:

Refer to Fig. A-GBQAA Sheet 04, View G.

1	Plate Assy-Shear	D5347048800000	Item (122)	Retain
	with			
28	Rivet		Item (100)	Discard

5 Between Frame 56 and Frame 57, from STGR 38 LH and from the brackets, Item (121) and Item (118), remove:

Refer to Fig. A-GBQAA Sheet 04, View J.

1	Plate-Shear	D5347048900400	Item (124)	Retain
	with			
28	Rivet		Item (100)	Discard

6 Between Frame 58 and Frame 59, from STGR 38 LH and from the brackets, Item (125) and Item (127), remove:

Refer to Fig. A-GBQAA Sheet 05, View L.

1	Plate-Shear	D5347049200400	Item (126)	Retain
	with			

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28	Rivet		Item (100)	Discard

7 Between Frame 60 and Frame 61, from STGR 38 LH and from the brackets, Item (128) and Item (130), remove:

Refer to Fig. A-GBQAA Sheet 05, View N.

1	Plate-Shear	D5347049300000	Item (129)	Retain
1	Section-Connecting	D5347065420400	Item (136)	Retain
	with			
45	Rivet		Item (100)	Discard

8 Between Frame 62 and Frame 63, from STGR 38 LH and from the brackets, Item (131) and Item (115), remove:

Refer to Fig. A-GBQAA Sheet 06, View Q.

1	Plate-Shear	D5347049400000	Item (123)	Retain
	with			
29	Rivet		Item (100)	Discard

(c) Clean the contact surfaces and the retained parts with:

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

(2) Subtask 531364-831-202-003 - Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 from Stringer 33 LH to Stringer 34 LH from Stringer 36 LH to Stringer 37 LH
To	160	Work location	from Frame 60 to Frame 62 from Stringer 32 LH to Stringer 33 LH from Stringer 36 LH to Stringer 37 LH Frame 63 from Stringer 31 LH to Stringer 32 LH from Stringer 36 LH to Stringer 37 LH

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Manpower Resources	
Manhours	5.00
Minimum number of person	1
Subtask elapsed time	5.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

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 Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane	04JME4	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00

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References	
Fig. A-GBRAA Cold Expansion of Holes in Frame 50 thru Frame 63	Sheet 01 Sheet 02 Sheet 03

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

(a) Inspect the holes for cracks from Frame 50 thru Frame 55 and from Frame 57 thru Frame 59.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 33 LH and STGR 34 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(b) Cold expand the holes from Frame 50 thru Frame 55 and from Frame 57 thru Frame 59.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 33 LH and STGR 34 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 02, View C.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

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

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(c) Inspect the holes for cracks at Frame 56.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 At Frame 56, between STGR 33 LH and STGR 34 LH and between STGR 35 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

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(d) Cold expand the holes at Frame 56.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 02.

1 At Frame 56, between STGR 33 LH and STGR 34 LH and between STGR 35 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 02, View D.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(e) Inspect the holes for cracks from Frame 60 thru Frame 62.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

1 From Frame 60 thru Frame 62, between STGR 32 LH and STGR 33 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(f) Cold expand the holes from Frame 60 thru Frame 62.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

1 From Frame 60 thru Frame 62, between STGR 32 LH and STGR 33 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 03, View E.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

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

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(g) Inspect the holes for cracks at Frame 63.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

1 At Frame 63, between STGR 31 LH and STGR 32 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frame, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 In case of crack indication, contact AIRBUS for further instructions.

3 In case of no crack indication, proceed with the next workstep.

(h) Cold expand the holes at Frame 63.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAA Sheet 01 and Fig. A-GBRAA Sheet 03.

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1 At Frame 63, between STGR 31 LH and STGR 32 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frame. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAA Sheet 03, View F.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

3 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

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(3) Subtask 531364-831-203-016 - Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 50 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D08R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
4	E5347001024400	1	WEB	
36	E5347001124200	1	ANGLE	
65	E5347001420200	1	ANGLE	
66	E5347001420000	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	20	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
764	DAN5-6-4X	14	PIN	
765	DAN5-6-5X	16	PIN	
766	DAN5-6-6X	7	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	2	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	41	COLLAR	
808	ASNA2528-3	3	NUT	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	4	PIN	

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBAAH Replacement of Webs and Angles at Frame 50	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBAAH Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 50, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920400	Item (37)	Discard
	with			
16	Rivet		Item (100)	Discard

2 From the flange of Frame 50, between STGR 35 LH and STGR 36 LH, remove:

6	Rivet		Item (100)	Discard

3 From Frame 50, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347073420200	Item (1)	Discard
	with			
17	Rivet		Item (100)	Discard

4 From Frame 50, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072820600	Item (2)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046825000	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard
	with			
65	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 50.

Refer to NTM 51-10-01.

Refer to Fig. A-GBAAH Sheet 02, View C.

1 On Frame 50, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 50, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBAAH Sheet 02 thru Fig. A-GBAAH Sheet 04.

1 On Frame 50, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBAAH Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 50 to the shear web, Item 4.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAH Sheet 04.

4 Transfer drill the tack hole from the Frame 50 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

5 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBAAH Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBAAH Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAH

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Sheet 04.

6 On Frame 50, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

7 Clean and deburr the new fastener holes in Frame 50 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBAAH Sheet 02, View C.

a On Frame 50, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBAAH Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

b On Frame 50, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAH Sheet 02, View C.

c On Frame 50, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAH Sheet 02, View C.

d On Frame 50, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAH Sheet 02, View C.

9 On Frame 50, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

10 Clean and deburr the cold expansion fastener holes in Frame 50 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 50, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBAAH Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

with

3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
20	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
14	Pin	DAN5-6-4X	Item 764
13	Pin	DAN5-6-5X	Item 765
27	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
5	Nut	ASNA2528-3A	Item 908

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use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 50, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBAAH Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

13 On the Frame 50 flange, at STGR 35 LH, refer to Fig. A-GBAAH Sheet 03, Section C-C, countersink the one fastener hole.

14 On the Frame 50 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBAAH Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 50 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBAAH Sheet 02, View C and Fig. A-GBAAH Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and three holes from the Frame to the angle, Item 1, refer to Fig. A-GBAAH Sheet 02, View C and Fig. A-GBAAH Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAH Sheet 04.

17 On the Frame 50 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

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18 Clean and deburr the new fastener holes in the Frame 50, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 50 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBAAH Sheet 02, View C and Fig. A-GBAAH Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

20 On the Frame 50 flange, at STGR 35 LH, refer to Fig. A-GBAAH Sheet 03, Section D-D, countersink the one fastener hole.

21 On the Frame 50 flange, at STGR 35 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBAAH Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 50 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBAAH Sheet 02, View C and Fig. A-GBAAH Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

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23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBAAH Sheet 02, View C and Fig. A-GBAAH Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAH Sheet 04.

24 On the Frame 50 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

25 Clean and deburr the new fastener holes in the Frame 50, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 50 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBAAH Sheet 02, View C and Fig. A-GBAAH Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Rivet	EN6081D6-07	Item 667

27 On the Frame 50 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBAAH Sheet 02, View C and Fig. A-GBAAH Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

4	Pin	DAN5-6-6X	Item 766
2	Pin	DAN5-6-7X	Item 767
4	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
4	Pin	DAN5-6-3	Item 963

28 On the Frame 50 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBAAH Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

29 Transfer drill and ream the three holes from the Frame to the angles, Item 65 and Item 66, refer to Fig. A-GBAAH Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAH Sheet 04.

30 On the Frame 50 flange, at STGR 38 LH, remove:

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

31 Clean and deburr the new fastener holes in the Frame 50 and angles, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

32 On the Frame 50 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBAAH Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

1	Pin	DAN5-6-6X	Item 766
2	Pin	DAN5-6-8X	Item 768
3	Collar	DAN11-6X	Item 807

33 On the Frame 50 flange, at STGR 39 LH, refer to Fig. A-GBAAH Sheet 03, Section F-F, countersink the one fastener hole.

34 On the Frame 50 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBAAH Sheet 03, Section F-F.

1	Rivet	EN6069D5-06	Item 556

with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

35 On the Frame 50 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBAAH Sheet 02, View C and Fig. A-GBAAH Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

36 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from the STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBAAH Sheet 02, View C and Fig. A-GBAAH Sheet 03, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAH Sheet 04.

37 On the Frame 50 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

38 Clean and deburr the new fastener holes in the Frame 50, STGR 39 LH and angle, Item 36, use:

	Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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Non Aqueous Cleaner - General	08BAA9	As required

39 On the Frame 50 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBAAH Sheet 02, View C and Fig. A-GBAAH Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Pin	DAN5-6-6X	Item 766
2	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(4) Subtask 531364-831-204-008 - Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 51 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D08R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
4	E5347001024400	1	WEB	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	20	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
764	DAN5-6-4X	14	PIN	
765	DAN5-6-5X	15	PIN	
766	DAN5-6-6X	6	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	3	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	40	COLLAR	
808	ASNA2528-3	3	NUT	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	4	PIN	

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	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	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

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NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBBAH Replacement of Webs and Angles at Frame 51	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBBAH Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

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1 From Frame 51, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920400	Item (37)	Discard
	with			
16	Rivet		Item (100)	Discard

2 From the flange of Frame 51, between STGR 35 LH and STGR 36 LH, remove:

6	Rivet		Item (100)	Discard

3 From Frame 51, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347073420200	Item (1)	Discard
	with			
17	Rivet		Item (100)	Discard

4 From Frame 51, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072820600	Item (2)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347470120000	Item (140)	Retain
	with			
64	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 51.

Refer to NTM 51-10-01.

Refer to Fig. A-GBBAH Sheet 02, View C.

1 On Frame 51, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM

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51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 51, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBBAH Sheet 02 thru Fig. A-GBBAH Sheet 04.

1 On Frame 51, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBBAH Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 51 to the shear web, Item 4.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAH Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBBAH Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBBAH Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAH Sheet 04.

5 Transfer drill the tack hole from the Frame 51 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 51, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

7 Clean and deburr the new fastener holes in Frame 51 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBBAH Sheet 02, View C.

a On Frame 51, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBBAH Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

b On Frame 51, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAH Sheet 02, View C.

c On Frame 51, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

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FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAH Sheet 02, View C.

d On Frame 51, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAH Sheet 02, View C.

9 On Frame 51, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

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10 Clean and deburr the cold expansion fastener holes in Frame 51 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 51, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBBAH Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

with

3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
20	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
14	Pin	DAN5-6-4X	Item 764
12	Pin	DAN5-6-5X	Item 765
26	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
5	Nut	ASNA2528-3A	Item 908

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 51, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBBAH Sheet 02, View C.

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1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

13 On the Frame 51 flange, at STGR 35 LH, refer to Fig. A-GBBAH Sheet 03, Section A-A, countersink the one fastener hole.

14 On the Frame 51 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBBAH Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 51 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBBAH Sheet 02, View C and Fig. A-GBBAH Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBBAH Sheet 02, View C and Fig. A-GBBAH Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAH Sheet 04.

17 On the Frame 51 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 51, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 51 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBBAH Sheet 02, View C and Fig. A-GBBAH Sheet 03, Section A-A.

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1	Angle	E5347001120000	Item 1
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

20 On the Frame 51 flange, at STGR 36 LH, refer to Fig. A-GBBAH Sheet 03, Section B-B, countersink the one fastener hole.

21 On the Frame 51 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBBAH Sheet 03, Section B-B.

1	Rivet	EN6069D5-06	Item 556
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 51 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBBAH Sheet 02, View C and Fig. A-GBBAH Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBBAH Sheet 02, View C and Fig. A-GBBAH Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAH Sheet 04.

24 On the Frame 51 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

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25 Clean and deburr the new fastener holes in the Frame 51, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 51 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBBAH Sheet 02, View C and Fig. A-GBBAH Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Rivet	EN6081D6-07	Item 667

27 On the Frame 51 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBBAH Sheet 02, View C and Fig. A-GBBAH Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Pin	DAN5-6-6X	Item 766
2	Pin	DAN5-6-7X	Item 767
4	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
4	Pin	DAN5-6-3	Item 963

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28 On the Frame 51 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBBAH Sheet 02, View C.

1	Angle	D5347470120000	Item (140)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Pin	DAN5-6-8X	Item 768	
3	Collar	DAN11-6X	Item 807	

29 On the Frame 51 flange, at STGR 39 LH, refer to Fig. A-GBBAH Sheet 03, Section D-D, countersink the one fastener hole.

30 On the Frame 51 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBBAH Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

31 On the Frame 51 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBBAH Sheet 02, View C and Fig. A-GBBAH Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

32 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes form the Frame to the angle, Item 36, refer to Fig. A-GBBAH Sheet 02, View C and Fig. A-GBBAH Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAH Sheet 04.

33 On the Frame 51 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

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34 Clean and deburr the new fastener holes in the Frame 51, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

35 On the Frame 51 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBBAH Sheet 02, View C and Fig. A-GBBAH Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Pin	DAN5-6-6X	Item 766
2	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

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(5) Subtask 531364-831-205-015 - Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 52 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D08R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
6	E5347001023600	1	WEB	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	2	RIVET	
567	EN6069D6-07	25	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	4	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	2	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	9	PIN	
765	DAN5-6-5X	1	PIN	
766	DAN5-6-6X	6	PIN	
806	NSA5075-6	13	COLLAR	
807	DAN11-6X	16	COLLAR	
808	ASNA2528-3	10	NUT	
863	DAN6-6-3	1	PIN	
865	DAN6-6-5	4	PIN	
866	DAN6-6-6	6	PIN	
963	DAN5-6-3	1	PIN	
964	DAN5-6-4	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBCAA Replacement of Webs and Angles at Frame 52	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBCAA Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 52, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920200	Item (3)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 52, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

8	Rivet		Item (100)	Discard

3 From Frame 52, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 52, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347077420200	Item (5)	Discard
1	Support	D5347032200400	Item (103)	Retain
1	Angle	D5347046825000	Item (116)	Retain
1	Section-Connecting	D5347065020200	Item (135)	Retain
1	Shim	D5347044920000	Item (142)	Retain
1	Shim	D5347044920600	Item (143)	Retain
	with			
65	Rivet		Item (100)	Discard

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(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 52.

Refer to NTM 51-10-01.

Refer to Fig. A-GBCAA Sheet 02, Views C, D and F.

1 On Frame 52, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 52, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 52, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 52, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBCAA Sheet 02 thru Fig. A-GBCAA Sheet 04.

1 On Frame 52, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBCAA Sheet 02, View C.

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1 Shear Web E5347001023600 Item 6

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 52 to the shear web, Item 6.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAA Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBCAA Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBCAA Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAA Sheet 04.

5 Transfer drill the tack hole from the Frame 52 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 52, between STGR 34 LH and STGR 39 LH, remove:

1 Shear Web E5347001023600 Item 6

7 Clean and deburr the new fastener holes in Frame 52 and the shear web, Item 6, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBCAA Sheet 02, Views C, D and F.

a On Frame 52, between STGR 34 LH and STGR 39 LH, put in position:

1 Shear Web E5347001023600 Item 6

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b On Frame 52, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAA Sheet 02, View C.

c On Frame 52, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAA Sheet 02, View C.

d On the top flange of Frame 52, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAA Sheet 02, View D.

e On the top flange of Frame 52, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAA Sheet 02, View F.

9 On Frame 52, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001023600	Item 6

10 Clean and deburr the cold expansion fastener holes in Frame 52 and the shear web, Item 6, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 52, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBCAA Sheet 02, View C.

1	Shear Web	E5347001023600	Item 6

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
25	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
16	Rivet	EN6081D6-08	Item 668
7	Pin	DAN5-6-4X	Item 764
1	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
1	Pin	DAN5-6-3	Item 963

use

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 52, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBCAA Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 52, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBCAA Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

14 On the Frame 52 flange, at STGR 35 LH, refer to Fig. A-GBCAA Sheet 03, Section B-B, countersink the one fastener hole.

15 On the Frame 52 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBCAA Sheet 03, Section B-B.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 52 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBCAA Sheet 02, View C and Fig. A-GBCAA Sheet 03, Section B-B.

1	Angle	E5347001120000	Item 1

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17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBCAA Sheet 02, View C and Fig. A-GBCAA Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAA Sheet 04.

18 On the Frame 52 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 52, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 52 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBCAA Sheet 02, View C and Fig. A-GBCAA Sheet 03, Section B-B.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

21 On the Frame 52 flange, at STGR 36 LH, refer to Fig. A-GBCAA Sheet 03, Section C-C, countersink the one fastener hole.

22 On the Frame 52 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBCAA Sheet 03, Section C-C.

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1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 52 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBCAA Sheet 02, View C and Fig. A-GBCAA Sheet 03, Section C-C.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes to the angle, Item 2, refer to Fig. A-GBCAA Sheet 03, Section C-C

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAA Sheet 04.

25 On the Frame 52 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 52, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 52 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBCAA Sheet 02, View C and Fig. A-GBCAA Sheet 03, Section C-C.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657

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2	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-4	Item 964	
1	Collar	NSA5075-6	Item 806	

28 On the Frame 52 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBCAA Sheet 02, View C and Fig. A-GBCAA Sheet 03, Section D-D.

1	Support	D5347032200400	Item (103)	Retained at removal
1	Section-Connecting	D5347065020200	Item (135)	Retained at removal
1	Shim	D5347044920000	Item (142)	Retained at removal
1	Shim	D5347044920600	Item (143)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

6	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-4X	Item 764
6	Pin	DAN5-6-6X	Item 766
7	Collar	DAN11-6X	Item 807
10	Collar	NSA5075-6	Item 806
4	Pin	DAN6-6-5	Item 865
6	Pin	DAN6-6-6	Item 866

29 On the aft side of the Frame 52 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBCAA Sheet 02, View C.

1	Angle	D5347046825000	Item (116)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-4X	Item 764
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(6) Subtask 531364-831-206-014 - Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 53 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D08R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
8	E5347001027400	1	WEB	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	2	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	1	PIN	
806	NSA5075-6	18	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	9	NUT	
863	DAN6-6-3	10	PIN	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	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	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

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NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBDAH Replacement of Webs and Angles at Frame 53	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBDAH Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

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1 From Frame 53, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the flange of Frame 53, between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 53, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 53, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078320200	Item (6)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046823800	Item (120)	Retain
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 53.

Refer to NTM 51-10-01.

Refer to Fig. A-GBDAH Sheet 02, View C.

1 On Frame 53, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM

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51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 53, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBDAH Sheet 02 thru Fig. A-GBDAH Sheet 04.

1 On Frame 53, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBDAH Sheet 02, View C.

1	Shear Web	E5347001027400	Item 8

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 53 to the shear web, Item 8.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAH Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBDAH Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBDAH Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAH Sheet 04.

5 Transfer drill the tack hole from the Frame 53 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 53, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001027400	Item 8

7 Clean and deburr the new fastener holes in Frame 53 and the shear web, Item 8, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBDAH Sheet 02, View C.

a On Frame 53, between STGR 34 LH and STGR 39 LH, put in position:

1	Shear Web	E5347001027400	Item 8

b On Frame 53, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAH Sheet 02, View C.

c On Frame 53, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAH Sheet 02, View C.

9 On Frame 53, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001027400	Item 8

10 Clean and deburr the cold expansion fastener holes in Frame 53 and the shear web, Item 8, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 53, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBDAH Sheet 02, View C.

1	Shear Web	E5347001027400	Item 8

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668

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6	Pin	DAN5-6-4X	Item 764
13	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863
1	Pin	DAN5-6-3	Item 963
2	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 53, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBDAH Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the Frame 53 flange, at STGR 35 LH, refer to Fig. A-GBDAH Sheet 03, Section A-A, countersink the one fastener hole.

14 On the Frame 53 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBDAH Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 53 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBDAH Sheet 02, View C and Fig. A-GBDAH Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

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16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBDAH Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAH Sheet 04.

17 On the Frame 53 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

18 Clean and deburr the new fastener holes in the Frame 53, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 53 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBDAH Sheet 02, View C and Fig. A-GBDAH Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

20 On the Frame 53 flange, at STGR 36 LH, refer to Fig. A-GBDAH Sheet 03, Section B-B, countersink the one fastener hole.

21 On the Frame 53 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBDAH Sheet 03, Section B-B.

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1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 53 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBDAH Sheet 02, View C and Fig. A-GBDAH Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBDAH Sheet 02, View C and Fig. A-GBDAH Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAH Sheet 04.

24 On the Frame 53 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

25 Clean and deburr the new fastener holes in the Frame 53, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 53 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBDAH Sheet 02, View C and Fig. A-GBDAH Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657

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2	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-4	Item 964	
1	Collar	NSA5075-6	Item 806	

27 On the Frame 53 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBDAH Sheet 02, View C and Fig. A-GBDAH Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

28 On the Frame 53 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBDAH Sheet 02, View C.

1	Angle	D5347046823800	Item (120)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-4X	Item 764	
1	Collar	DAN11-6X	Item 807	

29 On the Frame 53 flange, at STGR 39 LH, refer to Fig. A-GBDAH Sheet 03, Section D-D, countersink the one fastener hole.

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30 On the Frame 53 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBDAH Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

31 On the Frame 53 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBDAH Sheet 02, View C and Fig. A-GBDAH Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

32 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBDAH Sheet 02, View C and Fig. A-GBDAH Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBDAH Sheet 04.

33 On the Frame 53 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

34 Clean and deburr the new fastener holes in the Frame 53, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

35 On the Frame 53 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBDAH Sheet 02, View C and Fig. A-GBDAH Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D6-08	Item 668
2	Rivet	EN6081D5-07	Item 657

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(7) Subtask 531364-831-207-014 - Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 54 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D08R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
10	E5347001023400	1	WEB	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	6	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	21	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	1	PIN	
806	NSA5075-6	16	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	10	NUT	
863	DAN6-6-3	12	PIN	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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.

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NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBEAH Replacement of Webs and Angles at Frame 54	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBEAH Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 54, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 54, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

10	Rivet		Item (100)	Discard

3 From Frame 54, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard

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with

14	Rivet		Item (100)	Discard

4 From Frame 54, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078520200	Item (7)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046824000	Item (121)	Retain

with

56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 54.

Refer to NTM 51-10-01.

Refer to Fig. A-GBEAH Sheet 02, Views C, D and F.

1 On Frame 54, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 54, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 54, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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4 On the top flange of Frame 54, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBEAH Sheet 02 thru Fig. A-GBEAH Sheet 04.

1 On Frame 54, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBEAH Sheet 02, View C.

1	Shear Web	E5347001023400	Item 10

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 54 to the shear web, Item 10.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAH Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBEAH Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBEAH Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAH Sheet 04.

5 Transfer drill the tack hole from the Frame 54 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 54, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001023400	Item 10

7 Clean and deburr the fastener holes in Frame 54 and the shear web, Item 10, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBEAH Sheet 02, Views C, D and F.

a On Frame 54, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBEAH Sheet 02, View C.

1	Shear Web	E5347001023400	Item 10

b On Frame 54, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAH Sheet 02, View C.

c On Frame 54, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAH Sheet 02, View C.

d On the top flange of Frame 54, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAH Sheet 02, View D.

e On the top flange of Frame 54, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

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FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAH Sheet 02, View F.

9 On Frame 54, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001023400	Item 10

10 Clean and deburr the cold expansion fastener holes in Frame 54 and the shear web, Item 10, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 54, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBEAH Sheet 02, View C.

1	Shear Web	E5347001023400	Item 10

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
6	Rivet	EN6081D6-06	Item 666

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17	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
10	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 54, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBEAH Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 54, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBEAH Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

14 On the Frame 54 flange, at STGR 35 LH, refer to Fig. A-GBEAH Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 54 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBEAH Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 54 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBEAH Sheet 02, View C and Fig. A-GBEAH Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three hole in the Frame to the angle, Item 1, refer to Fig. A-GBEAH Sheet 02, View C and Fig. A-GBEAH Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAH Sheet 04.

18 On the Frame 54 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 54, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 54 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBEAH Sheet 02, View C and Fig. A-GBEAH Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765

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1	Collar	DAN11-6X	Item 807

21 On the Frame 54 flange, at STGR 36 LH, refer to Fig. A-GBEAH Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 54 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBEAH Sheet 03, Section B-B.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 54 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBEAH Sheet 02, View C and Fig. A-GBEAH Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBEAH Sheet 02, View C and Fig. A-GBEAH Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAH Sheet 04.

25 On the Frame 54 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 54, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 54 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBEAH Sheet 02, View C and Fig. A-GBEAH Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

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with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

28 On the Frame 54 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBEAH Sheet 02, View C and Fig. A-GBEAH Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal

with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

29 On the aft side of the Frame 54 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBEAH Sheet 02, View C.

1	Angle	D5347046824000	Item (121)	Retained at removal

with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-4X	Item 764	
1	Collar	DAN11-6X	Item 807	

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30 On the Frame 54 flange, at STGR 39 LH, refer to Fig. A-GBEAH Sheet 03, Section D-D, countersink the one fastener hole.

31 On the Frame 54 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBEAH Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

32 On the Frame 54 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBEAH Sheet 02, View C and Fig. A-GBEAH Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two hole from the Frame to the angle, Item 36, refer to Fig. A-GBEAH Sheet 02, View C and Fig. A-GBEAH Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAH Sheet 04.

34 On the Frame 54 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

35 Clean and deburr the new fastener holes in the Frame 54, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

36 On the Frame 54 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBEAH Sheet 02, View C and Fig. A-GBEAH Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D6-08	Item 668
2	Rivet	EN6081D5-07	Item 657

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(8) Subtask 531364-831-208-014 - Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 55 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D08R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
12	E5347001020800	1	WEB	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	6	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	10	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	16	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	10	NUT	
863	DAN6-6-3	12	PIN	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	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	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

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NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBFAH Replacement of Webs and Angles at Frame 55	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBFAH Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

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1 From Frame 55, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 55, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

10	Rivet		Item (100)	Discard

3 From Frame 55, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 55, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072120600	Item (8)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046823800	Item (120)	Retain
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 55.

Refer to NTM 51-10-01.

Refer to Fig. A-GBFAH Sheet 02, Views C, D and F.

1 On Frame 55, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM

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51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 55, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 55, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBFAH Sheet 02 thru Fig. A-GBFAH Sheet 04.

1 On Frame 55, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBFAH Sheet 02, View C.

1	Shear Web	E5347001020800	Item 12

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 55 to the shear web, Item 12.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAH Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBFAH Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBFAH Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAH Sheet 04.

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5 Transfer drill the tack hole from the Frame 55 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 55, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001020800	Item 12

7 Clean and deburr the new fastener holes in Frame 55 and the shear web, Item 12, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBFAH Sheet 02, Views C, D and F.

a On Frame 55, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBFAH Sheet 02, View C.

1	Shear Web	E5347001020800	Item 12

b On Frame 55, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAH Sheet 02, View C.

c On Frame 55, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAH Sheet 02, View C.

d On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAH Sheet 02, View D.

e On the top flange of Frame 55, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAH Sheet 02, View F.

9 On Frame 55, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001020800	Item 12

10 Clean and deburr the cold expansion fastener holes in Frame 55 and the shear web, Item 12, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 55, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBFAH Sheet 02, View C.

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1	Shear Web	E5347001020800	Item 12
	with		
3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
6	Rivet	EN6081D6-06	Item 666
17	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
10	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863
	use		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 55, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBFAH Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBFAH Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

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14 On the Frame 55 flange, at STGR 35 LH, refer to Fig. A-GBFAH Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 55 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBFAH Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 55 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBFAH Sheet 02, View C and Fig. A-GBFAH Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBFAH Sheet 02, View C and Fig. A-GBFAH Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAH Sheet 04.

18 On the Frame 55 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 55, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 55 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBFAH Sheet 02, View C and Fig. A-GBFAH Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

21 On the Frame 55 flange, at STGR 36 LH, refer to Fig. A-GBFAH Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 55 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBFAH Sheet 03, Section B-B.

1	Rivet	EN6069D5-06	Item 556

with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 55 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBFAH Sheet 02, View C and Fig. A-GBFAH Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBFAH Sheet 02, View C and Fig. A-GBFAH Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAH Sheet 04.

25 On the Frame 55 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 55, STGR 36 LH and angle, Item 2, use:

	Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 55 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBFAH Sheet 02, View C and Fig. A-GBFAH Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

28 On the Frame 55 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBFAH Sheet 02, View C and Fig. A-GBFAH Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 55 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBFAH Sheet 02, View C.

1	Angle	D5347046823800	Item (120)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

30 On the Frame 55 flange, at STGR 39 LH, refer to Fig. A-GBFAH Sheet 03, Section D-D, countersink the one fastener hole.

31 On the Frame 55 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBFAH Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

32 On the Frame 55 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBFAH Sheet 02, View C and Fig. A-GBFAH Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBFAH Sheet 02, View C and Fig. A-GBFAH Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAH Sheet 04.

34 On the Frame 55 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

35 Clean and deburr the new fastener holes in the Frame 55, STGR 39 LH and angle, Item 36, use:

	Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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Non Aqueous Cleaner - General	08BAA9	As required

36 On the Frame 55 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBFAH Sheet 02, View C and Fig. A-GBFAH Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-08	Item 668
2	Rivet	EN6081D5-07	Item 657

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(9) Subtask 531364-831-209-014 - Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 56 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D08R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
14	E5347001021000	1	WEB	
16	E5347001120400	1	ANGLE	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	10	RIVET	
656	EN6081D5-06	11	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	9	RIVET	
668	EN6081D6-08	24	RIVET	(1)
669	EN6081D6-09	10	RIVET	(2)
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	1	PIN	
806	NSA5075-6	24	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	10	NUT	
863	DAN6-6-3	17	PIN	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	2	PIN	
965	DAN5-6-5	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	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	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

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NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBGAH Replacement of Webs and Angles at Frame 56	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBGAH Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

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1 From Frame 56, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347078720000	Item (9)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 56, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 34 LH and STGR 36 LH, remove:

12	Rivet		Item (100)	Discard

3 From Frame 56, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347078820000	Item (10)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 56, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078620200	Item (11)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046824000	Item (121)	Retain
1	Support	D5347068520100	Item (134)	Retain
	with			
64	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 56.

Refer to NTM 51-10-01.

Refer to Fig. A-GBGAH Sheet 02, Views C, D and F.

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1 On Frame 56, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 56, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 56, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBGAH Sheet 02 thru Fig. A-GBGAH Sheet 04.

1 On Frame 56, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBGAH Sheet 02, View C.

1	Shear Web	E5347001021000	Item 14

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 56 to the shear web, Item 14.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAH Sheet 04.

4 Drill the additional 5 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBGAH Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBGAH Sheet

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02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAH Sheet 04.

5 Transfer drill the tack hole from the Frame 56 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 On Frame 56, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021000	Item 14

7 Clean and deburr the new fastener holes in Frame 56and the shear web, Item 14, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBGAH Sheet 02, Views C, D and F.

a On Frame 56, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBGAH Sheet 02, View C.

1	Shear Web	E5347001021000	Item 14

b On Frame 56, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAH Sheet 02, View C.

c On Frame 56, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAH Sheet 02, View C.

d On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAH Sheet 02, View D.

e On the top flange of Frame 56, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAH Sheet 02, View F.

9 On Frame 56, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021000	Item 14

10 Clean and deburr the cold expansion fastener holes in Frame 56and the shear web, Item 14, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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11 At Frame 56, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBGAH Sheet 02, View C.

1	Shear Web	E5347001021000	Item 14
	with		
3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
10	Rivet	EN6069D6-07	Item 567
7	Rivet	EN6081D5-06	Item 656
9	Rivet	EN6081D6-06	Item 666
19	Rivet	EN6081D6-08	Item 668
7	Pin	DAN5-6-4X	Item 764
17	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
15	Pin	DAN6-6-3	Item 863
2	Pin	DAN5-6-4	Item 964
	use		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 56, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBGAH Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBGAH Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463

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2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

14 On the Frame 56 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBGAH Sheet 02, View C and Fig. A-GBGAH Sheet 03, Section A-A.

1	Angle	E5347001120400	Item 16

15 Transfer drill and ream the holes from the Frame 56 and from STGR 35 LH to the angle, Item 16, refer to Fig. A-GBGAH Sheet 02, View C and Fig. A-GBGAH Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAH Sheet 04.

16 On the Frame 56 flange, at STGR 35 LH, remove:

1	Angle	E5347001120400	Item 16

17 Clean and deburr the new fastener holes in the Frame 56, STGR 35 LH and angle, Item 16, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

18 On the Frame 56 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBGAH Sheet 02, View C and Fig. A-GBGAH Sheet 03, Section A-A.

1	Angle	E5347001120400	Item 16

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669

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1	Collar	NSA5075-6	Item 806	
1	Pin	DAN5-6-5	Item 965	

19 On the Frame 56 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBGAH Sheet 02, View C and Fig. A-GBGAH Sheet 03, Section B-B.

1	Support	D5347068520100	Item (134)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D6-08	Item 668	

20 On the Frame 56 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBGAH Sheet 02, View C and Fig. A-GBGAH Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

21 On the aft side of the Frame 56 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBGAH Sheet 02, View C.

1	Angle	D5347046824000	Item (121)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

22 On the Frame 56 flange, at STGR 39 LH, refer to Fig. A-GBGAH Sheet 03, Section D-D, countersink the one fastener hole.

23 On the Frame 56 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBGAH Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 56 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBGAH Sheet 02, View C and Fig. A-GBGAH Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBGAH Sheet 02, View C and Fig. A-GBGAH Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAH Sheet 04.

26 On the Frame 56 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

27 Clean and deburr the new fastener holes in the Frame 56, STGR 39 LH and angle, Item 36, use:

	Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 56 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBGAH Sheet 02, View C and Fig. A-GBGAH Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(10) Subtask 531364-831-210-014 - Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 57 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D08R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
18	E5347001021200	1	WEB	
20	E5347001123800	1	ANGLE	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	1	RIVET	
668	EN6081D6-08	17	RIVET	(1)
669	EN6081D6-09	10	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	19	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	10	NUT	
863	DAN6-6-3	11	PIN	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBHAH Replacement of Webs and Angles at Frame 57	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBHAH Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 57, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347081820000	Item (12)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 57, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

8	Rivet		Item (100)	Discard

3 From Frame 57, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347081720000	Item (13)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 57, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347081620400	Item (14)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046823600	Item (118)	Retain
	with			
57	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 57.

Refer to NTM 51-10-01.

Refer to Fig. A-GBHAH Sheet 02, Views C, D and F.

1 On Frame 57, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 57, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 57, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBHAH Sheet 02 thru Fig. A-GBHAH Sheet 04.

1 On Frame 57, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBHAH Sheet 02, View C.

1	Shear Web	E5347001021200	Item 18

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 57 to the shear web, Item 18.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAH

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Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBHAH Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBHAH Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAH Sheet 04.

5 Transfer drill the tack hole from the Frame 57 between STGR 36 LH and STGR 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 57, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021200	Item 18

7 Clean and deburr the new fastener holes in Frame 57 and the shear web, Item 18, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBHAH Sheet 02, Views C, D and F.

a On Frame 57, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBHAH Sheet 02, View C.

1	Shear Web	E5347001021200	Item 18

b On Frame 57, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAH Sheet 02, View C.

c On Frame 57, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAH Sheet 02, View C.

d On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAH Sheet 02, View D.

e On the top flange of Frame 57, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAH Sheet 02, View F.

9 On Frame 57, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021200	Item 18

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10 Clean and deburr the cold expansion fastener holes in Frame 57 and the shear web, Item 18, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 57, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBHAH Sheet 02, View C.

1	Shear Web	E5347001021200	Item 18

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
13	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863
1	Pin	DAN5-6-3	Item 963
2	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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12 Install 1 fastener in the flange of Frame 57, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBHAH Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBHAH Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

14 On the Frame 57 flange, at STGR 35 LH, refer to Fig. A-GBHAH Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 57 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBHAH Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 57 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBHAH Sheet 02, View C and Fig. A-GBHAH Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBHAH Sheet 02, View C and Fig. A-GBHAH Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAH Sheet 04.

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18 On the Frame 57 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 57, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 57 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBHAH Sheet 02, View C and Fig. A-GBHAH Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

21 On the Frame 57 flange, at STGR 36 LH, refer to Fig. A-GBHAH Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 57 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBHAH Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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23 On the Frame 57 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBHAH Sheet 02, View C and Fig. A-GBHAH Sheet 03, Section B-B.

1	Angle	E5347001123800	Item 20

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 20, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the two holes from the Frame to the angle, Item 20, refer to Fig. A-GBHAH Sheet 02, View C and Fig. A-GBHAH Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAH Sheet 04.

25 On the Frame 57 flange, at STGR 36 LH, remove:

1	Angle	E5347001123800	Item 20

26 Clean and deburr the new fastener holes in the Frame 57, STGR 36 LH and angle, Item 20, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 57 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBHAH Sheet 02, View C and Fig. A-GBHAH Sheet 03, Section B-B.

1	Angle	E5347001123800	Item 20

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-07	Item 667
1	Collar	NSA5075-6	Item 806
1	Pin	DAN5-6-4	Item 964

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28 On the Frame 57 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBHAH Sheet 02, View C and Fig. A-GBHAH Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 57 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBHAH Sheet 02, View C.

1	Angle	D5347046823600	Item (118)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-09	Item 669	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

30 On the Frame 57 flange, at STGR 39 LH, refer to Fig. A-GBHAH Sheet 03, Section D-D, countersink the one fastener hole.

31 On the Frame 57 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBHAH Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556	
	with			

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

32 On the Frame 57 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBHAH Sheet 02, View C and Fig. A-GBHAH Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole form STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBHAH Sheet 02, View C and Fig. A-GBHAH Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBHAH Sheet 04.

34 On the Frame 57 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

35 Clean and deburr the new fastener holes in the Frame 57, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

36 On the Frame 57 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBHAH Sheet 02, View C and Fig. A-GBHAH Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668

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(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(11) Subtask 531364-831-211-014 - Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 58 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D08R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
22	E5347001021400	1	WEB	
24	E5347001120600	1	ANGLE	
26	E5347001120800	1	ANGLE	
70	E5347001124400	1	ANGLE	
363	EN6115K3-3	5	BOLT	
364	EN6115K3-4	3	BOLT	
374	EN6115K3A4	2	BOLT	
463	EN6114K3-3	1	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
555	EN6069D5-05	2	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	14	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	3	RIVET	
666	EN6081D6-06	2	RIVET	
667	EN6081D6-07	4	RIVET	
668	EN6081D6-08	6	RIVET	(1)
670	EN6081D7-10	4	RIVET	
678	EN6081D7-08	6	RIVET	
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	20	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	9	NUT	
863	DAN6-6-3	9	PIN	
908	ASNA2528-3A	2	NUT	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	5	PIN	
965	DAN5-6-5	2	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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

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For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBJAH Replacement of Webs and Angles at Frame 58	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBJAH Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 58, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347082420000	Item (15)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 58, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 58, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347080520000	Item (16)	Discard
	with			

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13	Rivet		Item (100)	Discard

4 From Frame 58, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347083020400	Item (17)	Discard
1	Support	D5347032200600	Item (104)	Retain
1	Angle	D5347046824200	Item (125)	Retain
	with			
47	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 58.

Refer to NTM 51-10-01.

Refer to Fig. A-GBJAH Sheet 02, Views C, D and F.

1 On Frame 58, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 58, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 7 holes for the fasteners, Item 363, Item 364 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 On the top flange of Frame 58, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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4 On the top flange of Frame 58, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBJAH Sheet 02 thru Fig. A-GBJAH Sheet 04.

1 On Frame 58, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBJAH Sheet 02, View C.

1	Shear Web	E5347001021400	Item 22

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 58 to the shear web, Item 22.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAH Sheet 04.

4 Drill the additional 10 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBJAH Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBJAH Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAH Sheet 04.

5 Transfer drill the tack hole from the Frame 58 between STGR 36 LH and STGR 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 58, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021400	Item 22

7 Clean and deburr the new fastener holes in Frame 58 and the shear web, Item 22, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBJAH Sheet 02, Views C, D and F.

a On Frame 58, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBJAH Sheet 02, View C.

1	Shear Web	E5347001021400	Item 22

b On Frame 58, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAH Sheet 02, View C.

c On Frame 58, between STGR 36 LH and STGR 37 LH, cold expand the 5 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAH Sheet 02, View C.

d On Frame 58, between STGR 36 LH and STGR 37 LH, cold expand the 2 holes for the fasteners, Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAH Sheet 02, View C.

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e On the top flange of Frame 58, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAH Sheet 02, View D.

f On the top flange of Frame 58, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAH Sheet 02, View F.

9 On Frame 58, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021400	Item 22

10 Clean and deburr the cold expansion fastener holes in Frame 58 and the shear web, Item 22, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 58, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBJAH Sheet 02, View C.

1	Shear Web	E5347001021400	Item 22

with

4	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
2	Bolt	EN6115K3A4	Item 374
14	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-06	Item 666
4	Rivet	EN6081D6-08	Item 668
6	Rivet	EN6081D7-08	Item 678
7	Pin	DAN5-6-4X	Item 764
13	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
7	Nut	ASNA2528-3	Item 808
8	Pin	DAN6-6-3	Item 863
2	Nut	ASNA2528-3A	Item 908

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5	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 58, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBJAH Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 58, at STGR 35 LH, install:

Refer to Fig. A-GBJAH Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

14 On the Frame 58 flange, at STGR 35 LH, refer to Fig. A-GBJAH Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 58 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBJAH Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 58 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBJAH Sheet 02, View C and Fig. A-GBJAH Sheet 03, Section A-A.

1	Angle	E5347001120600	Item 24

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17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 24, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 24, refer to Fig. A-GBJAH Sheet 02, View C and Fig. A-GBJAH Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAH Sheet 04.

18 On the Frame 58 flange, at STGR 35 LH, remove:

1	Angle	E5347001120600	Item 24

19 Clean and deburr the new fastener holes in the Frame 58, STGR 35 LH and angle, Item 24, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 58 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBJAH Sheet 02, View C and Fig. A-GBJAH Sheet 03, Section A-A.

1	Angle	E5347001120600	Item 24

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-06	Item 656
1	Pin	DAN5-6-5X	Item 765
2	Collar	NSA5075-6	Item 806
1	Collar	DAN11-6X	Item 807
2	Pin	DAN5-6-5	Item 965

21 On the Frame 58 flange, at STGR 36 LH, refer to Fig. A-GBJAH Sheet 03, Section B-B, countersink the one fastener hole.

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22 On the Frame 58 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBJAH Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 58 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBJAH Sheet 02, View C and Fig. A-GBJAH Sheet 03, Section B-B.

1	Angle	E5347001120800	Item 26

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 26, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH to the angle, Item 26, refer to Fig. A-GBJAH Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAH Sheet 04.

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 26, to the Frame 58 flange, at STGR 36 LH, then transfer drill and ream the two holes from the Frame to the angle, Item 26, refer to Fig. A-GBJAH Sheet 02, View E.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAH Sheet 04.

26 On the Frame 58 flange, at STGR 36 LH, remove:

1	Angle	E5347001120800	Item 26

27 Clean and deburr the new fastener holes in the Frame 58, STGR 36 LH and angle, Item 26, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 58 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBJAH Sheet 02, View C and Fig. A-GBJAH Sheet 03, Section B-B.

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1	Angle	E5347001120800	Item 26	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
1	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	

29 On the Frame 58 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBJAH Sheet 02, View C and Fig. A-GBJAH Sheet 03, Section C-C.

1	Support	D5347032200600	Item (104)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Rivet	EN6081D7-10	Item 670	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

30 On the aft side of the Frame 58 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBJAH Sheet 02, View C.

1	Angle	D5347046824200	Item (125)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-08	Item 668	

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1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

31 On the Frame 58 flange, at STGR 39 LH, refer to Fig. A-GBJAH Sheet 03, Section D-D, countersink the one fastener hole.

32 On the Frame 58 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBJAH Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 58 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBJAH Sheet 02, View C and Fig. A-GBJAH Sheet 03, Section D-D.

1	Angle	E5347001124400	Item 70

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 70, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 70, refer to Fig. A-GBJAH Sheet 02, View C and Fig. A-GBJAH Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBJAH Sheet 04.

35 On the Frame 58 flange, at STGR 39 LH, remove:

1	Angle	E5347001124400	Item 70

36 Clean and deburr the new fastener holes in the Frame 58, STGR 39 LH and angle, Item 70, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

37 On the Frame 58 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBJAH Sheet 02, View C and Fig. A-GBJAH Sheet 03, Section D-D.

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1	Angle	E5347001124400	Item 70
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(12) Subtask 531364-831-212-015 - Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 59 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D08R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
28	E5347001021600	1	WEB	
30	E5347001121000	1	ANGLE	
32	E5347001121200	1	ANGLE	
72	E5347001124600	1	ANGLE	
363	EN6115K3-3	5	BOLT	
364	EN6115K3-4	2	BOLT	
365	EN6115K3-5	3	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	20	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	17	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	9	RIVET	(1)
669	EN6081D6-09	3	RIVET	(2)
764	DAN5-6-4X	3	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	21	COLLAR	
807	DAN11-6X	5	COLLAR	
808	ASNA2528-3	11	NUT	
863	DAN6-6-3	8	PIN	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	6	PIN	
965	DAN5-6-5	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBKAH Replacement of Webs and Angles at Frame 59	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBKAH Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 59, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347089120000	Item (18)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 59, at STGR 35 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

5	Rivet		Item (100)	Discard

3 From Frame 59, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347089020000	Item (19)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 59, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347088920400	Item (20)	Discard
1	Support	D5347032201000	Item (106)	Retain
1	Angle	D5347046824400	Item (127)	Retain
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 59.

Refer to NTM 51-10-01.

Refer to Fig. A-GBKAH Sheet 02, Views C and D.

1 On Frame 59, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 59, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 7 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 59, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBKAH Sheet 02 thru Fig. A-GBKAH Sheet 04.

1 On Frame 59, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBKAH Sheet 02, View C.

1	Shear Web	E5347001021600	Item 28

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 59 to the shear web, Item 28.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAH Sheet 04.

4 Drill the additional 17 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBKAH Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBKAH Sheet

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02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAH Sheet 04.

5 Transfer drill the tack hole from the Frame 59 between STGR 36 LH and STGR 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 59, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021600	Item 28

7 Clean and deburr the new fastener holes in Frame 59 and the shear web, Item 28, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBKAH Sheet 02, Views C and D.

a On Frame 59, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBKAH Sheet 02, View C.

1	Shear Web	E5347001021600	Item 28

b On Frame 59, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAH Sheet 02, View C.

c On Frame 59, between STGR 36 LH and STGR 37 LH, cold expand the 7 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAH Sheet 02, View C.

d On the top flange of Frame 59, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAH Sheet 02, View D.

9 On Frame 59, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021600	Item 28

10 Clean and deburr the cold expansion fastener holes in Frame 59 and the shear web, Item 28, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 59, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBKAH Sheet 02, View C.

1	Shear Web	E5347001021600	Item 28

with

4	Bolt	EN6115K3-3	Item 363
2	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
16	Rivet	EN6081D5-06	Item 656
17	Rivet	EN6081D6-06	Item 666
5	Rivet	EN6081D6-08	Item 668
3	Pin	DAN5-6-4X	Item 764
14	Collar	NSA5075-6	Item 806
3	Collar	DAN11-6X	Item 807

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6	Nut	ASNA2528-3	Item 808
8	Pin	DAN6-6-3	Item 863
6	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 Install 1 fastener in the flange of Frame 59, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBKAH Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 59, at STGR 35 LH, install:

Refer to Fig. A-GBKAH Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

14 On the Frame 59 flange, at STGR 35 LH, refer to Fig. A-GBKAH Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 59 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBKAH Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 59 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBKAH Sheet 02, View C and Fig. A-GBKAH Sheet 03, Section A-A.

1	Angle	E5347001121000	Item 30

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17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 30, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 30, refer to Fig. A-GBKAH Sheet 02, View C and Fig. A-GBKAH Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAH Sheet 04.

18 On the Frame 59 flange, at STGR 35 LH, remove:

1	Angle	E5347001121000	Item 30

19 Clean and deburr the new fastener holes in the Frame 59, STGR 35 LH and angle, Item 30, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 59 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBKAH Sheet 02, View C and Fig. A-GBKAH Sheet 03, Section A-A.

1	Angle	E5347001121000	Item 30

with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Collar	NSA5075-6	Item 806
3	Pin	DAN5-6-5	Item 965

21 On the Frame 59 flange, at STGR 36 LH, refer to Fig. A-GBKAH Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 59 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBKAH Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 59 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBKAH Sheet 02, View C and Fig. A-GBKAH Sheet 03, Section B-B.

1	Angle	E5347001121200	Item 32

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 32, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 32, refer to Fig. A-GBKAH Sheet 02, View C and Fig. A-GBKAH Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAH Sheet 04.

25 On the Frame 59 flange, at STGR 36 LH, remove:

1	Angle	E5347001121200	Item 32

26 Clean and deburr the new fastener holes in the Frame 59, STGR 36 LH and angle, Item 32, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 59 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBKAH Sheet 02, View C and Fig. A-GBKAH Sheet 03, Section B-B.

1	Angle	E5347001121200	Item 32

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D6-07	Item 667

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28 On the Frame 59 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBKAH Sheet 02, View C and Fig. A-GBKAH Sheet 03, Section C-C.

1	Support	D5347032201000	Item (106)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Bolt	EN6115K3-5	Item 365	
3	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
3	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 59 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBKAH Sheet 02, View C.

1	Angle	D5347046824400	Item (127)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

30 On the Frame 59 flange, at STGR 39 LH, refer to Fig. A-GBKAH Sheet 03, Section D-D, countersink the one fastener hole.

31 On the Frame 59 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBKAH Sheet 03, Section D-D.

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1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

32 On the Frame 59 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBKAH Sheet 02, View C and Fig. A-GBKAH Sheet 03, Section D-D.

1	Angle	E5347001124600	Item 72

33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 72, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 72, refer to Fig. A-GBKAH Sheet 02, View C and Fig. A-GBKAH Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBKAH Sheet 04.

34 On the Frame 59 flange, at STGR 39 LH, remove:

1	Angle	E5347001124600	Item 72

35 Clean and deburr the new fastener holes in the Frame 59, STGR 39 LH and angle, Item 72, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

36 On the Frame 59 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBKAH Sheet 02, View C and Fig. A-GBKAH Sheet 03, Section D-D.

1	Angle	E5347001124600	Item 72

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657

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2	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(13) Subtask 531364-831-213-014 - Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 60 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D08R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
34	E5347001021800	1	WEB	
38	E5347001121600	1	ANGLE	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
40	E5347001121800	1	ANGLE	
363	EN6115K3-3	5	BOLT	
365	EN6115K3-5	8	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
567	EN6069D6-07	8	RIVET	
656	EN6081D5-06	41	RIVET	
666	EN6081D6-06	25	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	4	RIVET	(2)
764	DAN5-6-4X	4	PIN	
765	DAN5-6-5X	1	PIN	
806	NSA5075-6	31	COLLAR	
807	DAN11-6X	5	COLLAR	
808	ASNA2528-3	14	NUT	
863	DAN6-6-3	12	PIN	
864	DAN6-6-4	5	PIN	
865	DAN6-6-5	5	PIN	
963	DAN5-6-3	1	PIN	
964	DAN5-6-4	4	PIN	
965	DAN5-6-5	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)

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ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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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.

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBLAA Replacement of Webs and Angles at Frame 60	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBLAA Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 60, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347085020000	Item (21)	Discard
	with			
14	Rivet		Item (100)	Discard

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2 From the top flange of Frame 60, at STGR 35 LH and from the frame flange between STGR 34 LH and STGR 35 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 60, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347085120000	Item (22)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 60, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347093120600	Item (23)	Discard
1	Support	D5347032201200	Item (108)	Retain
1	Angle	D5347046821200	Item (128)	Retain
1	Section-Connecting	D5347065420400	Item (136)	Retain
1	Shim	D5347044920000	Item (142)	Retain
1	Shim	D5347044920600	Item (143)	Retain
	with			
77	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 60.

Refer to NTM 51-10-01.

Refer to Fig. A-GBLAA Sheet 02, Views C and D.

1 On Frame 60, at STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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2 On Frame 60, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 60, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBLAA Sheet 02 thru Fig. A-GBLAA Sheet 04.

1 On Frame 60, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBLAA Sheet 02, View C.

1	Shear Web	E5347001021800	Item 34

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 60 to the shear web, Item 34.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAA Sheet 04.

4 Drill the additional 38 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBLAA Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBLAA Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAA Sheet 04.

5 Transfer drill the tack hole from the Frame 60 between STGR 36 LH and STGR 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 60, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021800	Item 34

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7 Clean and deburr the new fastener holes in Frame 60 and the shear web, Item 34, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBLAA Sheet 02, Views C and D.

a On Frame 60, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBLAA Sheet 02, View C.

1	Shear Web	E5347001021800	Item 34

b On Frame 60, at STGR 35 LH, cold expand the 4 holes for the fasteners, Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAA Sheet 02, View C.

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c On Frame 60, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAA Sheet 02, View C.

d On the top flange of Frame 60, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAA Sheet 02, View D.

9 On Frame 60, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001021800	Item 34

10 Clean and deburr the cold expansion fastener holes in Frame 60 and the shear web, Item 34, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 60, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBLAA Sheet 02, View C.

1	Shear Web	E5347001021800	Item 34

with

5	Bolt	EN6115K3-3	Item 363
8	Rivet	EN6069D6-07	Item 567
37	Rivet	EN6081D5-06	Item 656
25	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
4	Pin	DAN5-6-4X	Item 764
4	Collar	DAN11-6X	Item 807
12	Collar	NSA5075-6	Item 806
5	Nut	ASNA2528-3	Item 808
12	Pin	DAN6-6-3	Item 863

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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12 On the top flange of Frame 60, at STGR 35 LH, install:

Refer to Fig. A-GBLAA Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

13 On the Frame 60 flange, at STGR 35 LH, refer to Fig. A-GBLAA Sheet 03, Section B-B, countersink the one fastener hole.

14 On the Frame 60 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBLAA Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 60 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBLAA Sheet 02, View C and Fig. A-GBLAA Sheet 03, Section B-B.

1	Angle	E5347001121600	Item 38

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 38, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH to the angle, Item 38, refer to Fig. A-GBLAA Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAA Sheet 04.

17 On the Frame 60 flange, at STGR 35 LH, remove:

1	Angle	E5347001121600	Item 38

18 Clean and deburr the new fastener holes in the STGR 35 LH and angle, Item 38, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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19 On the Frame 60 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBLAA Sheet 02, View C and Fig. A-GBLAA Sheet 03, Section B-B.

1	Angle	E5347001121600	Item 38
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
4	Bolt	EN6115K3-5	Item 365
2	Rivet	EN6081D5-06	Item 656
4	Nut	ASNA2528-3	Item 808

20 On the Frame 60 flange, at STGR 36 LH, refer to Fig. A-GBLAA Sheet 03, Section C-C, countersink the one fastener hole.

21 On the Frame 60 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBLAA Sheet 03, Section C-C.

1	Rivet	EN6069D5-05	Item 555
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

22 On the Frame 60 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBLAA Sheet 02, View C and Fig. A-GBLAA Sheet 03, Section C-C.

1	Angle	E5347001121800	Item 40

23 Transfer drill and ream one new hole from the pilot hole of the angle, Item 40, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 40, refer to Fig. A-GBLAA Sheet 02, View C and Fig. A-GBLAA Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAA Sheet 04.

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24 On the Frame 60 flange, at STGR 36 LH, remove:

1	Angle	E5347001121800	Item 40

25 Clean and deburr the new fastener holes in the Frame 60, STGR 36 LH and angle, Item 40, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

26 On the Frame 60 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBLAA Sheet 02, View C and Fig. A-GBLAA Sheet 03, Section C-C.

1	Angle	E5347001121800	Item 40

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D6-07	Item 667

27 On the Frame 60 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBLAA Sheet 02, View C and Fig. A-GBLAA Sheet 03, Section D-D.

1	Support	D5347032201200	Item (108)	Retained at removal
1	Section-Connecting	D5347065420400	Item (136)	Retained at removal
1	Shim	D5347044920000	Item (142)	Retained at removal
1	Shim	D5347044920600	Item (143)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	
19	Collar	NSA5075-6	Item 806	
4	Nut	ASNA2528-3	Item 808	
5	Pin	DAN6-6-4	Item 864	
5	Pin	DAN6-6-5	Item 865	
1	Pin	DAN5-6-3	Item 963	
4	Pin	DAN5-6-4	Item 964	
4	Pin	DAN5-6-5	Item 965	

28 On the aft side of the Frame 60 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBLAA Sheet 02, View C.

1	Angle	D5347046821200	Item (128)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(14) Subtask 531364-831-214-014 - Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 61 from Stringer 33 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D08R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
42	E5347001022000	1	WEB	
44	E5347001122000	1	ANGLE	
46	E5347001122200	1	ANGLE	
48	E5347001122400	1	ANGLE	
74	E5347001124800	1	ANGLE	
363	EN6115K3-3	6	BOLT	
364	EN6115K3-4	3	BOLT	
365	EN6115K3-5	4	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	4	RIVET	
567	EN6069D6-07	20	RIVET	
656	EN6081D5-06	36	RIVET	
657	EN6081D5-07	2	RIVET	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
666	EN6081D6-06	23	RIVET	
667	EN6081D6-07	10	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	6	RIVET	(2)
763	DAN5-6-3X	4	PIN	
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	13	COLLAR	
808	ASNA2528-3	14	NUT	
863	DAN6-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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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.

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBMAH Replacement of Webs and Angles at Frame 61	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBMAH Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 61, between STGR 33 LH and STGR 34 LH, remove:

1	Clip	D5347091620200	Item (24)	Discard
	with			
12	Rivet		Item (100)	Discard
	or			
13	Rivet		Item (100)	Discard

NOTE: Depending on installation on aircraft.

2 From Frame 61, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347090620000	Item (25)	Discard
	with			
13	Rivet		Item (100)	Discard

3 From the top flange of Frame 61, between STGR 34 LH and STGR 35 LH and from the frame flange between STGR 34 LH and STGR 35 LH, remove:

11	Rivet		Item (100)	Discard

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4 From Frame 61, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347090720000	Item (26)	Discard
	with			
13	Rivet		Item (100)	Discard

5 From Frame 61, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347090820400	Item (27)	Discard
1	Support	D5347032201600	Item (109)	Retain
1	Angle	D5347046821400	Item (130)	Retain
	with			
65	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 61.

Refer to NTM 51-10-01.

Refer to Fig. A-GBMAH Sheet 02, Views C and E.

1 On Frame 61, at STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 61, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 61, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBMAH Sheet 02 thru Fig. A-GBMAH Sheet 04.

1 On Frame 61, between STGR 33 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBMAH Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 61 to the shear web, Item 42.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAH Sheet 04.

4 Drill the additional 31 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBMAH Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBMAH Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAH Sheet 04.

5 Transfer drill the tack hole from the Frame 61 between STGR 36 LH and STGR 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

6 On Frame 61, between STGR 33 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022000	Item 42

7 Clean and deburr the new fastener holes in Frame 61 and the shear web, Item 42, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

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Refer to Fig. A-GBMAH Sheet 02, Views C and E.

a On Frame 61, between STGR 33 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBMAH Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

b On Frame 61, at STGR 35 LH, cold expand the 4 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAH Sheet 02, View E.

c On Frame 61, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAH Sheet 02, View C.

d On the top flange of Frame 61, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAH Sheet 02, View E.

9 On Frame 61, between STGR 33 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022000	Item 42

10 Clean and deburr the cold expansion fastener holes in Frame 61 and the shear web, Item 42, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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11 At Frame 61, between STGR 33 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBMAH Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42
	with		
5	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
20	Rivet	EN6069D6-07	Item 567
28	Rivet	EN6081D5-06	Item 656
22	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
4	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
4	Pin	DAN6-6-3	Item 863
	use		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

12 On Frame 61, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBMAH Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

13 On the top flange of Frame 61, at STGR 35 LH, install:

Refer to Fig. A-GBMAH Sheet 02, View E.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

14 On the Frame 61 flange, at STGR 34 LH, refer to Fig. A-GBMAH Sheet 03, Section A-A, countersink the one fastener hole.

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15 On the Frame 61 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBMAH Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 61 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBMAH Sheet 02, View C and Fig. A-GBMAH Sheet 03, Section A-A.

1	Angle	E5347001122000	Item 44

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 44, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH and the three holes from the Frame to the angle, Item 44, refer to Fig. A-GBMAH Sheet 02, View C and Fig. A-GBMAH Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAH Sheet 04.

18 On the Frame 61 flange, at STGR 34 LH, remove:

1	Angle	E5347001122000	Item 44

19 Clean and deburr the new fastener holes in the Frame 61, STGR 34 LH and angle, Item 44, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 61 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBMAH Sheet 02, View C and Fig. A-GBMAH Sheet 03, Section A-A.

1	Angle	E5347001122000	Item 44

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

If necessary, close the rivet hole in the frame flange at STGR 34 LH with:

1	Rivet	EN6081D6-06	Item 666

NOTE: Depending on installation on aircraft.

21 On the Frame 61 flange, at STGR 35 LH, refer to Fig. A-GBMAH Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 61 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBMAH Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 61 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBMAH Sheet 02, View C and Fig. A-GBMAH Sheet 03, Section B-B.

1	Angle	E5347001122200	Item 46

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 46, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the four holes from the Frame to the angle, Item 46, refer to Fig. A-GBMAH Sheet 02, View C and Fig. A-GBMAH Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAH Sheet 04.

25 On the Frame 61 flange, at STGR 35 LH, remove:

1	Angle	E5347001122200	Item 46

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26 Clean and deburr the new fastener holes in the Frame 61, STGR 35 LH and angle, Item 46, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 61 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBMAH Sheet 02, View C and Fig. A-GBMAH Sheet 03, Section B-B.

1	Angle	E5347001122200	Item 46

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
4	Rivet	EN6081D6-07	Item 667

28 On the Frame 61 flange, at STGR 36 LH, refer to Fig. A-GBMAH Sheet 03, Section C-C, countersink the one fastener hole.

29 On the Frame 61 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBMAH Sheet 03, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

30 On the Frame 61 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBMAH Sheet 02, View C and Fig. A-GBMAH Sheet 03, Section C-C.

1	Angle	E5347001122400	Item 48

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31 Transfer drill and ream one new hole from the pilot hole of the angle, Item 48, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 48, refer to Fig. A-GBMAH Sheet 02, View C and Fig. A-GBMAH Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAH Sheet 04.

32 On the Frame 61 flange, at STGR 36 LH, remove:

1	Angle	E5347001122400	Item 48

33 Clean and deburr the new fastener holes in the Frame 61, STGR 36 LH and angle, Item 48, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

34 On the Frame 61 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBMAH Sheet 02, View C and Fig. A-GBMAH Sheet 03, Section C-C.

1	Angle	E5347001122400	Item 48

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D5-07	Item 657
3	Rivet	EN6081D6-07	Item 667

35 On the Frame 61 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBMAH Sheet 02, View C and Fig. A-GBMAH Sheet 03, Section D-D.

1	Support	D5347032201600	Item (109)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	
4	Pin	DAN5-6-3X	Item 763	
4	Collar	DAN11-6X	Item 807	
4	Nut	ASNA2528-3	Item 808	

36 On the Frame 61 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBMAH Sheet 02, View C.

1	Angle	D5347046821400	Item (130)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

37 On the Frame 61 flange, at STGR 39 LH, refer to Fig. A-GBMAH Sheet 03, Section E-E., countersink the one fastener hole.

38 On the Frame 61 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBMAH Sheet 03, Section E-E.

1	Rivet	EN6069D5-05	Item 555	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

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39 On the Frame 61 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBMAH Sheet 02, View C and Fig. A-GBMAH Sheet 03, Section E-E.

1	Angle	E5347001124800	Item 74

40 Transfer drill and ream one new hole from the pilot hole of the angle, Item 74, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the four holes from the Frame to the angle, Item 74, refer to Fig. A-GBMAH Sheet 02, View C and Fig. A-GBMAH Sheet 03, Section E-E.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAH Sheet 04.

41 On the Frame 61 flange, at STGR 39 LH, remove:

1	Angle	E5347001124800	Item 74

42 Clean and deburr the new fastener holes in the Frame 61, STGR 39 LH and angle, Item 74, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

43 On the Frame 61 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBMAH Sheet 02, View C and Fig. A-GBMAH Sheet 03, Section E-E.

1	Angle	E5347001124800	Item 74

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

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(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(15) Subtask 531364-831-215-014 - Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 62 from Stringer 32 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D08R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
50	E5347001022200	1	WEB	
52	E5347001122600	1	ANGLE	
54	E5347001122800	1	ANGLE	
56	E5347001123000	1	ANGLE	
58	E5347001123200	1	ANGLE	
76	E5347001125000	1	ANGLE	
363	EN6115K3-3	6	BOLT	
364	EN6115K3-4	3	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
365	EN6115K3-5	4	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	5	RIVET	
567	EN6069D6-07	12	RIVET	
656	EN6081D5-06	45	RIVET	
657	EN6081D5-07	7	RIVET	
666	EN6081D6-06	21	RIVET	
667	EN6081D6-07	7	RIVET	
668	EN6081D6-08	16	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	5	PIN	
765	DAN5-6-5X	3	PIN	
806	NSA5075-6	26	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	14	NUT	
863	DAN6-6-3	16	PIN	
864	DAN6-6-4	1	PIN	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	
965	DAN5-6-5	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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.

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NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBNAH Replacement of Webs and Angles at Frame 62	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBNAH Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 62, between STGR 32 LH and STGR 33 LH, remove:

1	Clip	D5347093420200	Item (28)	Discard
	with			
14	Rivet		Item (100)	Discard
	or			
15	Rivet		Item (100)	Discard

NOTE: Depending on installation on aircraft

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2 From Frame 62, between STGR 33 LH and STGR 34 LH, remove:

1	Clip	D5347084020000	Item (29)	Discard
	with			
13	Rivet		Item (100)	Discard

3 From Frame 62, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347084120000	Item (30)	Discard
	with			
11	Rivet		Item (100)	Discard

4 From the top flange of Frame 62, at STGR 34 LH and from the frame flange between STGR 32 LH and STGR 35 LH, remove:

13	Rivet		Item (100)	Discard

5 From Frame 62, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347084220000	Item (31)	Discard
	with			
11	Rivet		Item (100)	Discard

6 From Frame 62, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347084820400	Item (32)	Discard
1	Support	D5347032201800	Item (111)	Retain
1	Angle	D5347046821600	Item (131)	Retain
	with			
58	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 62.

Refer to NTM 51-10-01.

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Refer to Fig. A-GBNAH Sheet 02, View C and Fig. A-GBNAH Sheet 03, View F.

1 On Frame 62, between STGR 34 LH and STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 62, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBNAH Sheet 02 thru Fig. A-GBNAH Sheet 06.

1 On Frame 62, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBNAH Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 62 to the shear web, Item 50.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAH Sheet 06.

4 On Frame 62, between STGR 34 LH and STGR 37 LH, drill the additional 42 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBNAH Sheet 03, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBNAH Sheet 03.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAH

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Sheet 06.

5 On Frame 62, between STGR 38 LH and STGR 39 LH, drill the additional rivet hole to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBNAH Sheet 03, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBNAH Sheet 03.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAH Sheet 06.

6 Transfer drill the tack hole from the Frame 62 between STGR 36 LH and STGR 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

7 On Frame 62, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022200	Item 50

8 Clean and deburr the new fastener holes in Frame 62 and the shear web, Item 50, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBNAH Sheet 02, Views C and D.

a On Frame 62, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBNAH Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

b On Frame 62, between STGR 34 LH and STGR 35 LH, cold expand the 4 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAH Sheet 02, View C.

c On Frame 62, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAH Sheet 02, View C.

d On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

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FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAH Sheet 03, View F.

10 On Frame 62, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022200	Item 50

11 Clean and deburr the cold expansion fastener holes in Frame 62 and the shear web, Item 50, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 62, between STGR 32 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBNAH Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

with

5	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
12	Rivet	EN6069D6-07	Item 567
35	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D5-07	Item 657

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20	Rivet	EN6081D6-06	Item 666
13	Rivet	EN6081D6-08	Item 668
5	Pin	DAN5-6-4X	Item 764
21	Collar	NSA5075-6	Item 806
5	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
16	Pin	DAN6-6-3	Item 863
1	Pin	DAN6-6-4	Item 864
1	Pin	DAN5-6-3	Item 963
3	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 On Frame 62, between STGR 34 LH and STGR 35 LH, wet install:

Refer to Fig. A-GBNAH Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBNAH Sheet 03, View F.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

15 On the Frame 62 flange, at STGR 33 LH, refer to Fig. A-GBNAH Sheet 04, Section A-A, countersink the one fastener hole.

16 On the Frame 62 flange, at STGR 33 LH, close the rivet hole in STGR 33 LH with:

Refer to Fig. A-GBNAH Sheet 04, Section A-A.

1	Rivet	EN6069D5-05	Item 555

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 62 flange, at STGR 33 LH, put in position:

Refer to Fig. A-GBNAH Sheet 02, View C and Fig. A-GBNAH Sheet 04, Section A-A.

1	Angle	E5347001122600	Item 52

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 52, to the STGR 33 LH, then transfer drill and ream the other hole from STGR 33 LH and the three holes from the Frame to the angle, Item 52, refer to Fig. A-GBNAH Sheet 02, View C and Fig. A-GBNAH Sheet 04, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAH Sheet 06.

19 On the Frame 62 flange, at STGR 33 LH, remove:

1	Angle	E5347001122600	Item 52

20 Clean and deburr the new fastener holes in the Frame 62, STGR 33 LH and angle, Item 52, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 62 flange, at STGR 33 LH, wet install:

Refer to Fig. A-GBNAH Sheet 02, View C and Fig. A-GBNAH Sheet 04, Section A-A.

1	Angle	E5347001122600	Item 52

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669

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1	Collar	NSA5075-6	Item 806
1	Pin	DAN5-6-5	Item 965

If necessary, close the rivet hole in the frame flange at STGR 33 LH with:

1	Rivet	EN6081D6-06	Item 666

22 On the Frame 62 flange, at STGR 34 LH, refer to Fig. A-GBNAH Sheet 04, Section B-B, countersink the one fastener hole.

23 On the Frame 62 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBNAH Sheet 04, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 62 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBNAH Sheet 02, View C and Fig. A-GBNAH Sheet 04, Section B-B.

1	Angle	E5347001122800	Item 54

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 54, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH and the three holes from the Frame to the angle, Item 54, refer to Fig. A-GBNAH Sheet 02, View C and Fig. A-GBNAH Sheet 04, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAH Sheet 06.

26 On the Frame 62 flange, at STGR 34 LH, remove:

1	Angle	E5347001122800	Item 54

27 Clean and deburr the new fastener holes in the Frame 62, STGR 34 LH and angle, Item 54, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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28 On the Frame 62 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBNAH Sheet 02, View C and Fig. A-GBNAH Sheet 04, Section B-B.

1	Angle	E5347001122800	Item 54

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

29 On the Frame 62 flange, at STGR 34 LH, install:

Refer to Fig. A-GBNAH Sheet 02, View C.

1	Rivet	EN6081D6-07	Item 667

30 On the Frame 62 flange, at STGR 35 LH, refer to Fig. A-GBNAH Sheet 04, Section C-C, countersink the one fastener hole.

31 On the Frame 62 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBNAH Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

32 On the Frame 62 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBNAH Sheet 02, View C and Fig. A-GBNAH Sheet 04, Section C-C.

1	Angle	E5347001123000	Item 56

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33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 56, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the five holes form the Frame to the angle, Item 56, refer to Fig. A-GBNAH Sheet 02, View C and Fig. A-GBNAH Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAH Sheet 06.

34 On the Frame 62 flange, at STGR 35 LH, remove:

1	Angle	E5347001123000	Item 56

35 Clean and deburr the new fastener holes in the Frame 62, STGR 35 LH and angle, Item 56, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

36 On the Frame 62 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBNAH Sheet 02, View C and Fig. A-GBNAH Sheet 04, Section C-C.

1	Angle	E5347001123000	Item 56

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

37 On the Frame 62 flange, at STGR 36 LH, refer to Fig. A-GBNAH Sheet 04, Section D-D, countersink the one fastener hole.

38 On the Frame 62 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBNAH Sheet 04, Section D-D.

1	Rivet	EN6069D5-05	Item 555

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

39 On the Frame 62 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBNAH Sheet 02, View C and Fig. A-GBNAH Sheet 04, Section D-D.

1	Angle	E5347001123200	Item 58

40 Transfer drill and ream one new hole from the pilot hole of the angle, Item 58, to the STGR 36 LH, then transfer drill and ream the other hole form STGR 36 LH and the five holes from the Frame to the angle, Item 58, refer to Fig. A-GBNAH Sheet 02, View C and Fig. A-GBNAH Sheet 04, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAH Sheet 06.

41 On the Frame 62 flange, at STGR 36 LH, remove:

1	Angle	E5347001123200	Item 58

42 Clean and deburr the new fastener holes in the Frame 62, STGR 36 LH and angle, Item 58, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

43 On the Frame 62 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBNAH Sheet 02, View C and Fig. A-GBNAH Sheet 04, Section D-D.

1	Angle	E5347001123200	Item 58

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

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44 On the Frame 62 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBNAH Sheet 02, View C and Fig. A-GBNAH Sheet 05, Section E-E.

1	Support	D5347032201800	Item (111)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	

45 On the aft side of the Frame 62 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBNAH Sheet 02, View C.

1	Angle	D5347046821600	Item (131)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

46 On the Frame 62 flange, at STGR 39 LH, refer to Fig. A-GBNAH Sheet 05, Section F-F, countersink the one fastener hole.

47 On the Frame 62 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBNAH Sheet 05, Section F-F.

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1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

48 On the Frame 62 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBNAH Sheet 02, View C and Fig. A-GBNAH Sheet 05, Section F-F.

1	Angle	E5347001125000	Item 76

49 Transfer drill and ream one new hole from the pilot hole of the angle, Item 76, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 76, refer to Fig. A-GBNAH Sheet 02, View C and Fig. A-GBNAH Sheet 05, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBNAH Sheet 04.

50 On the Frame 62 flange, at STGR 39 LH, remove:

1	Angle	E5347001125000	Item 76

51 Clean and deburr the new fastener holes in the Frame 62, STGR 39 LH and the angle, Item 76, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

52 On the Frame 62 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBNAH Sheet 02, View C and Fig. A-GBNAH Sheet 05, Section F-F.

1	Angle	E5347001125000	Item 76

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656

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2	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(16) Subtask 531364-831-216-014 - Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 63 from Stringer 32 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D08R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
60	E5347001022400	1	WEB	
62	E5347001123400	1	ANGLE	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
64	E5347001123600	2	ANGLE	
78	E5347001125200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
365	EN6115K3-5	8	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	4	RIVET	
567	EN6069D6-07	10	RIVET	
656	EN6081D5-06	43	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	22	RIVET	
667	EN6081D6-07	6	RIVET	
668	EN6081D6-08	12	RIVET	(1)
669	EN6081D6-09	7	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
806	NSA5075-6	22	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	13	NUT	
863	DAN6-6-3	13	PIN	
864	DAN6-6-4	1	PIN	
963	DAN5-6-3	8	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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.

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NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBPAH Replacement of Webs and Angles at Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBPAH Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 63, at STGR 33 LH, remove:

1	Shim	D5347032020200	Item (132)	Retain
1	Sheet-Support	D5347109620000	Item (133)	Retain
	with			
7	Rivet		Item (100)	Discard

2 From Frame 63, between STGR 32 LH and STGR 34 LH, remove:

1	Clip	D5347082820000	Item (33)	Discard
	with			

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21	Rivet		Item (100)	Discard

3 From the top flange of Frame 63, at STGR 34 LH and from the frame flange between STGR 33 LH and STGR 34 LH, remove:

5	Rivet		Item (100)	Discard

4 From Frame 63, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347079220000	Item (34)	Discard
	with			
10	Rivet		Item (100)	Discard

5 From Frame 63, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347079920000	Item (35)	Discard
	with			
11	Rivet		Item (100)	Discard

6 From Frame 63, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347082920200	Item (36)	Discard
1	Support	D5347032202000	Item (114)	Retain
1	Angle	D5347046821800	Item (115)	Retain
	with			
54	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 63.

Refer to NTM 51-10-01.

Refer to Fig. A-GBPAH Sheet 02, Views C and D.

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1 On Frame 63, at STGR 34 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 63, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 8 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 63, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBPAH Sheet 02 thru Fig. A-GBPAH Sheet 06.

1 On Frame 63, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBPAH Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 63 to the shear web, Item 60.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAH Sheet 06.

4 On Frame 63, between STGR 34 LH and STGR 37 LH, drill the additional 41 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBPAH Sheet 03, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBPAH Sheet 03.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAH Sheet 06.

5 Transfer drill the tack hole from the Frame 63 between STGR 36 LH and STGR 37 LH to the shear web with 6.100mm (0.2401in) dia. drill.

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6 On Frame 63, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022400	Item 60

7 Clean and deburr the new fastener holes in Frame 63 and the shear web, Item 60, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

8 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBPAH Sheet 02, Views C and D.

a On Frame 63, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBPAH Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

b On Frame 63, at STGR 34 LH, cold expand the 4 holes for the fasteners, Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAH Sheet 02, View C.

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c On Frame 63, between STGR 36 LH and STGR 37 LH, cold expand the 8 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAH Sheet 02, View C.

d On the top flange of Frame 63, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAH Sheet 02, View D.

9 On Frame 63, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022400	Item 60

10 Clean and deburr the cold expansion fastener holes in Frame 63 and the shear web, Item 60, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

11 At Frame 63, between STGR 32 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBPAH Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

with

4	Bolt	EN6115K3-3	Item 363
10	Rivet	EN6069D6-07	Item 567
35	Rivet	EN6081D5-06	Item 656
22	Rivet	EN6081D6-06	Item 666
10	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
14	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
4	Nut	ASNA2528-3	Item 808
13	Pin	DAN6-6-3	Item 863
1	Pin	DAN6-6-4	Item 864

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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12 On the Frame 63 flange, at STGR 33 LH, wet install:

Refer to Fig. A-GBPAH Sheet 02, View C and Fig. A-GBPAH Sheet 04, Section A-A.

1	Shim	D5347032020200	Item (132)	Retained at removal
1	Sheet-Support	D5347109620000	Item (133)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

3	Rivet	EN6081D6-09	Item 669
4	Collar	NSA5075-6	Item 806
4	Pin	DAN5-6-3	Item 963

13 On the Frame 63 flange, at STGR 34 LH, refer to Fig. A-GBPAH Sheet 04, Section B-B, countersink the one fastener hole.

14 On the Frame 63 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBPAH Sheet 04, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

15 On the Frame 63 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBPAH Sheet 02, View C and Fig. A-GBPAH Sheet 04, Section B-B.

1	Angle	E5347001123400	Item 62

16 Transfer drill and ream one new hole from the pilot hole of the angle, Item 62, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH to the angle, Item 62, refer to Fig. A-GBPAH Sheet 04, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAH Sheet 06.

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17 On the Frame 63 flange, at STGR 34 LH, remove:

1	Angle	E5347001123400	Item 62

18 Clean and deburr the new fastener holes in the STGR 34 LH and angle, Item 62, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

19 On the Frame 63 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBPAH Sheet 02, View C and Fig. A-GBPAH Sheet 04, Section B-B.

1	Angle	E5347001123400	Item 62

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

4	Bolt	EN6115K3-5	Item 365
2	Rivet	EN6081D5-06	Item 656
4	Nut	ASNA2528-3	Item 808

20 On the top flange of Frame 63, at STGR 35 LH, install:

Refer to Fig. A-GBPAH Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

21 On the Frame 63 flange, at STGR 35 LH, refer to Fig. A-GBPAH Sheet 04, Section C-C, countersink the one fastener hole.

22 On the Frame 63 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBPAH Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 63 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBPAH Sheet 02, View C and Fig. A-GBPAH Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 64, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the five holes form the Frame to the angle, Item 64, refer to Fig. A-GBPAH Sheet 02, View C and Fig. A-GBPAH Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAH Sheet 06.

25 On the Frame 63 flange, at STGR 35 LH, remove:

1	Angle	E5347001123600	Item 64

26 Clean and deburr the new fastener holes in the Frame 63, STGR 35 LH and angle, Item 64, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 63 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBPAH Sheet 02, View C and Fig. A-GBPAH Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

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28 On the Frame 63 flange, at STGR 36 LH, refer to Fig. A-GBPAH Sheet 04, Section C-C, countersink the one fastener hole.

29 On the Frame 63 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBPAH Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

30 On the Frame 63 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBPAH Sheet 02, View C and Fig. A-GBPAH Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

31 Transfer drill and ream one new hole from the pilot hole of the angle, Item 64, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 64, refer to Fig. A-GBPAH Sheet 02, View C and Fig. A-GBPAH Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAH Sheet 06.

32 On the Frame 63 flange, at STGR 36 LH, remove:

1	Angle	E5347001123600	Item 64

33 Clean and deburr the new fastener holes in the Frame 63, STGR 36 LH and angle, Item 64, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

34 On the Frame 63 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBPAH Sheet 02, View C and Fig. A-GBPAH Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	

35 On the Frame 63 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBPAH Sheet 02, View C and Fig. A-GBPAH Sheet 05, Section D-D.

1	Support	D5347032202000	Item (114)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	

36 On the Frame 63 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBPAH Sheet 02, View C.

1	Angle	D5347046821800	Item (115)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-08	Item 668	

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1	Pin	DAN5-6-5X	Item 765
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

37 On the Frame 63 flange, at STGR 39 LH, refer to Fig. A-GBPAH Sheet 05, Section E-E, countersink the one fastener hole.

38 On the Frame 63 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBPAH Sheet 05, Section E-E.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

39 On the Frame 63 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBPAH Sheet 02, View C and Fig. A-GBPAH Sheet 05, Section E-E.

1	Angle	E5347001125200	Item 78

40 Transfer drill and ream one new hole from the pilot hole of the angle, Item 78, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 78, refer to Fig. A-GBPAH Sheet 02, View C and Fig. A-GBPAH Sheet 05, Section E-E.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAH Sheet 04.

41 On the Frame 63 flange, at STGR 39 LH, remove:

1	Angle	E5347001125200	Item 78

42 Clean and deburr the new fastener holes in the Frame 63, STGR 39 LH and angle, Item 78, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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43 On the Frame 63 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBPAH Sheet 02, View C and Fig. A-GBPAH Sheet 05, Section E-E.

1	Angle	E5347001125200	Item 78
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(17) Subtask 531364-831-217-014 - Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 Stringer 38 LH
To	160	Work location	from Frame 60 to Frame 63 Stringer 38 LH

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Manpower Resources	
Manhours	6.50
Minimum number of person	2
Subtask elapsed time	6.50
Skills	AIRFRAME

Material necessary to do the job

Kit 531364D08R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
544	EN6069D4-04	14	RIVET	
655	EN6081D5-05	39	RIVET	
656	EN6081D5-06	127	RIVET	
657	EN6081D5-07	40	RIVET	
764	DAN5-6-4X	4	PIN	
765	DAN5-6-5X	4	PIN	
766	DAN5-6-6X	6	PIN	
806	NSA5075-6	10	COLLAR	
807	DAN11-6X	24	COLLAR	
864	DAN6-6-4	3	PIN	
865	DAN6-6-5	7	PIN	
875	DAN6-6-5X	4	PIN	
876	DAN6-6-6X	3	PIN	
877	DAN6-6-7X	3	PIN	

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	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12 53-41-14
Fig. A-GBQAA Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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(a) Install the shear plates.

Refer to Fig. A-GBQAA Sheet 01 thru Fig. A-GBQAA Sheet 06.

1 Between Frame 49 and Frame 50, on STGR 38 LH and on the bracket at Frame 49 and bracket, Item 66, put in position:

Refer to Fig. A-GBQAA Sheet 02, View D.

1	Plate-Shear	D5347456300000	Item (139)	Retained at removal

2 Transfer drill and ream the three holes from the shear plate, Item (139), to the bracket, Item 66, refer to Fig. A-GBQAA Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAA Sheet 06.

3 Between Frame 49 and Frame 50, on STGR 38 LH, remove:

1	Plate-Shear	D5347456300000	Item (139)	Retain

4 Between Frame 49 and Frame 50, on STGR 38 LH, clean and deburr the new fastener holes in the bracket, Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

5 Between Frame 49 and Frame 50, on STGR 38 LH and on the bracket at Frame 49 and bracket, Item 66, wet install:

Refer to Fig. A-GBQAA Sheet 02, View D.

1	Plate-Shear	D5347456300000	Item (139)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

6	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D5-07	Item 657

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6 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item (140), put in position:

Refer to Fig. A-GBQAA Sheet 02, View D.

1	Plate-Shear	D5347471500200	Item (117)	Retained at removal

7 Transfer drill and ream the three holes from the shear plate, Item (117), to the bracket, Item 65, refer to Fig. A-GBQAA Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAA Sheet 06.

8 Between Frame 50 and Frame 51, on STGR 38 LH, remove:

1	Plate-Shear	D5347471500200	Item (117)	Retain

9 Between Frame 50 and Frame 51, on STGR 38 LH, clean and deburr the new fastener holes in the bracket, Item 65, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

10 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item (140), wet install:

Refer to Fig. A-GBQAA Sheet 02, View D.

1	Plate-Shear	D5347471500200	Item (117)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-04	Item 544
6	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D5-07	Item 657

11 Between Frame 52 and Frame 53, on STGR 38 LH and on the brackets, Item (116) and Item (120), wet install:

Refer to Fig. A-GBQAA Sheet 03, View D.

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1	Plate Assy-Shear	D5347049100200	Item (119)	Retained at removal
1	Section-Connecting	D5347065020200	Item (135)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6069D4-04	Item 544	
6	Rivet	EN6081D5-05	Item 655	
18	Rivet	EN6081D5-06	Item 656	
6	Pin	DAN5-6-6X	Item 766	
16	Collar	DAN11-6X	Item 807	
4	Pin	DAN6-6-5X	Item 875	
3	Pin	DAN6-6-6X	Item 876	
3	Pin	DAN6-6-7X	Item 877	

12 Between Frame 54 and Frame 55, on STGR 38 LH and on the brackets, Item (121) and Item (120), wet install:

Refer to Fig. A-GBQAA Sheet 04, View H.

1	Plate Assy-Shear	D5347048800400	Item (122)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6069D4-04	Item 544	
6	Rivet	EN6081D5-05	Item 655	
20	Rivet	EN6081D5-06	Item 656	

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13 Between Frame 56 and Frame 57, on STGR 38 LH and on the brackets, Item (121) and Item (118), wet install:

Refer to Fig. A-GBQAA Sheet 04, View K.

1	Plate-Shear	D5347048900400	Item (124)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6069D4-04	Item 544	
6	Rivet	EN6081D5-05	Item 655	
20	Rivet	EN6081D5-06	Item 656	

14 Between Frame 58 and Frame 59, on STGR 38 LH and on the brackets, Item (125) and Item (127), wet install:

Refer to Fig. A-GBQAA Sheet 05, View M.

1	Plate-Shear	D5347049200000	Item (126)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6069D4-04	Item 544	
6	Rivet	EN6081D5-05	Item 655	
20	Rivet	EN6081D5-06	Item 656	

15 Between Frame 60 and Frame 61, on STGR 38 LH and on the brackets, Item (128) and Item (130), wet install:

Refer to Fig. A-GBQAA Sheet 05, View P.

1	Plate-Shear	D5347049300000	Item (129)	Retained at removal
1	Section-Connecting	D5347065420400	Item (136)	Retained at removal

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6069D4-04	Item 544	
8	Rivet	EN6081D5-05	Item 655	
17	Rivet	EN6081D5-06	Item 656	
4	Pin	DAN5-6-4X	Item 764	
4	Pin	DAN5-6-5X	Item 765	
10	Collar	NSA5075-6	Item 806	
8	Collar	DAN11-6X	Item 807	
3	Pin	DAN6-6-4	Item 864	
7	Pin	DAN6-6-5	Item 865	

16 Between Frame 62 and Frame 63, on STGR 38 LH and on the brackets, Item (131) and Item (115), wet install:

Refer to Fig. A-GBQAA Sheet 06, View R.

1	Plate-Shear	D5347049400000	Item (123)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-04	Item 544
7	Rivet	EN6081D5-05	Item 655
20	Rivet	EN6081D5-06	Item 656

(b) Install the corner profiles.

In accordance with SRM 53-41-14.

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1 Between Frame 48 thru Frame 63, at STGR 38 LH, install the corner profiles, if removed in accordance with SRM 53-41-14 C2 Identification - Floor Structure - Cargo Compartment.

(c) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(18) Subtask 531364-831-218-002 - Install new Surface Protection on Frame 50 thru Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 from Stringer 31 to Stringer 39
To	160	Work location	from Frame 60 to Frame 63 from Stringer 31 to Stringer 39

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	NON SPECIFIC

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	04JME4	As required	
	Coating - Flexible Structure	04QAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound	12ADB1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

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References	
Structural Repair Manual (SRM)	51-23-12

(a) Clean the working area with:

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

(b) Apply sealant beads around the edges of all new and reinstalled structure parts with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(c) Apply to all sealant beads:

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(d) Apply to all sealant beads:

Top Coat Polyurethane	04JME4	As required
and		
Coating - Flexible Structure	04QAB2	As required

(e) Install new water repellent protection on Frame 50 thru Frame 63.

1 Protect the Frame 50 thru Frame 63, STGR 31 LH thru STGR 39 LH and the re-installed shear plates with:

In accordance with SRM 51-23-12.

Corrosion Preventive Compound	12ADB1	As required

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**CONF 009

(1) **Subtask 531364-831-201-010 - Remove the Shear Plates at STGR 38 LH between Frame 50 and Frame 63**

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 Stringer 38 LH
To	160	Work location	from Frame 60 to Frame 63 Stringer 38 LH

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

Material necessary to do the job

Consumable CMLD01				
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)	53-41-14
Fig. A-GBQAJ Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

CAUTION: AIRBUS CONSIDERS IT IS TECHNICALLY ACCEPTABLE TO REWORK EVERY THIRD FRAME AT THE SAME TIME (I.E. LEAVE TWO FRAMES INTACT AND REWORK ONE) TO KEEP THE FUSELAGE STRUCTURE INTEGRITY.

(a) Remove the corner profiles.

In accordance with SRM 53-41-14 C2 Ident.-Floor Structure-Cargo Compartment.

1 Between Frame 48 thru Frame 63, at STGR 38 LH, remove the corner profiles, if necessary in accordance with SRM 53-41-14 C2 Identification - Floor Structure - Cargo Compartment.

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(b) Remove the shear plates.

Refer to Fig. A-GBQAJ Sheet 01 thru Fig. A-GBQAJ Sheet 06.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 Between Frame 49 and Frame 50, from STGR 38 LH and from the bracket at Frame 49 and bracket, Item (140), remove:

Refer to Fig. A-GBQAJ Sheet 02, View C.

1	Plate-Shear	D5347456300000	Item (139)	Retain
	with			
26	Rivet		Item (100)	Discard

2 Between Frame 50 and Frame 51, from STGR 38 LH and from the brackets, Item (116) and Item (140), remove:

Refer to Fig. A-GBQAJ Sheet 02, View C.

1	Plate-Shear	D5347471500200	Item (117)	Retain
	with			
28	Rivet		Item (100)	Discard

3 Between Frame 52 and Frame 53, from STGR 38 LH and from the brackets, Item (116) and Item (120), remove:

Refer to Fig. A-GBQAJ Sheet 03, View E.

1	Plate Assy-Shear	D5347049100600	Item (119)	Retain
	with			
29	Rivet		Item (100)	Discard

4 Between Frame 54 and Frame 55, from STGR 38 LH and from the brackets, Item (121) and Item (120), remove:

Refer to Fig. A-GBQAJ Sheet 04, View G.

1	Plate Assy-Shear	D5347048800400	Item (122)	Retain
	with			
28	Rivet		Item (100)	Discard

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5 Between Frame 56 and Frame 57, from STGR 38 LH and from the brackets, Item (121) and Item (118), remove:

Refer to Fig. A-GBQAJ Sheet 04, View J.

1	Plate-Shear	D5347048900400	Item (124)	Retain
	with			
28	Rivet		Item (100)	Discard

6 Between Frame 58 and Frame 59, from STGR 38 LH and from the brackets, Item (125) and Item (127), remove:

Refer to Fig. A-GBQAJ Sheet 05, View L.

1	Plate-Shear	D5347049200400	Item (126)	Retain
	with			
28	Rivet		Item (100)	Discard

7 Between Frame 60 and Frame 61, from STGR 38 LH and from the brackets, Item (128) and Item (130), remove:

Refer to Fig. A-GBQAJ Sheet 05, View N.

1	Plate-Shear	D5347049300200	Item (129)	Retain
	with			
30	Rivet		Item (100)	Discard

8 Between Frame 62 and Frame 63, from STGR 38 LH and from the brackets, Item (131) and Item (115), remove:

Refer to Fig. A-GBQAJ Sheet 06, View Q.

1	Plate-Shear	D5347049400000	Item (123)	Retain
	with			
29	Rivet		Item (100)	Discard

(c) Clean the contact surfaces and the retained parts with:

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

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(2) Subtask 531364-831-202-006 - Cold expand the Tack and Tooling Holes from Frame 50 thru Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 55 from Stringer 33 LH to Stringer 34 LH from Stringer 36 LH to Stringer 37 LH Frame 56 from Stringer 33 LH to Stringer 34 LH from Stringer 35 LH to Stringer 37 LH from Frame 57 to Frame 59 from Stringer 33 LH to Stringer 34 LH from Stringer 36 LH to Stringer 37 LH
To	160	Work location	from Frame 60 to Frame 62 from Stringer 32 LH to Stringer 33 LH from Stringer 36 LH to Stringer 37 LH Frame 63 from Stringer 31 LH to Stringer 32 LH from Stringer 36 LH to Stringer 37 LH

Manpower Resources	
Manhours	5.00
Minimum number of person	1
Subtask elapsed time	5.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

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 Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane	04JME4	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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.

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NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00
Fig. A-GBRAB Cold Expansion of Holes in Frame 50 thru Frame 63	Sheet 01 Sheet 02 Sheet 03

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

(a) Inspect the holes for cracks from Frame 50 thru Frame 55 and from Frame 57 thru Frame 59.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 02.

1 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 33 LH and STGR 34 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

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(b) Cold expand the holes from Frame 50 thru Frame 55 and from Frame 57 thru Frame 59.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 02.

1 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 33 LH and STGR 34 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 02, View C.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 From Frame 50 thru Frame 55 and Frame 57 thru Frame 59, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1 Expendable Tooling 1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1 Capital Tooling 1

DK-A320531364-1 Durable Tooling 1

EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 02, View C.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

4 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(c) Inspect the holes for cracks at Frame 56.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 02.

1 At Frame 56, between STGR 33 LH and STGR 34 LH and between STGR 35 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

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2 At Frame 56, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Cold expand the holes at Frame 56.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 02.

1 At Frame 56, between STGR 33 LH and STGR 34 LH and between STGR 35 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 02, View D.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

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2 At Frame 56, between STGR 37 LH and STGR 38 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 02, View D.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

4 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

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(e) Inspect the holes for cracks from Frame 60 thru Frame 62.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 02.

1 From Frame 60 thru Frame 62, between STGR 32 LH and STGR 33 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 From Frame 60 thru Frame 62, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(f) Cold expand the holes from Frame 60 thru Frame 62.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 02.

1 From Frame 60 thru Frame 62, between STGR 32 LH and STGR 33 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 02, View E.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 From Frame 60 thru Frame 62, between STGR 37 LH and STGR 38 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 02, View E.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 Clean the area of the expanded holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

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4 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(g) Inspect the holes for cracks at Frame 63.

Refer to NTM 51-10-01.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 03.

1 At Frame 63, between STGR 31 LH and STGR 32 LH and between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of the tack holes in the frame, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 8-1-N.

2 At Frame 63, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of the tack holes in the frames, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(h) Cold expand the holes at Frame 63.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBRAB Sheet 01 and Fig. A-GBRAB Sheet 03.

1 At Frame 63, between STGR 31 LH and STGR 32 LH and between STGR 36 LH and STGR 37 LH, cold expand the tack holes in the frame. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 8-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 03, View F.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

2 At Frame 63, between STGR 37 LH and STGR 38 LH, cold expand the tack holes in the frames. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBRAB Sheet 03, View F.

NOTE: Reaming of the tack holes after cold expansion is not necessary.

NOTE: This workstep is only applicable to MSN 3999 and subsequent.

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3 Clean the area of the expanded holes with:

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

4 Apply surface protection to the expanded holes with:

Wash Primer - Structure	04CMA2	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(3) Subtask 531364-831-203-017 - Replace the Shear Web and the Frame Clips from Frame 50, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 50 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D09R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
4	E5347001024400	1	WEB	
36	E5347001124200	1	ANGLE	
65	E5347001420200	1	ANGLE	
66	E5347001420000	1	ANGLE	
363	EN6115K3-3	3	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
373	EN6115K3A3	1	BOLT	
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	20	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
764	DAN5-6-4X	14	PIN	
765	DAN5-6-5X	15	PIN	
766	DAN5-6-6X	7	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	2	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	40	COLLAR	
808	ASNA2528-3	3	NUT	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	4	PIN	

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

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NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBAAJ Replacement of Webs and Angles at Frame 50	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBAAJ Sheet 01, View B and Section A-A.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 50, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920400	Item (37)	Discard
	with			
16	Rivet		Item (100)	Discard

2 From the top flange of Frame 50, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

6	Rivet		Item (100)	Discard

3 From Frame 50, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347073420200	Item (1)	Discard
	with			

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17	Rivet		Item (100)	Discard

4 From Frame 50, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072820600	Item (2)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347470120200	Item (116)	Discard
1	Angle	D5347470120000	Item (140)	Discard

with

64	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 50.

Refer to NTM 51-10-01.

Refer to Fig. A-GBAAJ Sheet 02, View C.

1 On Frame 50, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 50, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

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(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBAAJ Sheet 02 thru Fig. A-GBAAJ Sheet 04.

1 On Frame 50, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBAAJ Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 50 to the shear web, Item 4.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAJ Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBAAJ Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBAAJ Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAJ Sheet 04.

5 Transfer drill the tack hole from the Frame 50 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 50 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 4005 and subsequent.

7 On Frame 50, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

8 Clean and deburr the new fastener holes in Frame 50 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

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Refer to Fig. A-GBAAJ Sheet 02, View C.

a On Frame 50, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBAAJ Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

b On Frame 50, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAJ Sheet 02, View C.

c On Frame 50, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAJ Sheet 02, View C.

d On Frame 50, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBAAJ Sheet 02, View C.

10 On Frame 50, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

11 Clean and deburr the cold expansion fastener holes in Frame 50 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 50, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBAAJ Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4
	with		
3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
20	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
14	Pin	DAN5-6-4X	Item 764
12	Pin	DAN5-6-5X	Item 765
26	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
5	Nut	ASNA2528-3A	Item 908
	use		

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 50, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBAAJ Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

14 On the Frame 50 flange, at STGR 35 LH, refer to Fig. A-GBAAJ Sheet 03, Section C-C, countersink the one fastener hole.

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15 On the Frame 50 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBAAJ Sheet 03, Section C-C.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 50 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBAAJ Sheet 02, View C and Fig. A-GBAAJ Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBAAJ Sheet 02, View C and Fig. A-GBAAJ Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAJ Sheet 04.

18 On the Frame 50 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 50, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 50 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBAAJ Sheet 02, View C and Fig. A-GBAAJ Sheet 03, Section C-C.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765
3	Collar	DAN11-6X	Item 807

21 On the Frame 50 flange, at STGR 36 LH, refer to Fig. A-GBAAJ Sheet 03, Section D-D, countersink the one fastener hole.

22 On the Frame 50 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBAAJ Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 50 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBAAJ Sheet 02, View C and Fig. A-GBAAJ Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBAAJ Sheet 02, View C and Fig. A-GBAAJ Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAJ Sheet 04.

25 On the Frame 50 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 50, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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27 On the Frame 50 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBAAJ Sheet 02, View C and Fig. A-GBAAJ Sheet 03, Section D-D.

1	Angle	E5347001120200	Item 2	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

28 On the Frame 50 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBAAJ Sheet 02, View C and Fig. A-GBAAJ Sheet 03, Section E-E.

1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Pin	DAN5-6-6X	Item 766	
2	Pin	DAN5-6-7X	Item 767	
4	Collar	NSA5075-6	Item 806	
6	Collar	DAN11-6X	Item 807	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 50 flange, at STGR 38 LH, put in position:

Refer to Fig. A-GBAAJ Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

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30 Transfer drill and ream the three holes from the Frame to the angles, Item 65 and Item 66, refer to Fig. A-GBAAJ Sheet 02, View C and Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAJ Sheet 04.

31 On the Frame 50 flange, at STGR 38 LH, remove:

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

32 Clean and deburr the new fastener holes in the Frame 50 and angles, Item 65 and Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

33 On the Frame 50 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBAAJ Sheet 02, View C and Section B-B.

1	Angle	E5347001420200	Item 65
1	Angle	E5347001420000	Item 66

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Pin	DAN5-6-8X	Item 768
1	Pin	DAN5-6-6X	Item 766
3	Collar	DAN11-6X	Item 807

34 On the Frame 50 flange, at STGR 39 LH, refer to Fig. A-GBAAJ Sheet 03, Section F-F, countersink the one fastener hole.

35 On the Frame 50 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBAAJ Sheet 03, Section F-F.

1	Rivet	EN6069D5-06	Item 556

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

36 On the Frame 50 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBAAJ Sheet 02, View C and Fig. A-GBAAJ Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

37 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBAAJ Sheet 02, View C and Fig. A-GBAAJ Sheet 03, Section F-F

NOTE: For the hole diameters, refer to the table on Fig. A-GBAAJ Sheet 04.

38 On the Frame 50 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

39 Clean and deburr the new fastener holes in the Frame 50, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

40 On the Frame 50 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBAAJ Sheet 02, View C and Fig. A-GBAAJ Sheet 03, Section F-F.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Pin	DAN5-6-6X	Item 766

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2	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(4) Subtask 531364-831-204-014 - Replace the Shear Web and the Frame Clips from Frame 51, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 51 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D09R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
4	E5347001024400	1	WEB	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	3	BOLT	
373	EN6115K3A3	1	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
374	EN6115K3A4	4	BOLT	
375	EN6115K3A5	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	20	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	1	RIVET	
667	EN6081D6-07	23	RIVET	
764	DAN5-6-4X	14	PIN	
765	DAN5-6-5X	15	PIN	
766	DAN5-6-6X	6	PIN	
767	DAN5-6-7X	2	PIN	
768	DAN5-6-8X	3	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	34	COLLAR	
808	ASNA2528-3	3	NUT	
908	ASNA2528-3A	6	NUT	
963	DAN5-6-3	4	PIN	

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

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NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBBAJ Replacement of Webs and Angles at Frame 51	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBBAJ Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 51, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920400	Item (37)	Discard
	with			
16	Rivet		Item (100)	Discard

2 From the top flange of Frame 51, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

6	Rivet		Item (100)	Discard

3 From Frame 51, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347073420200	Item (1)	Discard
	with			

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17	Rivet		Item (100)	Discard

4 From Frame 51, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072820600	Item (2)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347470120000	Item (140)	Retain
	with			
64	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 51.

Refer to NTM 51-10-01.

Refer to Fig. A-GBBAJ Sheet 02, View C.

1 On Frame 51, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 373 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 6-1-N.

2 On Frame 51, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363, Item 374 and Item 375, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N and STDN 6-1-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBBAJ Sheet 02 thru Fig. A-GBBAJ Sheet 04.

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1 On Frame 51, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBBAJ Sheet 02, View C.

1	Shear Web	E5347001024400	Item 4

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 51 to the shear web, Item 4.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAJ Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBBAJ Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBBAJ Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAJ Sheet 04.

5 Transfer drill the tack hole from the Frame 51 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 51 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 4005 and subsequent.

7 On Frame 51, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

8 Clean and deburr the new fastener holes in Frame 51 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBBAJ Sheet 02, View C.

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a On Frame 51, between STGR 34 LH and STGR 39 LH, put in position:

1	Shear Web	E5347001024400	Item 4

b On Frame 51, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 373 and Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAJ Sheet 02, View C.

c On Frame 51, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 363. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAJ Sheet 02, View C.

d On Frame 51, between STGR 36 LH and STGR 37 LH, cold expand the 3 holes for the fasteners, Item 374 and Item 375. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBBAJ Sheet 02, View C.

10 On Frame 51, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024400	Item 4

11 Clean and deburr the cold expansion fastener holes in Frame 51 and the shear web, Item 4, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 51, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBBAJ Sheet 02, View C.

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1	Shear Web	E5347001024400	Item 4
	with		
3	Bolt	EN6115K3-3	Item 363
4	Bolt	EN6115K3A4	Item 374
1	Bolt	EN6115K3A5	Item 375
20	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D6-06	Item 666
20	Rivet	EN6081D6-07	Item 667
14	Pin	DAN5-6-4X	Item 764
12	Pin	DAN5-6-5X	Item 765
26	Collar	DAN11-6X	Item 807
3	Nut	ASNA2528-3	Item 808
5	Nut	ASNA2528-3A	Item 908
	use		
Polysulfide Sealant - General Purpose Brushable		06AAA1	As required

13 Install 1 fastener in the flange of Frame 51, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBBAJ Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3A	Item 908

14 On the Frame 51 flange, at STGR 35 LH, refer to Fig. A-GBBAJ Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 51 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBBAJ Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 51 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBBAJ Sheet 02, View C and Fig. A-GBBAJ Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBBAJ Sheet 02, View C and Fig. A-GBBAJ Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAJ Sheet 04.

18 On the Frame 51 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 51, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 51 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBBAJ Sheet 02, View C and Fig. A-GBBAJ Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Pin	DAN5-6-5X	Item 765

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3	Collar	DAN11-6X	Item 807

21 On the Frame 51 flange, at STGR 36 LH, refer to Fig. A-GBBAJ Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 51 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBBAJ Sheet 03, Section B-B.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 51 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBBAJ Sheet 02, View C and Fig. A-GBBAJ Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBBAJ Sheet 02, View C and Fig. A-GBBAJ Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAJ Sheet 04.

25 On the Frame 51 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 51, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 51 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBBAJ Sheet 02, View C and Fig. A-GBBAJ Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

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	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	
	28 On the Frame 51 flange, at STGR 37 LH, wet install:			
	Refer to Fig. A-GBBAJ Sheet 02, View C and Fig. A-GBBAJ Sheet 03, Section C-C.			
1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Pin	DAN5-6-6X	Item 766	
2	Pin	DAN5-6-7X	Item 767	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	
	29 On the Frame 51 flange, at STGR 38 LH, wet install:			
	Refer to Fig. A-GBBAJ Sheet 02, View C.			
1	Angle	D5347470120000	Item (140)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Pin	DAN5-6-8X	Item 768	
3	Collar	DAN11-6X	Item 807	

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30 On the Frame 51 flange, at STGR 39 LH, refer to Fig. A-GBBAJ Sheet 03, Section D-D, countersink the one fastener hole.

31 On the Frame 51 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBBAJ Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

32 On the Frame 51 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBBAJ Sheet 02, View C and Fig. A-GBBAJ Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBBAJ Sheet 02, View C and Fig. A-GBBAJ Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBBAJ Sheet 04.

34 On the Frame 51 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

35 Clean and deburr the new fastener holes in the Frame 51, STGR 39 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

36 On the Frame 51 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBBAJ Sheet 02, View C and Fig. A-GBBAJ Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-07	Item 657
2	Pin	DAN5-6-6X	Item 766
2	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(5) Subtask 531364-831-205-016 - Replace the Shear Web and the Frame Clips from Frame 52, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 52 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D09R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
6	E5347001023800	1	WEB	
80	E5347001125400	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	25	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	2	RIVET	
668	EN6081D6-08	20	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	8	PIN	
765	DAN5-6-5X	1	PIN	
806	NSA5075-6	7	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	10	NUT	
863	DAN6-6-3	1	PIN	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)

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ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBCAJ Replacement of Webs and Angles at Frame 52	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBCAJ Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural

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parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 52, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920200	Item (3)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 52, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

8	Rivet		Item (100)	Discard

3 From Frame 52, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 52, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078320600	Item (5)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347470120200	Item (116)	Retain
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 52.

Refer to NTM 51-10-01.

Refer to Fig. A-GBCAJ Sheet 02, Views C, D and F.

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1 On Frame 52, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 52, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 52, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 52, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBCAJ Sheet 02 thru Fig. A-GBCAJ Sheet 04.

1 On Frame 52, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBCAJ Sheet 02, View C.

1	Shear Web	E5347001023800	Item 6

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 52 to the shear web, Item 6.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAJ Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBCAJ Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBCAJ Sheet

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02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAJ Sheet 04.

5 Transfer drill the tack hole from the Frame 52 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 52 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 4005 and subsequent.

7 On Frame 52, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001023800	Item 6

8 Clean and deburr the new fastener holes in Frame 52 and the shear web, Item 6, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBCAJ Sheet 02, Views C, D and F.

a On Frame 52, between STGR 34 LH and STGR 39 LH, put in position:

1	Shear Web	E5347001023800	Item 6

b On Frame 52, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAJ Sheet 02, View C.

c On Frame 52, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAJ Sheet 02, View C.

d On the top flange of Frame 52, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1

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EK-A320531364-1 Expendable Tooling 1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1 Capital Tooling 1

DK-A320531364-1 Durable Tooling 1

EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAJ Sheet 02, View D.

e On the top flange of Frame 52, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1 Capital Tooling 1

DK-A320531364-1 Durable Tooling 1

EK-A320531364-1 Expendable Tooling 1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1 Capital Tooling 1

DK-A320531364-1 Durable Tooling 1

EK-A320531364-1 Expendable Tooling 1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBCAJ Sheet 02, View F.

10 On Frame 52, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001023800	Item 6

11 Clean and deburr the cold expansion fastener holes in Frame 52 and the shear web, Item 6, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 52, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBCAJ Sheet 02, View C.

1	Shear Web	E5347001023800	Item 6
	with		
3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
25	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
16	Rivet	EN6081D6-08	Item 668
7	Pin	DAN5-6-4X	Item 764
1	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
1	Pin	DAN5-6-3	Item 963
	use		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 52, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBCAJ Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 52, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBCAJ Sheet 02, View D.

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1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

15 On the Frame 52 flange, at STGR 35 LH, refer to Fig. A-GBCAJ Sheet 03, Section A-A, countersink the one fastener hole.

16 On the Frame 52 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBCAJ Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 52 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBCAJ Sheet 02, View C and Fig. A-GBCAJ Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBCAJ Sheet 02, View C and Fig. A-GBCAJ Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAJ Sheet 04.

19 On the Frame 52 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

20 Clean and deburr the new fastener holes in the Frame 52, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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21 On the Frame 52 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBCAJ Sheet 02, View C and Fig. A-GBCAJ Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

22 On the Frame 52 flange, at STGR 36 LH, refer to Fig. A-GBCAJ Sheet 03, Section B-B, countersink the one fastener hole.

23 On the Frame 52 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBCAJ Sheet 03, Section B-B.

1	Rivet	EN6069D5-06	Item 556
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 52 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBCAJ Sheet 02, View C and Fig. A-GBCAJ Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes in the Frame to the angle, Item 2, refer to Fig. A-GBCAJ Sheet 02, View C and Fig. A-GBCAJ Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAJ Sheet 04.

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26 On the Frame 52 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2	

27 Clean and deburr the new fastener holes in the Frame 52, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required	

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required	

28 On the Frame 52 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBCAJ Sheet 02, View C and Fig. A-GBCAJ Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-4	Item 964	
1	Collar	NSA5075-6	Item 806	

29 On the Frame 52 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBCAJ Sheet 02, View C and Fig. A-GBCAJ Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

6	Rivet	EN6081D6-09	Item 669	

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4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

30 On the aft side of the Frame 52 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBCAJ Sheet 02, View C.

1	Angle	D5347470120200	Item (116)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-4X	Item 764
1	Collar	DAN11-6X	Item 807

31 On the Frame 52 flange, at STGR 39 LH, refer to Fig. A-GBCAJ Sheet 03, Section D-D, countersink the one fastener hole.

32 On the Frame 52 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBCAJ Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 52 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBCAJ Sheet 02, View C and Fig. A-GBCAJ Sheet 03, Section D-D.

1	Angle	E5347001125400	Item 80

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 80, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 2, refer to Fig. A-GBCAJ Sheet 02, View C and Fig. A-GBCAJ Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBCAJ Sheet 04.

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35 On the Frame 52 flange, at STGR 39 LH, remove:

1	Angle	E5347001125400	Item 80

36 Clean and deburr the new fastener holes in theFrame 52, STGR 39 LH and angle, Item 80, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

37 On the Frame 52 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBCAJ Sheet 02, View C and Fig. A-GBCAJ Sheet 03, Section D-D.

1	Angle	E5347001125400	Item 80

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

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(6) Subtask 531364-831-206-015 - Replace the Shear Web and the Frame Clips from Frame 53, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 53 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D09R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
8	E5347001027400	1	WEB	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	2	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	1	PIN	
806	NSA5075-6	18	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	9	NUT	
863	DAN6-6-3	10	PIN	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBDAJ Replacement of Webs and Angles at Frame 53	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBDAJ Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 53, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the flange of Frame 53, between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 53, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 53, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078320400	Item (6)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046823800	Item (120)	Retain
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 53.

Refer to NTM 51-10-01.

Refer to Fig. A-GBDAJ Sheet 02, View C.

1 On Frame 53, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 53, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 In case of crack indication, contact AIRBUS for further instructions.

4 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBDAJ Sheet 02 thru Fig. A-GBDAJ Sheet 04.

1 On Frame 53, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBDAJ Sheet 02, View C.

1	Shear Web	E5347001027400	Item 8

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 53 to the shear web, Item 8.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAJ Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBDAJ Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBDAJ Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAJ Sheet 04.

5 Transfer drill the tack hole from the Frame 53 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

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6 Transfer drill the tack hole from the Frame 53 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 4005 and subsequent.

7 On Frame 53, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001027400	Item 8

8 Clean and deburr the new fastener holes in Frame 53 and the shear web, Item 8, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBDAJ Sheet 02, View C.

a On Frame 53, between STGR 34 LH and STGR 39 LH, put in position:

1	Shear Web	E5347001027400	Item 8

b On Frame 53, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAJ Sheet 02, View C.

c On Frame 53, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBDAJ Sheet 02, View C.

10 On Frame 53, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001027400	Item 8

11 Clean and deburr the new fastener holes in Frame 53 and the shear web, Item 8, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 53, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBDAJ Sheet 02, View C.

1	Shear Web	E5347001027400	Item 8

with

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3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
13	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863
1	Pin	DAN5-6-3	Item 963
2	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 53, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBDAJ Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the Frame 53 flange, at STGR 35 LH, refer to Fig. A-GBDAJ Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 53 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBDAJ Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

with

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 53 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBDAJ Sheet 02, View C and Fig. A-GBDAJ Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBDAJ Sheet 02, View C and Fig. A-GBDAJ Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAJ Sheet 04.

18 On the Frame 53 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

19 Clean and deburr the new fastener holes in the Frame 53, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 53 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBDAJ Sheet 02, View C and Fig. A-GBDAJ Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765

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1	Collar	DAN11-6X	Item 807

21 On the Frame 53 flange, at STGR 36 LH, refer to Fig. A-GBDAJ Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 53 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBDAJ Sheet 03, Section B-B.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 53 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBDAJ Sheet 02, View C and Fig. A-GBDAJ Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBDAJ Sheet 02, View C and Fig. A-GBDAJ Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBDAJ Sheet 04.

25 On the Frame 53 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

26 Clean and deburr the new fastener holes in the Frame 53, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 53 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBDAJ Sheet 02, View C and Fig. A-GBDAJ Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	
1	Pin	DAN5-6-4	Item 964	
1	Collar	NSA5075-6	Item 806	

28 On the Frame 53 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBDAJ Sheet 02, View C and Fig. A-GBDAJ Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

29 On the Frame 53 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBDAJ Sheet 02, View C.

1	Angle	D5347046823800	Item (120)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

2	Rivet	EN6081D6-08	Item 668	

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1	Pin	DAN5-6-4X	Item 764
1	Collar	DAN11-6X	Item 807

30 On the Frame 53 flange, at STGR 39 LH, refer to Fig. A-GBDAJ Sheet 03, Section D-D, countersink the one fastener hole.

31 On the Frame 53 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBDAJ Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

32 On the Frame 53 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBDAJ Sheet 02, View C and Fig. A-GBDAJ Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 36, refer to Fig. A-GBDAJ Sheet 02, View C and Fig. A-GBDAJ Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBDAJ Sheet 04.

34 On the Frame 53 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

35 Clean and deburr the new fastener holes in the Frame 53, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

36 On the Frame 53 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBDAJ Sheet 02, View C and Fig. A-GBDAJ Sheet 03, Section D-D.

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1	Angle	E5347001124200	Item 36
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D6-08	Item 668
2	Rivet	EN6081D5-07	Item 657

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(7) Subtask 531364-831-207-015 - Replace the Shear Web and the Frame Clips from Frame 54, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 54 from Stringer 34 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D09R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
10	E5347001025200	1	WEB	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	6	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	21	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	1	PIN	
806	NSA5075-6	16	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	10	NUT	
863	DAN6-6-3	11	PIN	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	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	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

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NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBEAJ Replacement of Webs and Angles at Frame 54	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBEAJ Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

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1 From Frame 54, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 54, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

10	Rivet		Item (100)	Discard

3 From Frame 54, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 54, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078520400	Item (7)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046824000	Item (121)	Retain
	with			
55	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 54.

Refer to NTM 51-10-01.

Refer to Fig. A-GBEAJ Sheet 02, Views C, D and F.

1 On Frame 54, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM

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51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 54, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 54, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 54, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBEAJ Sheet 02 thru Fig. A-GBEAJ Sheet 04.

1 On Frame 54, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBEAJ Sheet 02, View C.

1	Shear Web	E5347001025200	Item 10

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 54 to the shear web, Item 10.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAJ Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBEAJ Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBEAJ Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAJ Sheet 04.

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5 Transfer drill the tack hole from the Frame 54 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 54 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 4005 and subsequent.

7 On Frame 54, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025200	Item 10

8 Clean and deburr the new fastener holes in Frame 54 and the shear web, Item 10, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBEAJ Sheet 02, Views C, D and F.

a On Frame 54, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBEAJ Sheet 02, View C.

1	Shear Web	E5347001025200	Item 10

b On Frame 54, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAJ Sheet 02, View C.

c On Frame 54, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAJ Sheet 02, View C.

d On the top flange of Frame 54, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAJ Sheet 02, View D.

e On the top flange of Frame 54, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBEAJ Sheet 02, View F.

10 On Frame 54, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025200	Item 10

11 Clean and deburr the cold expansion fastener holes in Frame 54 and the shear web, Item 10, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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12 At Frame 54, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBEAJ Sheet 02, View C.

1	Shear Web	E5347001025200	Item 10
	with		
3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
6	Rivet	EN6081D6-06	Item 666
17	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
10	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
9	Pin	DAN6-6-3	Item 863
	use		
Polysulfide Sealant - General Purpose Brushable		06AAA1	As required

13 Install 1 fastener in the flange of Frame 54, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBEAJ Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 54, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBEAJ Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806

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1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

15 On the Frame 54 flange, at STGR 35 LH, refer to Fig. A-GBEAJ Sheet 03, Section A-A, countersink the one fastener hole.

16 On the Frame 54 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBEAJ Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 54 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBEAJ Sheet 02, View C and Fig. A-GBEAJ Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBEAJ Sheet 02, View C and Fig. A-GBEAJ Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAJ Sheet 04.

19 On the Frame 54 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

20 Clean and deburr the new fastener holes in the Frame 54, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 54 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBEAJ Sheet 02, View C and Fig. A-GBEAJ Sheet 03, Section A-A.

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1	Angle	E5347001120000	Item 1
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

22 On the Frame 54 flange, at STGR 36 LH, refer to Fig. A-GBEAJ Sheet 03, Section B-B, countersink the one fastener hole.

23 On the Frame 54 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBEAJ Sheet 03, Section B-B.

1	Rivet	EN6069D5-06	Item 556
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 54 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBEAJ Sheet 02, View C and Fig. A-GBEAJ Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBEAJ Sheet 02, View C and Fig. A-GBEAJ Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAJ Sheet 04.

26 On the Frame 54 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

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27 Clean and deburr the new fastener holes in the Frame 54, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 54 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBEAJ Sheet 02, View C and Fig. A-GBEAJ Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Rivet	EN6081D6-07	Item 667

29 On the Frame 54 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBEAJ Sheet 02, View C and Fig. A-GBEAJ Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

6	Rivet	EN6081D6-09	Item 669
4	Collar	NSA5075-6	Item 806
4	Pin	DAN5-6-3	Item 963

30 On the aft side of the Frame 54 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBEAJ Sheet 02, View C.

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1	Angle	D5347046824000	Item (121)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-4X	Item 764	
1	Collar	DAN11-6X	Item 807	

31 On the Frame 54 flange, at STGR 39 LH, refer to Fig. A-GBEAJ Sheet 03, Section D-D, countersink the one fastener hole.

32 On the Frame 54 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBEAJ Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 54 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBEAJ Sheet 02, View C and Fig. A-GBEAJ Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBEAJ Sheet 02, View C and Fig. A-GBEAJ Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBEAJ Sheet 04.

35 On the Frame 54 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

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36 Clean and deburr the new fastener holes in the Frame 54, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

37 On the Frame 54 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBEAJ Sheet 02, View C and Fig. A-GBEAJ Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-08	Item 668
2	Rivet	EN6081D5-07	Item 657

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

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(8) Subtask 531364-831-208-015 - Replace the Shear Web and the Frame Clips from Frame 55, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 55 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D09R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	2	ANGLE	
2	E5347001120200	1	ANGLE	
12	E5347001025400	1	WEB	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	3	BOLT	
364	EN6115K3-4	5	BOLT	
373	EN6115K3A3	1	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	6	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	10	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	16	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	10	NUT	
863	DAN6-6-3	12	PIN	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBFAJ Replacement of Webs and Angles at Frame 55	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBFAJ Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 55, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 55, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

10	Rivet		Item (100)	Discard

3 From Frame 55, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 55, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347072121000	Item (8)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046823800	Item (120)	Retain
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 55.

Refer to NTM 51-10-01.

Refer to Fig. A-GBFAJ Sheet 02, Views C, D and F.

1 On Frame 55, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 55, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 55, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBFAJ Sheet 02 thru Fig. A-GBFAJ Sheet 04.

1 On Frame 55, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBFAJ Sheet 02, View C.

1	Shear Web	E5347001025400	Item 12

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 55 to the shear web, Item 12.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAJ

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Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBFAJ Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBFAJ Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAJ Sheet 04.

5 Transfer drill the tack hole from the Frame 55 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 55 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 4005 and subsequent.

7 On Frame 55, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025400	Item 12

8 Clean and deburr the new fastener holes in Frame 55 and the shear web, Item 12, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBFAJ Sheet 02, Views C, D and F.

a On Frame 55, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBFAJ Sheet 02, View C.

1	Shear Web	E5347001025400	Item 12

b On Frame 55, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

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FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAJ Sheet 02, View C.

c On Frame 55, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAJ Sheet 02, View C.

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d On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAJ Sheet 02, View D.

e On the top flange of Frame 55, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBFAJ Sheet 02, View F.

10 On Frame 55, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025400	Item 12

11 Clean and deburr the cold expansion fastener holes in Frame 55 and the shear web, Item 12, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 55, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBFAJ Sheet 02, View C.

1	Shear Web	E5347001025400	Item 12

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
6	Rivet	EN6081D6-06	Item 666
17	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
10	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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13 Install 1 fastener in the flange of Frame 55, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBFAJ Sheet 02, View C.

1	Bolt	EN6115K3A3	Item 373
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 55, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBFAJ Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

15 On the Frame 55 flange, at STGR 35 LH, refer to Fig. A-GBFAJ Sheet 03, Section A-A, countersink the one fastener hole.

16 On the Frame 55 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBFAJ Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 55 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBFAJ Sheet 02, View C and Fig. A-GBFAJ Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBFAJ Sheet 02, View C and Fig. A-GBFAJ Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAJ Sheet 04.

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19 On the Frame 55 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

20 Clean and deburr the new fastener holes in the Frame 55, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 55 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBFAJ Sheet 02, View C and Fig. A-GBFAJ Sheet 03, Section A-A.

2	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

22 On the Frame 55 flange, at STGR 36 LH, refer to Fig. A-GBFAJ Sheet 03, Section B-B, countersink the one fastener hole.

23 On the Frame 55 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBFAJ Sheet 03, Section B-B.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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24 On the Frame 55 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBFAJ Sheet 02, View C and Fig. A-GBFAJ Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBFAJ Sheet 02, View C and Fig. A-GBFAJ Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAJ Sheet 04.

26 On the Frame 55 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

27 Clean and deburr the new fastener holes in the Frame 55, STGR 39 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 55 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBFAJ Sheet 02, View C and Fig. A-GBFAJ Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
3	Rivet	EN6081D6-07	Item 667

29 On the Frame 55 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBFAJ Sheet 02, View C and Fig. A-GBFAJ Sheet 03, Section C-C.

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1	Support	D5347032200000	Item (101)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

30 On the Frame 55 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBFAJ Sheet 02, View C.

1	Angle	D5347046823800	Item (120)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-09	Item 669	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

31 On the Frame 55 flange, at STGR 39 LH, refer to Fig. A-GBFAJ Sheet 03, Section D-D, countersink the one fastener hole.

32 On the Frame 55 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBFAJ Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

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33 On the Frame 55 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBFAJ Sheet 02, View C and Fig. A-GBFAJ Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes form the Frame to the angle, Item 36, refer to Fig. A-GBFAJ Sheet 02, View C and Fig. A-GBFAJ Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBFAJ Sheet 04.

35 On the Frame 55 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

36 Clean and deburr the new fastener holes in the Frame 55, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

37 On the Frame 55 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBFAJ Sheet 02, View C and Fig. A-GBFAJ Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-08	Item 668
2	Rivet	EN6081D5-07	Item 657

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(9) Subtask 531364-831-209-015 - Replace the Shear Web and the Frame Clips from Frame 56, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 56 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D09R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
2	E5347001120200	1	ANGLE	
14	E5347001024000	1	WEB	
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
556	EN6069D5-06	3	RIVET	
567	EN6069D6-07	10	RIVET	
656	EN6081D5-06	8	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	6	RIVET	
667	EN6081D6-07	3	RIVET	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
668	EN6081D6-08	19	RIVET	(1)
669	EN6081D6-09	10	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	21	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	10	NUT	
863	DAN6-6-3	17	PIN	
963	DAN5-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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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.

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBGAJ Replacement of Webs and Angles at Frame 56	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBGAJ Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 56, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347071920000	Item (37)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 56, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 34 LH and STGR 36 LH, remove:

10	Rivet		Item (100)	Discard

3 From Frame 56, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347072020200	Item (4)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 56, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347078620400	Item (8)	Discard
1	Support	D5347032200000	Item (101)	Retain

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1	Angle	D5347046824000	Item (121)	Retain
	with			
56	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 56.

Refer to NTM 51-10-01.

Refer to Fig. A-GBGAJ Sheet 02, Views C, D and F.

1 On Frame 56, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 56, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 56, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

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(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBGAJ Sheet 02 thru Fig. A-GBGAJ Sheet 04.

1 On Frame 56, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBGAJ Sheet 02, View C.

1	Shear Web	E5347001024000	Item 14

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 56 to the shear web, Item 14.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAJ Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBGAJ Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBGAJ Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAJ Sheet 04.

5 Transfer drill the tack hole from the Frame 56 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 56 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 4005 and subsequent.

7 On Frame 56, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024000	Item 14

8 Clean and deburr the new fastener holes in Frame 56 and the shear web, Item 14, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

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Refer to Fig. A-GBGAJ Sheet 02, Views C, D and F.

a On Frame 56, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBGAJ Sheet 02, View C.

1	Shear Web	E5347001024000	Item 14

b On Frame 56, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAJ Sheet 02, View C.

c On Frame 56, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAJ Sheet 02, View C.

d On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAJ Sheet 02, View D.

e On the top flange of Frame 56, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBGAJ Sheet 02, View F.

10 On Frame 56, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024000	Item 14

11 Clean and deburr the cold expansion fastener holes in Frame 56 and the shear web, Item 14, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 56, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBGAJ Sheet 02, View C.

1	Shear Web	E5347001024000	Item 14

with

3	Bolt	EN6115K3-3	Item 363
5	Bolt	EN6115K3-4	Item 364
10	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
6	Rivet	EN6081D6-06	Item 666
17	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
15	Collar	NSA5075-6	Item 806

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6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
15	Pin	DAN6-6-3	Item 863

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 56, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBGAJ Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 56, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBGAJ Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
2	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
2	Pin	DAN6-6-3	Item 863

15 On the Frame 56 flange, at STGR 35 LH, refer to Fig. A-GBGAJ Sheet 03, Section A-A, countersink the one fastener hole.

16 On the Frame 56 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBGAJ Sheet 03, Section A-A.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 56 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBGAJ Sheet 02, View C and Fig. A-GBGAJ Sheet 03, Section A-A.

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1	Angle	E5347001120000	Item 1

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBGAJ Sheet 02, View C and Fig. A-GBGAJ Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAJ Sheet 04.

19 On the Frame 56 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

20 Clean and deburr the new fastener holes in the Frame 56, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 56 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBGAJ Sheet 02, View C and Fig. A-GBGAJ Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-09	Item 669
1	Collar	DAN11-6X	Item 807
1	Pin	DAN5-6-5X	Item 765

22 On the Frame 56 flange, at STGR 36 LH, refer to Fig. A-GBGAJ Sheet 03, Section B-B, countersink the one fastener hole.

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23 On the Frame 56 flange, at STGR 36 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBGAJ Sheet 03, Section B-B.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 56 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBGAJ Sheet 02, View C and Fig. A-GBGAJ Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 2, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 2, refer to Fig. A-GBGAJ Sheet 02, View C and Fig. A-GBGAJ Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAJ Sheet 04.

26 On the Frame 56 flange, at STGR 36 LH, remove:

1	Angle	E5347001120200	Item 2

27 Clean and deburr the new fastener holes in the Frame 56, STGR 36 LH and angle, Item 2, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 56 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBGAJ Sheet 02, View C and Fig. A-GBGAJ Sheet 03, Section B-B.

1	Angle	E5347001120200	Item 2

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

29 On the Frame 56 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBGAJ Sheet 02, View C and Fig. A-GBGAJ Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

6	Rivet	EN6081D6-09	Item 669
4	Collar	NSA5075-6	Item 806
4	Pin	DAN5-6-3	Item 963

30 On the aft side of the Frame 56 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBGAJ Sheet 02, View C.

1	Angle	D5347046824000	Item (121)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

31 On the Frame 56 flange, at STGR 39 LH, refer to Fig. A-GBGAJ Sheet 03, Section D-D, countersink the one fastener hole.

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32 On the Frame 56 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBGAJ Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 56 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBGAJ Sheet 02, View C and Fig. A-GBGAJ Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBGAJ Sheet 02, View C and Fig. A-GBGAJ Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBGAJ Sheet 04.

35 On the Frame 56 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

36 Clean and deburr the new fastener holes in the Frame 56, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

37 On the Frame 56 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBGAJ Sheet 02, View C and Fig. A-GBGAJ Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(10) Subtask 531364-831-210-015 - Replace the Shear Web and the Frame Clips from Frame 57, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 57 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D09R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	E5347001120000	1	ANGLE	
18	E5347001025600	1	WEB	
20	E5347001123800	1	ANGLE	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
36	E5347001124200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
364	EN6115K3-4	5	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	5	RIVET	
667	EN6081D6-07	1	RIVET	
668	EN6081D6-08	17	RIVET	(1)
669	EN6081D6-09	10	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	19	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	10	NUT	
863	DAN6-6-3	11	PIN	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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.

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NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBHAJ Replacement of Webs and Angles at Frame 57	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBHAJ Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 57, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347081820000	Item (12)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 57, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

8	Rivet		Item (100)	Discard

3 From Frame 57, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347081720000	Item (13)	Discard

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with

13	Rivet		Item (100)	Discard

4 From Frame 57, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347081620600	Item (14)	Discard
1	Support	D5347032200000	Item (101)	Retain
1	Angle	D5347046823600	Item (118)	Retain

with

57	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 57.

Refer to NTM 51-10-01.

Refer to Fig. A-GBHAJ Sheet 02, Views C, D and F.

1 On Frame 57, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 57, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 6 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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4 On the top flange of Frame 57, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBHAJ Sheet 02 thru Fig. A-GBHAJ Sheet 04.

1 On Frame 57, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBHAJ Sheet 02, View C.

1	Shear Web	E5347001025600	Item 18

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 57 to the shear web, Item 18.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAJ Sheet 04.

4 Drill the additional 8 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBHAJ Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBHAJ Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAJ Sheet 04.

5 Transfer drill the tack hole from the Frame 57 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 57 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 4005 and subsequent.

7 On Frame 57, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025600	Item 18

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8 Clean and deburr the new fastener holes in Frame 57 and the shear web, Item 18, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBHAJ Sheet 02, Views C, D and F.

a On Frame 57, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBHAJ Sheet 02, View C.

1	Shear Web	E5347001025600	Item 18

b On Frame 57, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAJ Sheet 02, View C.

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c On Frame 57, between STGR 36 LH and STGR 37 LH, cold expand the 6 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAJ Sheet 02, View C.

d On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAJ Sheet 02, View D.

e On the top flange of Frame 57, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBHAJ Sheet 02, View F.

10 On Frame 57, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025600	Item 18

11 Clean and deburr the cold expansion fastener holes in Frame 57 and the shear web, Item 18, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 57, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBHAJ Sheet 02, View C.

1	Shear Web	E5347001025600	Item 18

with

3	Bolt	EN6115K3-3	Item 363

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5	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
8	Rivet	EN6081D5-06	Item 656
5	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
13	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863
1	Pin	DAN5-6-3	Item 963
2	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 57, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBHAJ Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 57, between STGR 35 LH and STGR 36 LH, install:

Refer to Fig. A-GBHAJ Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

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15 On the Frame 57 flange, at STGR 35 LH, refer to Fig. A-GBHAJ Sheet 03, Section A-A, countersink the one fastener hole.

16 On the Frame 57 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBHAJ Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 57 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBHAJ Sheet 02, View C and Fig. A-GBHAJ Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 1, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 1, refer to Fig. A-GBHAJ Sheet 02, View C and Fig. A-GBHAJ Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAJ Sheet 04.

19 On the Frame 57 flange, at STGR 35 LH, remove:

1	Angle	E5347001120000	Item 1

20 Clean and deburr the new fastener holes in the Frame 57, STGR 35 LH and angle, Item 1, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 57 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBHAJ Sheet 02, View C and Fig. A-GBHAJ Sheet 03, Section A-A.

1	Angle	E5347001120000	Item 1

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

22 On the Frame 57 flange, at STGR 36 LH, refer to Fig. A-GBHAJ Sheet 03, Section B-B, countersink the one fastener hole.

23 On the Frame 57 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBHAJ Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 57 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBHAJ Sheet 02, View C and Fig. A-GBHAJ Sheet 03, Section B-B.

1	Angle	E5347001123800	Item 20

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 20, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the two holes from the Frame to the angle, Item 20, refer to Fig. A-GBHAJ Sheet 02, View C and Fig. A-GBHAJ Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBHAJ Sheet 04.

26 On the Frame 57 flange, at STGR 36 LH, remove:

1	Angle	E5347001123800	Item 20

27 Clean and deburr the new fastener holes in the Frame 57, STGR 36 LH and angle, Item 20, use:

	Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 57 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBHAJ Sheet 02, View C and Fig. A-GBHAJ Sheet 03, Section B-B.

1	Angle	E5347001123800	Item 20	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656	
1	Rivet	EN6081D6-07	Item 667	
1	Collar	NSA5075-6	Item 806	
1	Pin	DAN5-6-4	Item 964	

29 On the Frame 57 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBHAJ Sheet 02, View C and Fig. A-GBHAJ Sheet 03, Section C-C.

1	Support	D5347032200000	Item (101)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

6	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

30 On the Frame 57 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBHAJ Sheet 02, View C.

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1	Angle	D5347046823600	Item (118)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-09	Item 669	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

31 On the Frame 57 flange, at STGR 39 LH, refer to Fig. A-GBHAJ Sheet 03, Section D-D, countersink the one fastener hole.

32 On the Frame 57 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBHAJ Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

33 On the Frame 57 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBHAJ Sheet 02, View C and Fig. A-GBHAJ Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 36, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the two holes from the Frame to the angle, Item 36, refer to Fig. A-GBHAJ Sheet 02, View C and Fig. A-GBHAJ Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBHAJ Sheet 04.

35 On the Frame 57 flange, at STGR 39 LH, remove:

1	Angle	E5347001124200	Item 36

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36 Clean and deburr the new fastener holes in the Frame 57, STGR 39 LH and angle, Item 36, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

37 On the Frame 57 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBHAJ Sheet 02, View C and Fig. A-GBHAJ Sheet 03, Section D-D.

1	Angle	E5347001124200	Item 36

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

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(11) Subtask 531364-831-211-015 - Replace the Shear Web and the Frame Clips from Frame 58, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 58 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D09R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
22	E5347001025800	1	WEB	
24	E5347001120600	1	ANGLE	
26	E5347001120800	1	ANGLE	
70	E5347001124400	1	ANGLE	
363	EN6115K3-3	5	BOLT	
364	EN6115K3-4	3	BOLT	
374	EN6115K3A4	2	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	12	RIVET	
657	EN6081D5-07	3	RIVET	
666	EN6081D6-06	2	RIVET	
667	EN6081D6-07	4	RIVET	
668	EN6081D6-08	6	RIVET	(1)
670	EN6081D7-10	4	RIVET	
678	EN6081D7-08	4	RIVET	
764	DAN5-6-4X	7	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	22	COLLAR	
807	DAN11-6X	9	COLLAR	
808	ASNA2528-3	9	NUT	
863	DAN6-6-3	11	PIN	
908	ASNA2528-3A	2	NUT	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	5	PIN	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
965	DAN5-6-5	2	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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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NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBJAJ Replacement of Webs and Angles at Frame 58	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBJAJ Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 58, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347082420000	Item (15)	Discard
	with			
13	Rivet		Item (100)	Discard

2 From the top flange of Frame 58, between STGR 35 LH and STGR 36 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 58, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347080520000	Item (16)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 58, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347083020600	Item (17)	Discard
1	Support	D5347032200600	Item (104)	Retain
1	Angle	D5347046824200	Item (125)	Retain
	with			
50	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

Non Aqueous Cleaner - General	08BAA9	As required

and

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Textile - Lint Free Cotton	14SBA1	As required

(c) Inspect the existing holes for cracks on Frame 58.

Refer to NTM 51-10-01.

Refer to Fig. A-GBJAJ Sheet 02, Views C, D and F.

1 On Frame 58, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 58, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 7 holes for the fasteners, Item 363, Item 364 and Item 374, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N AND STDN 6-1-N.

3 On the top flange of Frame 58, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 On the top flange of Frame 58, between STGR 37 LH and STGR 38 LH, do a rotating probe inspection for cracks of 1 hole, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 6-3-N.

5 In case of crack indication, contact AIRBUS for further instructions.

6 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBJAJ Sheet 02 thru Fig. A-GBJAJ Sheet 04.

1 On Frame 58, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBJAJ Sheet 02, View C.

1	Shear Web	E5347001025800	Item 22

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

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3 Transfer drill the fastener holes from the Frame 58 to the shear web, Item 22.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAJ Sheet 04.

4 Drill the additional 10 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBJAJ Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBJAJ Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAJ Sheet 04.

5 Transfer drill the tack hole from the Frame 58 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 58 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 4005 and subsequent.

7 On Frame 58, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025800	Item 22

8 Clean and deburr the new fastener holes in Frame 58 and the shear web, Item 22, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBJAJ Sheet 02, Views C, D and F.

a On Frame 58, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBJAJ Sheet 02, View C.

1	Shear Web	E5347001025800	Item 22

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b On Frame 58, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAJ Sheet 02, View C.

c On Frame 58, between STGR 36 LH and STGR 37 LH, cold expand the 5 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAJ Sheet 02, View C.

d On Frame 58, between STGR 36 LH and STGR 37 LH, cold expand the 2 holes for the fasteners, Item 374. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-1-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAJ Sheet 02, View C.

e On the top flange of Frame 58, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1

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DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAJ Sheet 02, View D.

f On the top flange of Frame 58, between STGR 37 LH and STGR 38 LH, cold expand 1 hole. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 6-3-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBJAJ Sheet 02, View F.

10 On Frame 58, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001025800	Item 22

11 Clean and deburr the cold expansion fastener holes in Frame 58 and the shear web, Item 22, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 58, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBJAJ Sheet 02, View C.

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1	Shear Web	E5347001025800	Item 22
	with		
4	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
2	Bolt	EN6115K3A4	Item 374
15	Rivet	EN6069D6-07	Item 567
7	Pin	DAN5-6-4X	Item 764
8	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-06	Item 666
4	Rivet	EN6081D6-08	Item 668
4	Rivet	EN6081D7-08	Item 678
15	Collar	NSA5075-6	Item 806
7	Collar	DAN11-6X	Item 807
7	Nut	ASNA2528-3	Item 808
10	Pin	DAN6-6-3	Item 863
2	Nut	ASNA2528-3A	Item 908
5	Pin	DAN5-6-4	Item 964
	use		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 58, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBJAJ Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 58, at STGR 35 LH, install:

Refer to Fig. A-GBJAJ Sheet 02, View D.

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1	Bolt	EN6114K3-3	Item 463
1	Collar	NSA5075-6	Item 806
1	Nut	ASNA2528-3	Item 808
1	Pin	DAN6-6-3	Item 863

15 On the Frame 58 flange, at STGR 35 LH, refer to Fig. A-GBJAJ Sheet 03, Section A-A, countersink the one fastener hole.

16 On the Frame 58 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBJAJ Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 58 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBJAJ Sheet 02, View C and Fig. A-GBJAJ Sheet 03, Section A-A.

1	Angle	E5347001120600	Item 24

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 24, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the three holes from the Frame to the angle, Item 24, refer to Fig. A-GBJAJ Sheet 02, View C and Fig. A-GBJAJ Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAJ Sheet 04.

19 On the Frame 58 flange, at STGR 35 LH, remove:

1	Angle	E5347001120600	Item 24

20 Clean and deburr the new fastener holes in the Frame 58, STGR 35 LH and angle, Item 24, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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21 On the Frame 58 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBJAJ Sheet 02, View C and Fig. A-GBJAJ Sheet 03, Section A-A.

1	Angle	E5347001120600	Item 24
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-06	Item 656
1	Pin	DAN5-6-5X	Item 765
2	Collar	NSA5075-6	Item 806
1	Collar	DAN11-6X	Item 807
2	Pin	DAN5-6-5	Item 965

22 On the Frame 58 flange, at STGR 36 LH, refer to Fig. A-GBJAJ Sheet 03, Section B-B, countersink the one fastener hole.

23 On the Frame 58 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBJAJ Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 58 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBJAJ Sheet 02, View C and Fig. A-GBJAJ Sheet 03, Section B-B.

1	Angle	E5347001120800	Item 26

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 26, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH to the angle, Item 26, refer to Fig. A-GBJAJ Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAJ Sheet 04.

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26 Transfer drill and ream one new hole from the pilot hole of the angle, Item 26, to the Frame 58 flange, at STGR 36 LH, then transfer drill and ream the two holes from the Frame to the angle, Item 26, refer to Fig. A-GBJAJ Sheet 02, View E.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBJAJ Sheet 04.

27 On the Frame 58 flange, at STGR 36 LH, remove:

1	Angle	E5347001120800	Item 26

28 Clean and deburr the new fastener holes in the Frame 58, STGR 36 LH and angle, Item 26, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

29 On the Frame 58 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBJAJ Sheet 02, View C and Fig. A-GBJAJ Sheet 03, Section B-B.

1	Angle	E5347001120800	Item 26

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

30 On the Frame 58 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBJAJ Sheet 02, View C and Fig. A-GBJAJ Sheet 03, Section C-C.

1	Support	D5347032200600	Item (104)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Rivet	EN6081D7-10	Item 670	
4	Collar	NSA5075-6	Item 806	
4	Pin	DAN5-6-3	Item 963	

31 On the aft side of the Frame 58 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBJAJ Sheet 02, View C.

1	Angle	D5347046820800	Item (125)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

32 On the Frame 58 flange, at STGR 39 LH, refer to Fig. A-GBJAJ Sheet 03, Section D-D, countersink the one fastener hole.

33 On the Frame 58 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBJAJ Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

34 On the Frame 58 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBJAJ Sheet 02, View C and Fig. A-GBJAJ Sheet 03, Section D-D.

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1	Angle	E5347001124400	Item 70

35 Transfer drill and ream one new hole from the pilot hole of the angle, Item 70, to the STGR 39 LH, then transfer drill and ream the other hole from the STGR 39 LH and the two holes from the Frame to the angle, Item 70, refer to Fig. A-GBJAJ Sheet 02, View C and Fig. A-GBJAJ Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBJAJ Sheet 04.

36 On the Frame 58 flange, at STGR 39 LH, remove:

1	Angle	E5347001124400	Item 70

37 Clean and deburr the new fastener holes in the Frame 58, STGR 39 LH and angle, Item 70, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

38 On the Frame 58 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBJAJ Sheet 02, View C and Fig. A-GBJAJ Sheet 03, Section D-D.

1	Angle	E5347001124400	Item 70

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

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for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(12) Subtask 531364-831-212-016 - Replace the Shear Web and the Frame Clips from Frame 59, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Work location	Frame 59 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D09R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
28	E5347001026000	1	WEB	
30	E5347001121000	1	ANGLE	
32	E5347001121200	1	ANGLE	
72	E5347001124600	1	ANGLE	
363	EN6115K3-3	5	BOLT	
364	EN6115K3-4	2	BOLT	
365	EN6115K3-5	3	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	2	RIVET	
556	EN6069D5-06	1	RIVET	
567	EN6069D6-07	15	RIVET	
656	EN6081D5-06	20	RIVET	
657	EN6081D5-07	2	RIVET	
666	EN6081D6-06	20	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	9	RIVET	(1)

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
669	EN6081D6-09	3	RIVET	(2)
764	DAN5-6-4X	3	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	22	COLLAR	
807	DAN11-6X	5	COLLAR	
808	ASNA2528-3	11	NUT	
863	DAN6-6-3	9	PIN	
963	DAN5-6-3	4	PIN	
964	DAN5-6-4	6	PIN	
965	DAN5-6-5	3	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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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.

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBKAJ Replacement of Webs and Angles at Frame 59	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBKAJ Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 59, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347089120000	Item (18)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 59, at STGR 35 LH and from the frame flange between STGR 35 LH and STGR 36 LH, remove:

5	Rivet		Item (100)	Discard

3 From Frame 59, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347089020000	Item (19)	Discard
	with			
14	Rivet		Item (100)	Discard

4 From Frame 59, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347088920800	Item (20)	Discard
1	Support	D5347032201000	Item (106)	Retain

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1	Angle	D5347046824400	Item (127)	Retain
	with			
60	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 59.

Refer to NTM 51-10-01.

Refer to Fig. A-GBKAJ Sheet 02, Views C and D.

1 On Frame 59, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 3 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 59, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 7 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 59, between STGR 35 LH and STGR 36 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBKAJ Sheet 02 thru Fig. A-GBKAJ Sheet 04.

1 On Frame 59, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBKAJ Sheet 02, View C.

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1 Shear Web E5347001026000 Item 28

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 59 to the shear web, Item 28.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAJ Sheet 04.

4 Drill the additional 17 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBKAJ Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBKAJ Sheet 02.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAJ Sheet 04.

5 Transfer drill the tack hole from the Frame 59 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 59 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 4005 and subsequent.

7 On Frame 59, between STGR 34 LH and STGR 39 LH, remove:

1 Shear Web E5347001026000 Item 28

8 Clean and deburr the new fastener holes in Frame 59 and the shear web, Item 28, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBKAJ Sheet 02, Views C and D.

a On Frame 59, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBKAJ Sheet 02, View C.

1 Shear Web E5347001026000 Item 28

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b On Frame 59, between STGR 35 LH and STGR 36 LH, cold expand the 3 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAJ Sheet 02, View C.

c On Frame 59, between STGR 36 LH and STGR 37 LH, cold expand the 7 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAJ Sheet 02, View C.

d On the top flange of Frame 59, between STGR 35 LH and STGR 36 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBKAJ Sheet 02, View D.

10 On Frame 59, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001026000	Item 28

11 Clean and deburr the cold expansion fastener holes in Frame 59 and the shear web, Item 28, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 59, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBKAJ Sheet 02, View C.

1	Shear Web	E5347001026000	Item 28

with

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4	Bolt	EN6115K3-3	Item 363
2	Bolt	EN6115K3-4	Item 364
15	Rivet	EN6069D6-07	Item 567
16	Rivet	EN6081D5-06	Item 656
20	Rivet	EN6081D6-06	Item 666
5	Rivet	EN6081D6-08	Item 668
3	Pin	DAN5-6-4X	Item 764
15	Collar	NSA5075-6	Item 806
3	Collar	DAN11-6X	Item 807
6	Nut	ASNA2528-3	Item 808
9	Pin	DAN6-6-3	Item 863
6	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 Install 1 fastener in the flange of Frame 59, between STGR 35 LH and STGR 36 LH:

Refer to Fig. A-GBKAJ Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 59, at STGR 35 LH, install:

Refer to Fig. A-GBKAJ Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

15 On the Frame 59 flange, at STGR 35 LH, refer to Fig. A-GBKAJ Sheet 03, Section A-A, countersink the one fastener hole.

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16 On the Frame 59 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBKAJ Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 59 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBKAJ Sheet 02, View C and Fig. A-GBKAJ Sheet 03, Section A-A.

1	Angle	E5347001121000	Item 30

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 30, to the STGR 35 LH, then transfer drill and ream the other hole form STGR 35 LH and the three holes from the Frame to the angle, Item 30, refer to Fig. A-GBKAJ Sheet 02, View C and Fig. A-GBKAJ Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAJ Sheet 04.

19 On the Frame 59 flange, at STGR 35 LH, remove:

1	Angle	E5347001121000	Item 30

20 Clean and deburr the new fastener holes in the Frame 59, STGR 35 LH and angle, Item 30, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 59 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBKAJ Sheet 02, View C and Fig. A-GBKAJ Sheet 03, Section A-A.

1	Angle	E5347001121000	Item 30

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656
3	Collar	NSA5075-6	Item 806
3	Pin	DAN5-6-5	Item 965

22 On the Frame 59 flange, at STGR 36 LH, refer to Fig. A-GBKAJ Sheet 03, Section B-B, countersink the one fastener hole.

23 On the Frame 59 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBKAJ Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 59 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBKAJ Sheet 02, View C and Fig. A-GBKAJ Sheet 03, Section B-B.

1	Angle	E5347001121200	Item 32

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 32, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 32, refer to Fig. A-GBKAJ Sheet 02, View C and Fig. A-GBKAJ Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBKAJ Sheet 04.

26 On the Frame 59 flange, at STGR 36 LH, :

1	Angle	E5347001121200	Item 32

27 Clean and deburr the new fastener holes in the Frame 59, STGR 36 LH and angle, Item 32, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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28 On the Frame 59 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBKAJ Sheet 02, View C and Fig. A-GBKAJ Sheet 03, Section B-B.

1	Angle	E5347001121200	Item 32	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D5-06	Item 656	
3	Rivet	EN6081D6-07	Item 667	

29 On the Frame 59 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBKAJ Sheet 02, View C and Fig. A-GBKAJ Sheet 03, Section C-C.

1	Support	D5347032201000	Item (106)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Bolt	EN6115K3-5	Item 365	
3	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
3	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	

30 On the Frame 59 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBKAJ Sheet 02, View C.

1	Angle	D5347046824400	Item (127)	Retained at removal
	with			

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

31 On the Frame 59 flange, at STGR 39 LH, refer to Fig. A-GBKAJ Sheet 03, Section D-D, countersink the one fastener hole.

32 On the Frame 59 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBKAJ Sheet 03, Section D-D.

1	Rivet	EN6069D5-06	Item 556

with

	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 59 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBKAJ Sheet 02, View C and Fig. A-GBKAJ Sheet 03, Section D-D.

1	Angle	E5347001124600	Item 72

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 72, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 72, refer to Fig. A-GBKAJ Sheet 02, View C and Fig. A-GBKAJ Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBKAJ Sheet 04.

35 On the Frame 59 flange, at STGR 39 LH, remove:

1	Angle	E5347001124600	Item 72

36 Clean and deburr the new fastener holes in the Frame 59, STGR 39 LH and angle, Item 72, use:

	Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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	Non Aqueous Cleaner - General	08BAA9	As required

37 On the Frame 59 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBKAJ Sheet 02, View C and Fig. A-GBKAJ Sheet 03, Section D-D.

1	Angle	E5347001124600	Item 72
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
	and		
2	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

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(13) Subtask 531364-831-213-015 - Replace the Shear Web and the Frame Clips from Frame 60, between STGR 34 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 60 from Stringer 34 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D09R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
34	E5347001024200	1	WEB	
38	E5347001121600	1	ANGLE	
40	E5347001121800	1	ANGLE	
82	E5347001125600	1	ANGLE	
363	EN6115K3-3	5	BOLT	
365	EN6115K3-5	8	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	3	RIVET	
567	EN6069D6-07	8	RIVET	
656	EN6081D5-06	43	RIVET	
666	EN6081D6-06	25	RIVET	
667	EN6081D6-07	3	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	4	RIVET	(2)
764	DAN5-6-4X	4	PIN	
765	DAN5-6-5X	1	PIN	
806	NSA5075-6	17	COLLAR	
807	DAN11-6X	5	COLLAR	
808	ASNA2528-3	14	NUT	
863	DAN6-6-3	12	PIN	
963	DAN5-6-3	5	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBLAJ Replacement of Webs and Angles at Frame 60	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBLAJ Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 60, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347085020000	Item (21)	Discard
	with			
14	Rivet		Item (100)	Discard

2 From the top flange of Frame 60, at STGR 35 LH and from the frame flange between STGR 34 LH and STGR 35 LH, remove:

7	Rivet		Item (100)	Discard

3 From Frame 60, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347085120000	Item (22)	Discard
	with			
13	Rivet		Item (100)	Discard

4 From Frame 60, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347093121000	Item (23)	Discard
1	Support Assy	D5347032203000	Item (108)	Retain
1	Angle	D5347046821200	Item (128)	Retain
	with			
65	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

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(c) Inspect the existing holes for cracks on Frame 60.

Refer to NTM 51-10-01.

Refer to Fig. A-GBLAJ Sheet 02, Views C and D.

1 On Frame 60, at STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 60, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 60, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBLAJ Sheet 02 thru Fig. A-GBLAJ Sheet 04.

1 On Frame 60, between STGR 34 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBLAJ Sheet 02, View C.

1	Shear Web	E5347001024200	Item 34

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 60 to the shear web, Item 34.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAJ Sheet 04.

4 Drill the additional 38 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBLAJ Sheet 02, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBLAJ Sheet 02.

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NOTE: For the hole diameters, refer to the table on Fig. A-GBLAJ Sheet 04.

5 Transfer drill the tack hole from the Frame 60 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 60 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 4005 and subsequent.

7 On Frame 60, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024200	Item 34

8 Clean and deburr the new fastener holes in Frame 60 and the shear web, Item 34, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBLAJ Sheet 02, Views C and D.

a On Frame 60, between STGR 34 LH and STGR 39 LH, put in position:

1	Shear Web	E5347001024200	Item 34

b On Frame 60, at STGR 35 LH, cold expand the 4 holes for the fasteners, Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

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WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAJ Sheet 02, View C.

c On Frame 60, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAJ Sheet 02, View C.

d On the top flange of Frame 60, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

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For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBLAJ Sheet 02, View D.

10 On Frame 60, between STGR 34 LH and STGR 39 LH, remove:

1	Shear Web	E5347001024200	Item 34

11 Clean and deburr the cold expansion fastener holes in Frame 60 and the shear web, Item 34, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 60, between STGR 34 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBLAJ Sheet 02, View C.

1	Shear Web	E5347001024200	Item 34

with

5	Bolt	EN6115K3-3	Item 363
8	Rivet	EN6069D6-07	Item 567
37	Rivet	EN6081D5-06	Item 656
23	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
3	Pin	DAN5-6-4X	Item 764
12	Collar	NSA5075-6	Item 806
3	Collar	DAN11-6X	Item 807
5	Nut	ASNA2528-3	Item 808

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12	Pin	DAN6-6-3	Item 863

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 On the top flange of Frame 60, at STGR 35 LH, install:

Refer to Fig. A-GBLAJ Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

14 On the Frame 60 flange, at STGR 35 LH, refer to Fig. A-GBLAJ Sheet 03, Section A-A, countersink the one fastener hole.

15 On the Frame 60 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBLAJ Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 60 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBLAJ Sheet 02, View C and Fig. A-GBLAJ Sheet 03, Section A-A.

1	Angle	E5347001121600	Item 38

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 38, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH to the angle, Item 38, refer to Fig. A-GBLAJ Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAJ Sheet 04.

18 On the Frame 60 flange, at STGR 35 LH, remove:

1	Angle	E5347001121600	Item 38

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19 Clean and deburr the new fastener holes in the STGR 35 LH and angle, Item 38, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 60 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBLAJ Sheet 02, View C and Fig. A-GBLAJ Sheet 03, Section A-A.

1	Angle	E5347001121600	Item 38

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
2	Rivet	EN6081D5-06	Item 656
4	Nut	ASNA2528-3	Item 808

21 On the Frame 60 flange, at STGR 36 LH, refer to Fig. A-GBLAJ Sheet 03, Section B-B, countersink the one fastener hole.

22 On the Frame 60 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBLAJ Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

23 On the Frame 60 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBLAJ Sheet 02, View C and Fig. A-GBLAJ Sheet 03, Section B-B.

1	Angle	E5347001121800	Item 40

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24 Transfer drill and ream one new hole from the pilot hole of the angle, Item 40, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the three holes from the Frame to the angle, Item 40, refer to Fig. A-GBLAJ Sheet 02, View C and Fig. A-GBLAJ Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAJ Sheet 04.

25 On the Frame 60 flange, at STGR 36 LH, remove:

1	Angle	E5347001121800	Item 40	

26 Clean and deburr the new fastener holes in the Frame 60, STGR 36 LH and angle, Item 40, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

27 On the Frame 60 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBLAJ Sheet 02, View C and Fig. A-GBLAJ Sheet 03, Section B-B.

1	Angle	E5347001121800	Item 40

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D6-07	Item 667

28 On the Frame 60 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBLAJ Sheet 02, View C and Fig. A-GBLAJ Sheet 03, Section C-C.

1	Support Assy	D5347032203000	Item (108)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	
5	Collar	NSA5075-6	Item 806	
4	Nut	ASNA2528-3	Item 808	
5	Pin	DAN5-6-3	Item 963	

29 On the aft side of the Frame 60 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBLAJ Sheet 02, View C.

1	Angle	D5347046821200	Item (128)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

3	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

30 On the Frame 60 flange, at STGR 39 LH, refer to Fig. A-GBLAJ Sheet 03, Section D-D, countersink the one fastener hole.

31 On the Frame 60 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBLAJ Sheet 03, Section D-D.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

32 On the Frame 60 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBLAJ Sheet 02, View C and Fig. A-GBLAJ Sheet 03, Section D-D.

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1	Angle	E5347001125600	Item 82

33 Transfer drill and ream one new hole from the pilot hole of the angle, Item 82, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 82, refer to Fig. A-GBLAJ Sheet 02, View C and Fig. A-GBLAJ Sheet 03, Section D-D.

NOTE: For the hole diameters, refer to the table on Fig. A-GBLAJ Sheet 04.

34 On the Frame 60 flange, at STGR 39 LH, remove:

1	Angle	E5347001125600	Item 82

35 Clean and deburr the new fastener holes in the Frame 60, STGR 39 LH and angle, Item 82, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

36 On the Frame 60 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBLAJ Sheet 02, View C and Fig. A-GBLAJ Sheet 03, Section D-D.

1	Angle	E5347001125600	Item 82

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D6-06	Item 666
2	Rivet	EN6081D5-06	Item 656
1	Pin	DAN5-6-4X	Item 764
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
for internal structure, use:		
Top Coat Polyurethane	04JME4	As required
for external structure, use:		
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(14) Subtask 531364-831-214-015 - Replace the Shear Web and the Frame Clips from Frame 61, between STGR 33 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 61 from Stringer 33 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D09R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
42	E5347001022000	1	WEB	
44	E5347001122000	1	ANGLE	
46	E5347001122200	1	ANGLE	
48	E5347001122400	1	ANGLE	
74	E5347001124800	1	ANGLE	
363	EN6115K3-3	6	BOLT	
364	EN6115K3-4	3	BOLT	
365	EN6115K3-5	4	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	4	RIVET	
567	EN6069D6-07	20	RIVET	
656	EN6081D5-06	36	RIVET	
657	EN6081D5-07	2	RIVET	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
666	EN6081D6-06	23	RIVET	
667	EN6081D6-07	10	RIVET	
668	EN6081D6-08	18	RIVET	(1)
669	EN6081D6-09	6	RIVET	(2)
763	DAN5-6-3X	4	PIN	
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	3	PIN	
806	NSA5075-6	4	COLLAR	
807	DAN11-6X	13	COLLAR	
808	ASNA2528-3	14	NUT	
863	DAN6-6-3	4	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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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.

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBMAJ Replacement of Webs and Angles at Frame 61	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBMAJ Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 61, between STGR 33 LH and STGR 34 LH, remove:

1	Clip	D5347091620200	Item (24)	Discard
	with			
12	Rivet		Item (100)	Discard
	or			
13	Rivet		Item (100)	Discard

NOTE: Depending on installation on aircraft.

2 From Frame 61, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347090620000	Item (25)	Discard
	with			
13	Rivet		Item (100)	Discard

3 From the top flange of Frame 61, between STGR 34 LH and STGR 35 LH and from the frame flange between STGR 34 LH and STGR 35 LH, remove:

11	Rivet		Item (100)	Discard

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4 From Frame 61, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347090720000	Item (26)	Discard
	with			
13	Rivet		Item (100)	Discard

5 From Frame 61, between STGR 36 LH and STGR 39 LH, remove:

1	Web-Shear	D5347090821000	Item (27)	Discard
1	Support	D5347032201600	Item (109)	Retain
1	Angle	D5347046821400	Item (130)	Retain
	with			
65	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 61.

Refer to NTM 51-10-01.

Refer to Fig. A-GBMAJ Sheet 02, Views C and E.

1 On Frame 61, at STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 61, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 61, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

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4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBMAJ Sheet 02 thru Fig. A-GBMAJ Sheet 04.

1 On Frame 61, between STGR 33 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBMAJ Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 61 to the shear web, Item 42.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAJ Sheet 04.

4 Drill the additional 31 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBMAJ Sheet 02, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBMAJ Sheet 02.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAJ Sheet 04.

5 Transfer drill the tack hole from the Frame 61 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 61 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 4005 and subsequent.

7 On Frame 61, between STGR 33 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022000	Item 42

8 Clean and deburr the new fastener holes in Frame 61 and the shear web, Item 42, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBMAJ Sheet 02, Views C and E.

a On Frame 61, between STGR 33 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBMAJ Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42

b On Frame 61, at STGR 35 LH, cold expand the 4 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAJ Sheet 02, View E.

c On Frame 61, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAJ Sheet 02, View C.

d On the top flange of Frame 61, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBMAJ Sheet 02, View E.

10 On Frame 61, between STGR 33 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022000	Item 42

11 Clean and deburr the cold expansion fastener holes in Frame 61 and the shear web, Item 42, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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	Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 61, between STGR 33 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBMAJ Sheet 02, View C.

1	Shear Web	E5347001022000	Item 42
	with		
5	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364
20	Rivet	EN6069D6-07	Item 567
28	Rivet	EN6081D5-06	Item 656
22	Rivet	EN6081D6-06	Item 666
15	Rivet	EN6081D6-08	Item 668
6	Pin	DAN5-6-4X	Item 764
4	Collar	NSA5075-6	Item 806
6	Collar	DAN11-6X	Item 807
8	Nut	ASNA2528-3	Item 808
4	Pin	DAN6-6-3	Item 863
	use		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 On Frame 61, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBMAJ Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

14 On the top flange of Frame 61, at STGR 35 LH, install:

Refer to Fig. A-GBMAJ Sheet 02, View E.

1	Bolt	EN6114K3-3	Item 463

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1	Nut	ASNA2528-3	Item 808

15 On the Frame 61 flange, at STGR 34 LH, refer to Fig. A-GBMAJ Sheet 03, Section A-A, countersink the one fastener hole.

16 On the Frame 61 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBMAJ Sheet 03, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

17 On the Frame 61 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBMAJ Sheet 02, View C and Fig. A-GBMAJ Sheet 03, Section A-A.

1	Angle	E5347001122000	Item 44

18 Transfer drill and ream one new hole from the pilot hole of the angle, Item 44, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 35 LH and the four holes from the Frame to the angle, Item 44, refer to Fig. A-GBMAJ Sheet 02, View C and Fig. A-GBMAJ Sheet 03, Section A-A.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAJ Sheet 04.

19 On the Frame 61 flange, at STGR 34 LH, remove:

1	Angle	E5347001122000	Item 44

20 Clean and deburr the new fastener holes in the Frame 61, STGR 34 LH and angle, Item 44, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

21 On the Frame 61 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBMAJ Sheet 02, View C and Fig. A-GBMAJ Sheet 03, Section A-A.

1	Angle	E5347001122000	Item 44

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with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

If necessary, close the rivet hole in the frame flange at STGR 34 LH with:

1	Rivet	EN6081D6-06	Item 666

NOTE: Depending on installation on aircraft.

22 On the Frame 61 flange, at STGR 35 LH, refer to Fig. A-GBMAJ Sheet 03, Section B-B, countersink the one fastener hole.

23 On the Frame 61 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBMAJ Sheet 03, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 61 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBMAJ Sheet 02, View C and Fig. A-GBMAJ Sheet 03, Section B-B.

1	Angle	E5347001122200	Item 46

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 46, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the four holes from the Frame to the angle, Item 46, refer to Fig. A-GBMAJ Sheet 02, View C and Fig. A-GBMAJ Sheet 03, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAJ Sheet 04.

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26 On the Frame 61 flange, at STGR 35 LH, remove:

1	Angle	E5347001122200	Item 46

27 Clean and deburr the new fastener holes in the Frame 61, STGR 35 LH and angle, Item 46, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 61 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBMAJ Sheet 02, View C and Fig. A-GBMAJ Sheet 03, Section B-B.

1	Angle	E5347001122200	Item 46

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
4	Rivet	EN6081D6-07	Item 667

29 On the Frame 61 flange, at STGR 36 LH, refer to Fig. A-GBMAJ Sheet 03, Section C-C, countersink the one fastener hole.

30 On the Frame 61 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBMAJ Sheet 03, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

31 On the Frame 61 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBMAJ Sheet 02, View C and Fig. A-GBMAJ Sheet 03, Section C-C.

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1	Angle	E5347001122400	Item 48	

32 Transfer drill and ream one new hole from the pilot hole of the angle, Item 48, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 48, refer to Fig. A-GBMAJ Sheet 02, View C and Fig. A-GBMAJ Sheet 03, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAJ Sheet 04.

33 On the Frame 61 flange, at STGR 36 LH, remove:

1	Angle	E5347001122400	Item 48	

34 Clean and deburr the new fastener holes in the Frame 61, STGR 36 LH and angle, Item 48, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

35 On the Frame 61 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBMAJ Sheet 02, View C and Fig. A-GBMAJ Sheet 03, Section C-C.

1	Angle	E5347001122400	Item 48	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656	
2	Rivet	EN6081D5-07	Item 657	
3	Rivet	EN6081D6-07	Item 667	

36 On the Frame 61 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBMAJ Sheet 02, View C and Fig. A-GBMAJ Sheet 03, Section D-D.

1	Support	D5347032201600	Item (109)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	
4	Pin	DAN5-6-3X	Item 763	
4	Collar	DAN11-6X	Item 807	
4	Nut	ASNA2528-3	Item 808	

37 On the Frame 61 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBMAJ Sheet 02, View C.

1	Angle	D5347046821400	Item (130)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
3	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

38 On the Frame 61 flange, at STGR 39 LH, refer to Fig. A-GBMAJ Sheet 03, Section E-E, countersink the one fastener hole.

39 On the Frame 61 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBMAJ Sheet 03, Section E-E.

1	Rivet	EN6069D5-05	Item 555	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

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40 On the Frame 61 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBMAJ Sheet 02, View C and Fig. A-GBMAJ Sheet 03, Section E-E.

1	Angle	E5347001124800	Item 74

41 Transfer drill and ream one new hole from the pilot hole of the angle, Item 74, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the four holes from the Frame to the angle, Item 74, refer to Fig. A-GBMAJ Sheet 02, View C and Fig. A-GBMAJ Sheet 03, Section E-E.

NOTE: For the hole diameters, refer to the table on Fig. A-GBMAJ Sheet 04.

42 On the Frame 61 flange, at STGR 39 LH, remove:

1	Angle	E5347001124800	Item 74

43 Clean and deburr the new fastener holes in the Frame 61, STGR 39 LH and angle, Item 74, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

44 On the Frame 61 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBMAJ Sheet 02, View C and Fig. A-GBMAJ Sheet 03, Section E-E.

1	Angle	E5347001124800	Item 74

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

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(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(15) Subtask 531364-831-215-015 - Replace the Shear Web and the Frame Clips from Frame 62, between STGR 32 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 62 from Stringer 32 LH to Stringer 39 LH

Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D09R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
50	E5347001022200	1	WEB	
52	E5347001122600	1	ANGLE	
54	E5347001122800	1	ANGLE	
56	E5347001123000	1	ANGLE	
58	E5347001123200	1	ANGLE	
76	E5347001125000	1	ANGLE	
363	EN6115K3-3	6	BOLT	
364	EN6115K3-4	3	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
365	EN6115K3-5	4	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	5	RIVET	
567	EN6069D6-07	12	RIVET	
656	EN6081D5-06	45	RIVET	
657	EN6081D5-07	7	RIVET	
666	EN6081D6-06	21	RIVET	
667	EN6081D6-07	7	RIVET	
668	EN6081D6-08	16	RIVET	(1)
669	EN6081D6-09	8	RIVET	(2)
764	DAN5-6-4X	5	PIN	
765	DAN5-6-5X	3	PIN	
806	NSA5075-6	26	COLLAR	
807	DAN11-6X	8	COLLAR	
808	ASNA2528-3	15	NUT	
863	DAN6-6-3	16	PIN	
864	DAN6-6-4	1	PIN	
963	DAN5-6-3	5	PIN	
964	DAN5-6-4	3	PIN	
965	DAN5-6-5	1	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

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NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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.

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NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBNAJ Replacement of Webs and Angles at Frame 62	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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

(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBNAJ Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 62, between STGR 32 LH and STGR 33 LH, remove:

1	Clip	D5347093420200	Item (28)	Discard
	with			
14	Rivet		Item (100)	Discard
	or			
15	Rivet		Item (100)	Discard

NOTE: Depending on installation on aircraft.

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2 From Frame 62, between STGR 33 LH and STGR 34 LH, remove:

1	Clip	D5347084020000	Item (29)	Discard
	with			
13	Rivet		Item (100)	Discard

3 From Frame 62, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347084120000	Item (30)	Discard
	with			
11	Rivet		Item (100)	Discard

4 From the top flange of Frame 62, at STGR 34 LH and from the frame flange between STGR 32 LH and STGR 35 LH, remove:

13	Rivet		Item (100)	Discard

5 From Frame 62, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347084220000	Item (31)	Discard
	with			
11	Rivet		Item (100)	Discard

6 From Frame 62, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347084820400	Item (32)	Discard
1	Support	D5347032201800	Item (111)	Retain
1	Angle	D5347046821600	Item (131)	Retain
	with			
58	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 62.

Refer to NTM 51-10-01.

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Refer to Fig. A-GBNAJ Sheet 02, View C and Fig. A-GBNAJ Sheet 03, View F.

1 On Frame 62, between STGR 34 LH and STGR 35 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 363 and Item 364, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 62, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 9 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBNAJ Sheet 02 thru Fig. A-GBNAJ Sheet 06.

1 On Frame 62, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBNAJ Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 62 to the shear web, Item 50.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAJ Sheet 06.

4 On Frame 62, between STGR 34 LH and STGR 37 LH, drill the additional 42 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBNAJ Sheet 03, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBNAJ Sheet 03.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAJ

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Sheet 06.

5 On Frame 62, between STGR 38 LH and STGR 39 LH, drill the additional rivet hole to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBNAJ Sheet 03, View D.

NOTE: For the dimensions, refer to the table on Fig. A-GBNAJ Sheet 03.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAJ Sheet 06.

6 Transfer drill the tack hole from the Frame 62 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

7 Transfer drill the tack hole from the Frame 62 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 4005 and subsequent.

8 On Frame 62, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022200	Item 50

9 Clean and deburr the new fastener holes in Frame 62 and the shear web, Item 50, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

10 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBNAJ Sheet 02, Views C and F.

a On Frame 62, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBNAJ Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

b On Frame 62, between STGR 34 LH and STGR 35 LH, cold expand the 4 holes for the fasteners, Item 363 and Item 364. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

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FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAJ Sheet 02, View C.

c On Frame 62, between STGR 36 LH and STGR 37 LH, cold expand the 9 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAJ Sheet 02, View C.

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d On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBNAJ Sheet 03, View F.

11 On Frame 62, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022200	Item 50

12 Clean and deburr the cold expansion fastener holes in Frame 62 and the shear web, Item 50, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

13 At Frame 62, between STGR 32 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBNAJ Sheet 02, View C.

1	Shear Web	E5347001022200	Item 50

with

5	Bolt	EN6115K3-3	Item 363
3	Bolt	EN6115K3-4	Item 364

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12	Rivet	EN6069D6-07	Item 567
35	Rivet	EN6081D5-06	Item 656
1	Rivet	EN6081D5-07	Item 657
20	Rivet	EN6081D6-06	Item 666
13	Rivet	EN6081D6-08	Item 668
5	Pin	DAN5-6-4X	Item 764
21	Collar	NSA5075-6	Item 806
5	Collar	DAN11-6X	Item 807
9	Nut	ASNA2528-3	Item 808
16	Pin	DAN6-6-3	Item 863
1	Pin	DAN6-6-4	Item 864
1	Pin	DAN5-6-3	Item 963
3	Pin	DAN5-6-4	Item 964

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

14 On Frame 62, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBNAJ Sheet 02, View C.

1	Bolt	EN6115K3-3	Item 363
1	Nut	ASNA2528-3	Item 808

15 On the top flange of Frame 62, between STGR 34 LH and STGR 35 LH, install:

Refer to Fig. A-GBNAJ Sheet 03, View F.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

16 On the Frame 62 flange, at STGR 33 LH, refer to Fig. A-GBNAJ Sheet 04, Section A-A, countersink the one fastener hole.

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17 On the Frame 62 flange, at STGR 33 LH, close the rivet hole in STGR 33 LH with:

Refer to Fig. A-GBNAJ Sheet 04, Section A-A.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

18 On the Frame 62 flange, at STGR 33 LH, put in position:

Refer to Fig. A-GBNAJ Sheet 02, View C and Fig. A-GBNAJ Sheet 04, Section A-A.

1	Angle	E5347001122600	Item 52

19 Transfer drill and ream one new hole from the pilot hole of the angle, Item 52, to the STGR 33 LH, then transfer drill and ream the other hole from STGR 33 LH and the three holes from the Frame to the angle, Item 52, refer to Fig. A-GBNAJ Sheet 02, View C and Fig. A-GBNAJ Sheet 04, Section A-A.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAJ Sheet 06.

20 On the Frame 62 flange, at STGR 33 LH, remove:

1	Angle	E5347001122600	Item 52

21 Clean and deburr the new fastener holes in the Frame 62, STGR 33 LH and angle, Item 52, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

22 On the Frame 62 flange, at STGR 33 LH, wet install:

Refer to Fig. A-GBNAJ Sheet 02, View C and Fig. A-GBNAJ Sheet 04, Section A-A.

1	Angle	E5347001122600	Item 52

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Collar	NSA5075-6	Item 806
1	Pin	DAN5-6-5	Item 965

If necessary, close the rivet hole in the frame flange at STGR 34 LH with:

1	Rivet	EN6081D6-06	Item 666

23 On the Frame 62 flange, at STGR 34 LH, refer to Fig. A-GBNAJ Sheet 04, Section B-B, countersink the one fastener hole.

24 On the Frame 62 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBNAJ Sheet 04, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

25 On the Frame 62 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBNAJ Sheet 02, View C and Fig. A-GBNAJ Sheet 04, Section B-B.

1	Angle	E5347001122800	Item 54

26 Transfer drill and ream one new hole from the pilot hole of the angle, Item 54, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH and the thee holes from the Frame to the angle, Item 54, refer to Fig. A-GBNAJ Sheet 02, View C and Fig. A-GBNAJ Sheet 04, Section B-B.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAJ Sheet 06.

27 On the Frame 62 flange, at STGR 34 LH, remove:

1	Angle	E5347001122800	Item 54

28 Clean and deburr the new fastener holes in the Frame 62, STGR 34 LH and the angle, Item 54, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

29 On the Frame 62 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBNAJ Sheet 02, View C and Fig. A-GBNAJ Sheet 04, Section B-B.

1	Angle	E5347001122800	Item 54

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-09	Item 669
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

30 On the Frame 62 flange, at STGR 34 LH, install:

Refer to Fig. A-GBNAJ Sheet 02, View C.

1	Rivet	EN6081D6-07	Item 667

31 On the Frame 62 flange, at STGR 35 LH, refer to Fig. A-GBNAJ Sheet 04, Section C-C, countersink the one fastener hole.

32 On the Frame 62 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBNAJ Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

33 On the Frame 62 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBNAJ Sheet 02, View C and Fig. A-GBNAJ Sheet 04, Section C-C.

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1	Angle	E5347001123000	Item 56

34 Transfer drill and ream one new hole from the pilot hole of the angle, Item 56, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the five holes from the Frame to the angle, Item 56, refer to Fig. A-GBNAJ Sheet 02, View C and Fig. A-GBNAJ Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAJ Sheet 06.

35 On the Frame 62 flange, at STGR 35 LH, remove:

1	Angle	E5347001123000	Item 56

36 Clean and deburr the new fastener holes in the Frame 62, STGR 35 LH and angle, Item 56, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

37 On the Frame 62 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBNAJ Sheet 02, View C and Fig. A-GBNAJ Sheet 04, Section C-C.

1	Angle	E5347001123000	Item 56

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

38 On the Frame 62 flange, at STGR 36 LH, refer to Fig. A-GBNAJ Sheet 04, Section D-D, countersink the one fastener hole.

39 On the Frame 62 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBNAJ Sheet 04, Section D-D.

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1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

40 On the Frame 62 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBNAJ Sheet 02, View C and Fig. A-GBNAJ Sheet 04, Section D-D.

1	Angle	E5347001123200	Item 58

41 Transfer drill and ream one new hole from the pilot hole of the angle, Item 58, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 58, refer to Fig. A-GBNAJ Sheet 02, View C and Fig. A-GBNAJ Sheet 04, Section D-D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBNAJ Sheet 06.

42 On the Frame 62 flange, at STGR 36 LH, remove:

1	Angle	E5347001123200	Item 58

43 Clean and deburr the new fastener holes in the Frame 62, STGR 36 LH and the angle, Item 58, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

44 On the Frame 62 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBNAJ Sheet 02, View C and Fig. A-GBNAJ Sheet 04, Section D-D.

1	Angle	E5347001123200	Item 58

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656

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3	Rivet	EN6081D5-07	Item 657	
2	Rivet	EN6081D6-07	Item 667	

45 On the Frame 62 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBNAJ Sheet 02, View C and Fig. A-GBNAJ Sheet 05, Section E-E.

1	Support	D5347032201800	Item (111)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

4	Bolt	EN6115K3-5	Item 365
4	Rivet	EN6081D6-09	Item 669
4	Collar	NSA5075-6	Item 806
4	Nut	ASNA2528-3	Item 808
4	Pin	DAN5-6-3	Item 963

46 On the aft side of the Frame 62 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBNAJ Sheet 02, View C.

1	Angle	D5347046821600	Item (131)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

3	Rivet	EN6081D6-08	Item 668
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

47 On the Frame 62 flange, at STGR 39 LH, refer to Fig. A-GBNAJ Sheet 05, Section F-F, countersink the one fastener hole.

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48 On the Frame 62 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBNAJ Sheet 05, Section F-F.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

49 On the Frame 62 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBNAJ Sheet 02, View C and Fig. A-GBNAJ Sheet 05, Section F-F.

1	Angle	E5347001125000	Item 76

50 Transfer drill and ream one new hole from the pilot hole of the angle, Item 76, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 76, refer to Fig. A-GBNAJ Sheet 02, View C and Fig. A-GBNAJ Sheet 05, Section F-F.

NOTE: For the hole diameters, refer to the table on Fig. A-GBNAJ Sheet 06.

51 On the Frame 62 flange, at STGR 39 LH, remove:

1	Angle	E5347001125000	Item 76

52 Clean and deburr the new fastener holes in the Frame 62, STGR 39 LH and angle, Item 76, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

53 On the Frame 62 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBNAJ Sheet 02, View C and Fig. A-GBNAJ Sheet 05, Section F-F.

1	Angle	E5347001125000	Item 76

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(16) Subtask 531364-831-216-015 - Replace the Shear Web and the Frame Clips from Frame 63, between STGR 32 LH and STGR 39 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	160	Work location	Frame 63 from Stringer 32 LH to Stringer 39 LH

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Manpower Resources	
Manhours	15.25
Minimum number of person	2
Subtask elapsed time	13.75
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 531364D09R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
60	E5347001022400	1	WEB	
62	E5347001123400	1	ANGLE	
64	E5347001123600	2	ANGLE	
78	E5347001125200	1	ANGLE	
363	EN6115K3-3	4	BOLT	
365	EN6115K3-5	8	BOLT	
463	EN6114K3-3	1	BOLT	
555	EN6069D5-05	4	RIVET	
567	EN6069D6-07	11	RIVET	
656	EN6081D5-06	43	RIVET	
657	EN6081D5-07	6	RIVET	
666	EN6081D6-06	22	RIVET	
667	EN6081D6-07	6	RIVET	
668	EN6081D6-08	12	RIVET	(1)
669	EN6081D6-09	7	RIVET	(2)
764	DAN5-6-4X	6	PIN	
765	DAN5-6-5X	2	PIN	
806	NSA5075-6	22	COLLAR	
807	DAN11-6X	2	COLLAR	
808	ASNA2528-3	13	NUT	
863	DAN6-6-3	13	PIN	
864	DAN6-6-4	1	PIN	
963	DAN5-6-3	8	PIN	

NOTE (1): PN ASNA2050DXJ4813 can be used as an alternative.

NOTE (2): PN ASNA2050DXJ4814 can be used as an alternative.

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 - Decorative External Struc	04JMD3	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Top Coat Polyurethane	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)
	FTIA320531364-1	Capital Tooling	1	(3)

NOTE: 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 ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital tool kit No.: FTI-A320-53-1364-1

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 FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531364-1	Durable Tooling	1	(1)
	EK-A320531364-1	Expendable Tooling	1	(2)

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ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	WCIA320531364-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

NOTE (1): Durable tool kit No.: DK-A320-53-1364-1

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

NOTE (2): Expendable tool kit No.: EK-A320-53-1364-1

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.

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1364-1

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 WCI.

References	
Consumable Material List (CML)	
Non Destructive Test Manual (NTM)	51-10-01
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GBPAJ Replacement of Webs and Angles at Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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

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(a) Remove the frame clips and the shear web.

Refer to Fig. A-GBPAJ Sheet 01, View B.

NOTE: Only non-metallic tools must be used to separate the structural parts.

NOTE: Only non-metallic scraper must be used to remove sealant.

1 From Frame 63, at STGR 33 LH, remove:

1	Shim	D5347032020200	Item (132)	Retain
1	Sheet-Support	D5347109620000	Item (133)	Retain
	with			
7	Rivet		Item (100)	Discard

2 From Frame 63, between STGR 32 LH and STGR 34 LH, remove:

1	Clip	D5347082820000	Item (33)	Discard
	with			
21	Rivet		Item (100)	Discard

3 From the top flange of Frame 63, at STGR 34 LH and from the frame flange between STGR 33 LH and STGR 34 LH, remove:

5	Rivet		Item (100)	Discard

4 From Frame 63, between STGR 34 LH and STGR 35 LH, remove:

1	Clip	D5347079220000	Item (34)	Discard
	with			
10	Rivet		Item (100)	Discard

5 From Frame 63, between STGR 35 LH and STGR 36 LH, remove:

1	Clip	D5347079920000	Item (35)	Discard
	with			
11	Rivet		Item (100)	Discard

6 From Frame 63, between STGR 36 LH and STGR 39 LH, remove:

1	Shear Web	D5347082920200	Item (36)	Discard
1	Support	D5347032202000	Item (114)	Retain

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1	Angle	D5347046821800	Item (115)	Retain
	with			
55	Rivet		Item (100)	Discard

(b) Clean the frame and the retained parts with:

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

(c) Inspect the existing holes for cracks on Frame 63.

Refer to NTM 51-10-01.

Refer to Fig. A-GBPAJ Sheet 02, Views C and D.

1 On Frame 63, at STGR 34 LH, do a rotating probe inspection for cracks of 4 holes for the fasteners, Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

2 On Frame 63, between STGR 36 LH and STGR 37 LH, do a rotating probe inspection for cracks of 8 holes for the fasteners, Item 363 and Item 365, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the holes in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

3 On the top flange of Frame 63, at STGR 35 LH, do a rotating probe inspection for cracks of 1 hole for the fastener, Item 463, refer to NTM 51-10-01.

NOTE: Obtain the start diameter of the hole in accordance with SRM 51-48-00 standard tool diameter STDN 4-4-N.

4 In case of crack indication, contact AIRBUS for further instructions.

5 In case of no crack indication, proceed with the next workstep.

(d) Install the enlarged shear web and the support angles.

Refer to Fig. A-GBPAJ Sheet 02 thru Fig. A-GBPAJ Sheet 06.

1 On Frame 63, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBPAJ Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

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2 Check the installation of the enlarged shear web to the fuselage skin. Make sure there is no gap between the structure parts. If necessary install tapered shims made from ABS5044.

3 Transfer drill the fastener holes from the Frame 63 to the shear web, Item 60.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAJ Sheet 06.

4 On Frame 63, between STGR 34 LH and STGR 37 LH, drill the additional 41 rivet holes to between 4.060mm (0.1599in) and 4.170mm (0.1641in), refer to Fig. A-GBPAJ Sheet 03, View E.

NOTE: For the dimensions, refer to the table on Fig. A-GBPAJ Sheet 03.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAJ Sheet 06.

5 Transfer drill the tack hole from the Frame 63 between STGR 36 LH and STGR 37 LH to the shear web with a 6.100mm (0.2401in) dia. drill.

6 Transfer drill the tack hole from the Frame 63 between STGR 37 LH and STGR 38 LH to the shear web with a 4.300mm (0.1692in) dia. drill.

NOTE: This workstep is only applicable to MSN 4005 and subsequent.

7 On Frame 63, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022400	Item 60

8 Clean and deburr the new fastener holes in Frame 63 and the shear web, Item 60, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

9 Cold expand the holes.

In accordance with SRM 51-48-00.

Refer to Fig. A-GBPAJ Sheet 02, Views C and D.

a On Frame 63, between STGR 32 LH and STGR 39 LH, put in position:

Refer to Fig. A-GBPAJ Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

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b On Frame 63, at STGR 34 LH, cold expand the 4 holes for the fasteners, Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAJ Sheet 02, View C.

c On Frame 63, between STGR 36 LH and STGR 37 LH, cold expand the 8 holes for the fasteners, Item 363 and Item 365. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

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NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAJ Sheet 02, View C.

d On the top flange of Frame 63, at STGR 35 LH, cold expand 1 hole for the fastener, Item 463. Do the cold expansion procedure in accordance with SRM 51-48-00 with the standard tool diameter STDN 4-4-N.

For cold expansion, use the mechanically-operated cold-expansion-tool included in the FTI tool kits:

FTIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

or

For cold expansion, use the mechanically-operated cold-expansion-tool included in the WCI tool kits:

WCIA320531364-1	Capital Tooling	1
DK-A320531364-1	Durable Tooling	1
EK-A320531364-1	Expendable Tooling	1

NOTE: Be careful with the direction of the sleeve split at cold expansion, refer to Fig. A-GBPAJ Sheet 02, View D.

10 On Frame 63, between STGR 32 LH and STGR 39 LH, remove:

1	Shear Web	E5347001022400	Item 60

11 Clean and deburr the cold expansion fastener holes in Frame 63 and the shear web, Item 60, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

12 At Frame 63, between STGR 32 LH and STGR 39 LH, wet install:

Refer to Fig. A-GBPAJ Sheet 02, View C.

1	Shear Web	E5347001022400	Item 60

with

4	Bolt	EN6115K3-3	Item 363

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11	Rivet	EN6069D6-07	Item 567	
1	Pin	DAN6-6-4	Item 864	
35	Rivet	EN6081D5-06	Item 656	
22	Rivet	EN6081D6-06	Item 666	
10	Rivet	EN6081D6-08	Item 668	
6	Pin	DAN5-6-4X	Item 764	
14	Collar	NSA5075-6	Item 806	
4	Nut	ASNA2528-3	Item 808	
13	Pin	DAN6-6-3	Item 863	

use

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

13 On the Frame 63 flange, at STGR 33 LH, wet install:

Refer to Fig. A-GBPAJ Sheet 02, View C and Fig. A-GBPAJ Sheet 04, Section A-A.

1	Shim	D5347032020200	Item (132)	Retained at removal
1	Sheet-Support	D5347109620000	Item (133)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

3	Rivet	EN6081D6-09	Item 669
4	Collar	NSA5075-6	Item 806
4	Pin	DAN5-6-3	Item 963

14 On the Frame 63 flange, at STGR 34 LH, refer to Fig. A-GBPAJ Sheet 04, Section B-B, countersink the one fastener hole.

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15 On the Frame 63 flange, at STGR 34 LH, close the rivet hole in STGR 34 LH with:

Refer to Fig. A-GBPAJ Sheet 04, Section B-B.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

16 On the Frame 63 flange, at STGR 34 LH, put in position:

Refer to Fig. A-GBPAJ Sheet 02, View C and Fig. A-GBPAJ Sheet 04, Section B-B.

1	Angle	E5347001123400	Item 62

17 Transfer drill and ream one new hole from the pilot hole of the angle, Item 62, to the STGR 34 LH, then transfer drill and ream the other hole from STGR 34 LH to the angle, Item 62, refer to Fig. A-GBPAJ Sheet 02, View C and Fig. A-GBPAJ Sheet 04, Section B-B.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAJ Sheet 06.

18 On the Frame 63 flange, at STGR 34 LH, remove:

1	Angle	E5347001123400	Item 62

19 Clean and deburr the new fastener holes in STGR 34 LH and the angle, Item 62, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

20 On the Frame 63 flange, at STGR 34 LH, wet install:

Refer to Fig. A-GBPAJ Sheet 02, View C and Fig. A-GBPAJ Sheet 04, Section B-B.

1	Angle	E5347001123400	Item 62

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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and

4	Bolt	EN6115K3-5	Item 365
2	Rivet	EN6081D5-06	Item 656
4	Nut	ASNA2528-3	Item 808

21 On the top flange of Frame 63, at STGR 35 LH, install:

Refer to Fig. A-GBPAJ Sheet 02, View D.

1	Bolt	EN6114K3-3	Item 463
1	Nut	ASNA2528-3	Item 808

22 On the Frame 63 flange, at STGR 35 LH, refer to Fig. A-GBPAJ Sheet 04, Section C-C, countersink the one fastener hole.

23 On the Frame 63 flange, at STGR 35 LH, close the rivet hole in STGR 35 LH with:

Refer to Fig. A-GBPAJ Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

24 On the Frame 63 flange, at STGR 35 LH, put in position:

Refer to Fig. A-GBPAJ Sheet 02, View C and Fig. A-GBPAJ Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

25 Transfer drill and ream one new hole from the pilot hole of the angle, Item 64, to the STGR 35 LH, then transfer drill and ream the other hole from STGR 35 LH and the five holes from the Frame to the angle, Item 64, refer to Fig. A-GBPAJ Sheet 02, View C and Fig. A-GBPAJ Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAJ Sheet 06.

26 On the Frame 63 flange, at STGR 35 LH, remove:

1	Angle	E5347001123600	Item 64

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27 Clean and deburr the new fastener holes in the Frame 63, STGR 35 LH and angle, Item 64, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

28 On the Frame 63 flange, at STGR 35 LH, wet install:

Refer to Fig. A-GBPAJ Sheet 02, View C and Fig. A-GBPAJ Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

29 On the Frame 63 flange, at STGR 36 LH, refer to Fig. A-GBPAJ Sheet 04, Section C-C, countersink the one fastener hole.

30 On the Frame 63 flange, at STGR 36 LH, close the rivet hole in STGR 36 LH with:

Refer to Fig. A-GBPAJ Sheet 04, Section C-C.

1	Rivet	EN6069D5-05	Item 555

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

31 On the Frame 63 flange, at STGR 36 LH, put in position:

Refer to Fig. A-GBPAJ Sheet 02, View C and Fig. A-GBPAJ Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

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32 Transfer drill and ream one new hole from the pilot hole of the angle, Item 64, to the STGR 36 LH, then transfer drill and ream the other hole from STGR 36 LH and the five holes from the Frame to the angle, Item 64, refer to Fig. A-GBPAJ Sheet 02, View C and Fig. A-GBPAJ Sheet 04, Section C-C.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAJ Sheet 06.

33 On the Frame 63 flange, at STGR 36 LH, remove:

1	Angle	E5347001123600	Item 64	

34 Clean and deburr the new fastener holes in the Frame 63, STGR 36 LH and angle, Item 64, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

35 On the Frame 63 flange, at STGR 36 LH, wet install:

Refer to Fig. A-GBPAJ Sheet 02, View C and Fig. A-GBPAJ Sheet 04, Section C-C.

1	Angle	E5347001123600	Item 64

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
3	Rivet	EN6081D5-07	Item 657
2	Rivet	EN6081D6-07	Item 667

36 On the Frame 63 flange, at STGR 37 LH, wet install:

Refer to Fig. A-GBPAJ Sheet 02, View C and Fig. A-GBPAJ Sheet 05, Section D-D.

1	Support	D5347032202000	Item (114)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
4	Bolt	EN6115K3-5	Item 365	
4	Rivet	EN6081D6-09	Item 669	
4	Collar	NSA5075-6	Item 806	
4	Nut	ASNA2528-3	Item 808	
4	Pin	DAN5-6-3	Item 963	

37 On the Frame 63 flange, at STGR 38 LH, wet install:

Refer to Fig. A-GBPAJ Sheet 02, View C.

1	Angle	D5347046821800	Item (115)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6081D6-08	Item 668	
1	Pin	DAN5-6-5X	Item 765	
1	Collar	DAN11-6X	Item 807	

38 On the Frame 63 flange, at STGR 39 LH, refer to Fig. A-GBPAJ Sheet 05, Section E-E, countersink the one fastener hole.

39 On the Frame 63 flange, at STGR 39 LH, close the rivet hole in STGR 39 LH with:

Refer to Fig. A-GBPAJ Sheet 05, Section E-E.

1	Rivet	EN6069D5-05	Item 555	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

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40 On the Frame 63 flange, at STGR 39 LH, put in position:

Refer to Fig. A-GBPAJ Sheet 02, View C and Fig. A-GBPAJ Sheet 05, Section E-E.

1	Angle	E5347001125200	Item 78

41 Transfer drill and ream one new hole from the pilot hole of the angle, Item 78, to the STGR 39 LH, then transfer drill and ream the other hole from STGR 39 LH and the three holes from the Frame to the angle, Item 78, refer to Fig. A-GBPAJ Sheet 02, View C and Fig. A-GBPAJ Sheet 05, Section E-E.

NOTE: For the hole diameters, refer to the table on Fig. A-GBPAJ Sheet 06.

42 On the Frame 63 flange, at STGR 39 LH, remove:

1	Angle	E5347001125200	Item 78

43 Clean and deburr the new fastener holes in the Frame 63, STGR 39 LH and angle, Item 78, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

44 On the Frame 63 flange, at STGR 39 LH, wet install:

Refer to Fig. A-GBPAJ Sheet 02, View C and Fig. A-GBPAJ Sheet 05, Section E-E.

1	Angle	E5347001125200	Item 78

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6081D5-06	Item 656
2	Rivet	EN6081D6-07	Item 667
1	Pin	DAN5-6-5X	Item 765
1	Collar	DAN11-6X	Item 807

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(e) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

for internal structure, use:

Top Coat Polyurethane	04JME4	As required

for external structure, use:

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(17) Subtask 531364-831-217-015 - Install the Shear Plates at STGR 38 LH between Frame 50 and Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 Stringer 38 LH
To	160	Work location	from Frame 60 to Frame 63 Stringer 38 LH

Manpower Resources	
Manhours	6.50
Minimum number of person	2
Subtask elapsed time	6.50
Skills	AIRFRAME

Material necessary to do the job

Kit 531364D09R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
544	EN6069D4-04	14	RIVET	
655	EN6081D5-05	39	RIVET	
656	EN6081D5-06	133	RIVET	
657	EN6081D5-07	40	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	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12 53-41-14
Fig. A-GBQAJ Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Install the shear plates.

Refer to Fig. A-GBQAJ Sheet 01 thru Fig. A-GBQAJ Sheet 06.

1 Between Frame 49 and Frame 50, on STGR 38 LH and on the bracket at Frame 49 and bracket, Item 66, put in position:

Refer to Fig. A-GBQAJ Sheet 02, View D.

1	Plate-Shear	D5347456300000	Item (139)	Retained at removal

2 Transfer drill and ream the three holes from the shear plate, Item (139), to the bracket, Item 66, refer to Fig. A-GBQAJ Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAJ Sheet 06.

3 Between Frame 49 and Frame 50, on STGR 38 LH, remove:

1	Plate-Shear	D5347456300000	Item (139)	Retain

4 Between Frame 49 and Frame 50, on STGR 38 LH, clean and deburr the new fastener holes in the bracket, Item 66, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

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Non Aqueous Cleaner - General	08BAA9	As required		

5 Between Frame 49 and Frame 50, on STGR 38 LH and on the bracket at Frame 49 and bracket, Item 66, wet install:

Refer to Fig. A-GBQAJ Sheet 02, View D.

1	Plate-Shear	D5347456300000	Item (139)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

and

6	Rivet	EN6081D5-06	Item 656	
20	Rivet	EN6081D5-07	Item 657	

6 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item (140), put in position:

Refer to Fig. A-GBQAJ Sheet 02, View D.

1	Plate-Shear	D5347471500200	Item (117)	Retained at removal

7 Transfer drill and ream the three holes from the shear plate, Item (117), to the bracket, Item 65, refer to Fig. A-GBQAJ Sheet 02, View D.

NOTE: For the hole diameters, refer to the tables on Fig. A-GBQAJ Sheet 06.

8 Between Frame 50 and Frame 51, on STGR 38 LH, remove:

1	Plate-Shear	D5347471500200	Item (117)	Retain

9 Between Frame 50 and Frame 51, on STGR 38 LH, clean and deburr the new fastener holes in the bracket, Item 65, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner - General	08BAA9	As required

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10 Between Frame 50 and Frame 51, on STGR 38 LH and on the brackets, Item 65 and Item (140), wet install:

Refer to Fig. A-GBQAJ Sheet 02, View D.

1	Plate-Shear	D5347471500200	Item (117)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6069D4-04	Item 544	
6	Rivet	EN6081D5-06	Item 656	
20	Rivet	EN6081D5-07	Item 657	

11 Between Frame 52 and Frame 53, on STGR 38 LH and on the brackets, Item (116) and Item (120), wet install:

Refer to Fig. A-GBQAJ Sheet 03, View F.

1	Plate Assy-Shear	D5347049100200	Item (119)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6069D4-04	Item 544	
6	Rivet	EN6081D5-05	Item 655	
21	Rivet	EN6081D5-06	Item 656	

12 Between Frame 54 and Frame 55, on STGR 38 LH and on the brackets, Item (121) and Item (120), wet install:

Refer to Fig. A-GBQAJ Sheet 04, View H.

1	Plate Assy-Shear	D5347048800400	Item (122)	Retained at removal
	with			

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	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6069D4-04	Item 544	
6	Rivet	EN6081D5-05	Item 655	
20	Rivet	EN6081D5-06	Item 656	

13 Between Frame 56 and Frame 57, on STGR 38 LH and on the brackets, Item (121) and Item (118), wet install:

Refer to Fig. A-GBQAJ Sheet 04, View K.

1	Plate-Shear	D5347048900400	Item (124)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			
2	Rivet	EN6069D4-04	Item 544	
6	Rivet	EN6081D5-05	Item 655	
20	Rivet	EN6081D5-06	Item 656	

14 Between Frame 58 and Frame 59, on STGR 38 LH and on the brackets, Item (125) and Item (127), wet install:

Refer to Fig. A-GBQAJ Sheet 05, View M.

1	Plate-Shear	D5347049200400	Item (126)	Retained at removal
	or			
1	Plate-Shear	D5347049200200	Item (126)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	and			

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2	Rivet	EN6069D4-04	Item 544	
6	Rivet	EN6081D5-05	Item 655	
20	Rivet	EN6081D5-06	Item 656	

15 Between Frame 60 and Frame 61, on STGR 38 LH and on the brackets, Item (128) and Item (130), wet install:

Refer to Fig. A-GBQAJ Sheet 05, View P.

1	Plate-Shear	D5347049300200	Item (129)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-04	Item 544	
8	Rivet	EN6081D5-05	Item 655	
20	Rivet	EN6081D5-06	Item 656	

16 Between Frame 62 and Frame 63, on STGR 38 LH and on the brackets, Item (131) and Item (115), wet install:

Refer to Fig. A-GBQAJ Sheet 06, View R.

1	Plate-Shear	D5347049400000	Item (123)	Retained at removal

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

and

2	Rivet	EN6069D4-04	Item 544	
7	Rivet	EN6081D5-05	Item 655	
20	Rivet	EN6081D5-06	Item 656	

(b) Install the corner profiles.

In accordance with SRM 53-41-14.

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1 Between Frame 48 thru Frame 63, at STGR 38 LH, install the corner profiles, if removed in accordance with SRM 53-41-14 C2 Identification - Floor Structure - Cargo Compartment.

(c) Install new surface protection on fasteners and rivets.

1 Protect the surfaces on all replaced fasteners and rivets with:

In accordance with SRM 51-75-12.

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane	04JME4	As required

(18) Subtask 531364-831-218-002 - Install new Surface Protection on Frame 50 thru Frame 63

Work Zones and Access Panels			
	Zone	Access/Work location	
From	150	Work location	from Frame 50 to Frame 59 from Stringer 31 to Stringer 39
To	160	Work location	from Frame 60 to Frame 63 from Stringer 31 to Stringer 39

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	NON SPECIFIC

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	04JME4	As required	
	Coating - Flexible Structure	04QAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound	12ADB1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

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References	
Structural Repair Manual (SRM)	51-23-12

(a) Clean the working area with:

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

(b) Apply sealant beads around the edges of all new and reinstalled structure parts with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(c) Apply to all sealant beads:

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(d) Apply to all sealant beads:

Top Coat Polyurethane	04JME4	As required
and		
Coating - Flexible Structure	04QAB2	As required

(e) Install new water repellent protection on Frame 50 thru Frame 63.

1 Protect the Frame 50 thru Frame 63, STGR 31 LH thru STGR 39 LH and the re-installed shear plates with:

In accordance with SRM 51-23-12.

Corrosion Preventive Compound	12ADB1	As required

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**CONF ALL

D. TEST

**CONF 001

(1) Subtask 531364-700-201-001 - Testing

Manpower Resources	
Skills	NON SPECIFIC

This Service Bulletin requires the accomplishment of Tests which are given in:

- SUBTASK 531364-942-201 003 Close-up .

The man-hours for the tests are included in the referenced Service Bulletin subtasks.

**CONF 002

(1) Subtask 531364-700-201-001 - Testing

Manpower Resources	
Skills	NON SPECIFIC

This Service Bulletin requires the accomplishment of Tests which are given in:

- SUBTASK 531364-942-201 002 Close-up .

The man-hours for the tests are included in the referenced Service Bulletin subtasks.

**CONF 003

(1) Subtask 531364-700-201-001 - Testing

Manpower Resources	
Skills	NON SPECIFIC

This Service Bulletin requires the accomplishment of Tests which are given in:

- SUBTASK 531364-942-201 003 Close-up .

The man-hours for the tests are included in the referenced Service Bulletin subtasks.

**CONF 004

(1) Subtask 531364-700-201-001 - Testing

Manpower Resources	
Skills	NON SPECIFIC

This Service Bulletin requires the accomplishment of Tests which are given in:

- SUBTASK 531364-942-201 002 Close-up .

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The man-hours for the tests are included in the referenced Service Bulletin subtasks.

**CONF 005

(1) **Subtask 531364-700-201-001 - Testing**

Manpower Resources	
Skills	NON SPECIFIC

This Service Bulletin requires the accomplishment of Tests which are given in:

- SUBTASK 531364-942-201 002 Close-up .

The man-hours for the tests are included in the referenced Service Bulletin subtasks.

**CONF 006

(1) **Subtask 531364-700-201-001 - Testing**

Manpower Resources	
Skills	NON SPECIFIC

This Service Bulletin requires the accomplishment of Tests which are given in:

- SUBTASK 531364-942-201 003 Close-up .

The man-hours for the tests are included in the referenced Service Bulletin subtasks.

**CONF 007

(1) **Subtask 531364-700-201-001 - Testing**

Manpower Resources	
Skills	NON SPECIFIC

This Service Bulletin requires the accomplishment of Tests which are given in:

- SUBTASK 531364-942-201 003 Close-up .

The man-hours for the tests are included in the referenced Service Bulletin subtasks.

**CONF 008

(1) **Subtask 531364-700-201-001 - Testing**

Manpower Resources	
Skills	NON SPECIFIC

This Service Bulletin requires the accomplishment of Tests which are given in:

- SUBTASK 531364-942-201 003 Close-up .

The man-hours for the tests are included in the referenced Service Bulletin subtasks.

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**CONF 009

(1) Subtask 531364-700-201-001 - Testing

Manpower Resources	
Skills	NON SPECIFIC

This Service Bulletin requires the accomplishment of Tests which are given in:

- SUBTASK 531364-942-201 003 Close-up .

The man-hours for the tests are included in the referenced Service Bulletin subtasks.

**CONF ALL

E. CLOSE-UP

**CONF 001

(1) Subtask 531364-942-201-003 - Close-up

Work Zones and Access Panels		
	Zone	Access/Work location
	150	
	160	

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-410-001 Task 25-52-22-400-001 Task 25-52-44-400-003 Task 25-55-12-400-003 Task 25-55-17-400-001 Task 25-80-00-400-001 Task 28-11-27-400-001 Task 52-30-00-860-002 Task 53-35-13-400-001 Task 53-42-14-400-001 Task 53-42-17-400-001

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

(b) Install the belly fairing panel 197GB, refer to AMM Task 53-35-13-400-001.

(c) If rear underfloor venting is fitted:

1 Install the Sidewall Panels 151JW and 151HW, refer to AMM Task 25-55-12-400-003.

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2 Install the air-conditioning ducts between Frame 57 and Frame 58, refer to AMM Task 21-20-00-410-001.

(d) If the semi-automatic loading system is fitted:

1 Install the YZ fixed latches L/H side, refer to AMM Task 25-52-44-400-003.

NOTE: After cold working and extension of one of the fastener holes used for the installation of the YZ-latches of the cargo loading system at frame 50 to frame 58, the original bolt with a diameter of 4.800mm (0.1889in.) can be used.

(e) Install the insulation blankets in the working area as necessary, refer to AMM Task 25-80-00-400-001.

(f) In the AFT and BULK cargo compartments, install the floor panels between frame 49 and frame 64, refer to AMM Task 53-42-14-400-001 and AMM Task 53-42-17-400-001.

(g) If necessary, install the ball mats between Frame 52 and Frame 56, refer to AMM 25-52-22-400-001.

(h) Install the door nets from the AFT and/or BULK cargo compartment(s), if removed, refer to AMM Task 25-55-17-400-001.

(i) Install the Additional Center Tank No. 1 (ACT1) and Additional Center Tank No. 2 (ACT2), refer to AMM Task 28-11-27-400-001.

(j) Do the Test procedures as specified in the Installation of the Additional Center Tank (ACT), refer to AMM Task 28-11-27-400-001.

(k) Close the AFT cargo-compartment door 826, refer to AMM Task 52-30-00-860-002.

(l) Remove the access platform from the position at the opening of the AFT cargo-compartment door 826.

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

****CONF 002**

(1) Subtask 531364-942-201-002 - Close-up

Work Zones and Access Panels		
	Zone	Access/Work location
	150	
	160	

Manpower Resources	
Skills	NON SPECIFIC

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References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-410-001 Task 25-52-22-400-001 Task 25-52-44-400-003 Task 25-55-12-400-003 Task 25-55-17-400-001 Task 25-80-00-400-001 Task 28-11-27-400-001 Task 52-30-00-860-002 Task 53-35-13-400-001 Task 53-42-14-400-001 Task 53-42-17-400-001

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

(b) Install the belly fairing panel 197GB, refer to AMM Task 53-35-13-400-001.

(c) If rear underfloor venting is fitted:

1 Install the Sidewall Panels 151JW and 151HW, refer to AMM Task 25-55-12-400-003.

2 Install the air-conditioning ducts between Frame 57 and Frame 58, refer to AMM Task 21-20-00-410-001.

(d) If the semi-automatic loading system is fitted:

1 Install the YZ fixed latches L/H side, refer to AMM Task 25-52-44-400-003.

NOTE: After cold working and extension of one of the fastener holes used for the installation of the YZ-latches of the cargo loading system at frame 50 to frame 58, the original bolt with a diameter of 4.800mm (0.1889in.) can be used.

(e) Install the insulation blankets in the working area as necessary, refer to AMM Task 25-80-00-400-001.

(f) In the AFT and BULK cargo compartments, install the floor panels between frame 49 and frame 64, refer to AMM Task 53-42-14-400-001 and AMM Task 53-42-17-400-001.

(g) If necessary, install the ball mats between Frame 52 and Frame 56, refer to AMM 25-52-22-400-001.

(h) Install the door nets from the AFT and/or BULK cargo compartment(s), if removed, refer to AMM Task 25-55-17-400-001.

(i) Install the Additional Center Tank (ACT), refer to AMM Task 28-11-27-400-001.

(j) Do the Test procedures as specified in the installation of the Additional Center Tank (ACT), refer to AMM Task 28-11-27-400-001.

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(k) Close the AFT cargo-compartment door 826, refer to AMM Task 52-30-00-860-002.

(l) Remove the access platform from the position at the opening of the AFT cargo-compartment door 826.

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

**CONF 003

(1) Subtask 531364-942-201-003 - Close-up

Work Zones and Access Panels		
	Zone	Access/Work location
	150	
	160	

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-410-001 Task 25-52-22-400-001 Task 25-52-44-400-003 Task 25-55-12-400-003 Task 25-55-17-400-001 Task 25-80-00-400-001 Task 28-11-27-400-001 Task 52-30-00-860-002 Task 53-35-13-400-001 Task 53-42-14-400-001 Task 53-42-17-400-001

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

(b) Install the belly fairing panel 197GB, refer to AMM Task 53-35-13-400-001.

(c) If rear underfloor venting is fitted:

1 Install the Sidewall Panels 151JW and 151HW, refer to AMM Task 25-55-12-400-003.

2 Install the air-conditioning ducts between Frame 57 and Frame 58, refer to AMM Task 21-20-00-410-001.

(d) If the semi-automatic loading system is fitted:

1 Install the YZ fixed latches L/H side, refer to AMM Task 25-52-44-400-003.

NOTE: After cold working and extension of one of the fastener holes used for the installation of the YZ-latches of the cargo loading system at frame 50 to frame 58, the original bolt with a diameter of 4.800mm (0.1889in.) can be used.

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(e) Install the insulation blankets in the working area as necessary, refer to AMM Task 25-80-00-400-001.

(f) In the AFT and BULK cargo compartments, install the floor panels between frame 49 and frame 64, refer to AMM Task 53-42-14-400-001 and AMM Task 53-42-17-400-001.

(g) If necessary, install the ball mats between Frame 52 and Frame 56, refer to AMM 25-52-22-400-001.

(h) Install the door nets from the AFT and/or BULK cargo compartment(s), if removed, refer to AMM Task 25-55-17-400-001.

(i) Install the Additional Center Tank No. 1 (ACT1) and Additional Center Tank No. 2 (ACT2), refer to AMM Task 28-11-27-400-001.

(j) Do the Test procedures as specified in the Installation of the Additional Center Tank (ACT), refer to AMM Task 28-11-27-400-001.

(k) Close the AFT cargo-compartment door 826, refer to AMM Task 52-30-00-860-002.

(l) Remove the access platform from the position at the opening of the AFT cargo-compartment door 826.

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

**CONF 004

(1) Subtask 531364-942-201-002 - Close-up

Work Zones and Access Panels		
	Zone	Access/Work location
	150	
	160	

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-410-001 Task 25-52-22-400-001 Task 25-52-44-400-003 Task 25-55-12-400-003 Task 25-55-17-400-001 Task 25-80-00-400-001 Task 28-11-27-400-001 Task 52-30-00-860-002 Task 53-35-13-400-001 Task 53-42-14-400-001 Task 53-42-17-400-001

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

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(b) Install the belly fairing panel 197GB, refer to AMM Task 53-35-13-400-001.

(c) If rear underfloor venting is fitted:

1 Install the Sidewall Panels 151JW and 151HW, refer to AMM Task 25-55-12-400-003.

2 Install the air-conditioning ducts between Frame 57 and Frame 58, refer to AMM Task 21-20-00-410-001.

(d) If the semi-automatic loading system is fitted:

1 Install the YZ fixed latches L/H side, refer to AMM Task 25-52-44-400-003.

NOTE: After cold working and extension of one of the fastener holes used for the installation of the YZ-latches of the cargo loading system at frame 50 to frame 58, the original bolt with a diameter of 4.800mm (0.1889in.) can be used.

(e) Install the insulation blankets in the working area as necessary, refer to AMM Task 25-80-00-400-001.

(f) In the AFT and BULK cargo compartments, install the floor panels between frame 49 and frame 64, refer to AMM Task 53-42-14-400-001 and AMM Task 53-42-17-400-001.

(g) If necessary, install the ball mats between Frame 52 and Frame 56, refer to AMM 25-52-22-400-001.

(h) Install the door nets from the AFT and/or BULK cargo compartment(s), if removed, refer to AMM Task 25-55-17-400-001.

(i) Install the Additional Center Tank (ACT), refer to AMM Task 28-11-27-400-001.

(j) Do the Test procedures as specified in the installation of the Additional Center Tank (ACT), refer to AMM Task 28-11-27-400-001.

(k) Close the AFT cargo-compartment door 826, refer to AMM Task 52-30-00-860-002.

(l) Remove the access platform from the position at the opening of the AFT cargo-compartment door 826.

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

**CONF 005

(1) Subtask 531364-942-201-002 - Close-up

Work Zones and Access Panels		
	Zone	Access/Work location
	150	
	160	

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Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-410-001 Task 25-52-22-400-001 Task 25-52-44-400-003 Task 25-55-12-400-003 Task 25-55-17-400-001 Task 25-80-00-400-001 Task 28-11-27-400-001 Task 52-30-00-860-002 Task 53-35-13-400-001 Task 53-42-14-400-001 Task 53-42-17-400-001

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

(b) Install the belly fairing panel 197GB, refer to AMM Task 53-35-13-400-001.

(c) If rear underfloor venting is fitted:

1 Install the Sidewall Panels 151JW and 151HW, refer to AMM Task 25-55-12-400-003.

2 Install the air-conditioning ducts between Frame 57 and Frame 58, refer to AMM Task 21-20-00-410-001.

(d) If the semi-automatic loading system is fitted:

1 Install the YZ fixed latches L/H side, refer to AMM Task 25-52-44-400-003.

NOTE: After cold working and extension of one of the fastener holes used for the installation of the YZ-latches of the cargo loading system at frame 50 to frame 58, the original bolt with a diameter of 4.800mm (0.1889in.) can be used.

(e) Install the insulation blankets in the working area as necessary, refer to AMM Task 25-80-00-400-001.

(f) In the AFT and BULK cargo compartments, install the floor panels between frame 49 and frame 64, refer to AMM Task 53-42-14-400-001 and AMM Task 53-42-17-400-001.

(g) If necessary, install the ball mats between Frame 52 and Frame 56, refer to AMM 25-52-22-400-001.

(h) Install the door nets from the AFT and/or BULK cargo compartment(s), if removed, refer to AMM Task 25-55-17-400-001.

(i) Install the Additional Center Tank (ACT), refer to AMM Task 28-11-27-400-001.

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(j) Do the Test procedures as specified in the installation of the Additional Center Tank (ACT), refer to AMM Task 28-11-27-400-001.

(k) Close the AFT cargo-compartment door 826, refer to AMM Task 52-30-00-860-002.

(l) Remove the access platform from the position at the opening of the AFT cargo-compartment door 826.

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

**CONF 006

(1) Subtask 531364-942-201-003 - Close-up

Work Zones and Access Panels		
	Zone	Access/Work location
	150	
	160	

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-410-001 Task 25-52-22-400-001 Task 25-52-44-400-003 Task 25-55-12-400-003 Task 25-55-17-400-001 Task 25-80-00-400-001 Task 28-11-27-400-001 Task 52-30-00-860-002 Task 53-35-13-400-001 Task 53-42-14-400-001 Task 53-42-17-400-001

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

(b) Install the belly fairing panel 197GB, refer to AMM Task 53-35-13-400-001.

(c) If rear underfloor venting is fitted:

1 Install the Sidewall Panels 151JW and 151HW, refer to AMM Task 25-55-12-400-003.

2 Install the air-conditioning ducts between Frame 57 and Frame 58, refer to AMM Task 21-20-00-410-001.

(d) If the semi-automatic loading system is fitted:

1 Install the YZ fixed latches L/H side, refer to AMM Task 25-52-44-400-003.

NOTE: After cold working and extension of one of the fastener holes

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used for the installation of the YZ-latches of the cargo loading system at frame 50 to frame 58, the original bolt with a diameter of 4.800mm (0.1889in.) can be used.

(e) Install the insulation blankets in the working area as necessary, refer to AMM Task 25-80-00-400-001.

(f) In the AFT and BULK cargo compartments, install the floor panels between frame 49 and frame 64, refer to AMM Task 53-42-14-400-001 and AMM Task 53-42-17-400-001.

(g) If necessary, install the ball mats between Frame 52 and Frame 56, refer to AMM 25-52-22-400-001.

(h) Install the door nets from the AFT and/or BULK cargo compartment(s), if removed, refer to AMM Task 25-55-17-400-001.

(i) Install the Additional Center Tank No. 1 (ACT1) and Additional Center Tank No. 2 (ACT2), refer to AMM Task 28-11-27-400-001.

(j) Do the Test procedures as specified in the Installation of the Additional Center Tank (ACT), refer to AMM Task 28-11-27-400-001.

(k) Close the AFT cargo-compartment door 826, refer to AMM Task 52-30-00-860-002.

(l) Remove the access platform from the position at the opening of the AFT cargo-compartment door 826.

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

**CONF 007

(1) Subtask 531364-942-201-003 - Close-up

Work Zones and Access Panels		
	Zone	Access/Work location
	150	
	160	

Manpower Resources	
Skills	NON SPECIFIC

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References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-410-001 Task 25-52-22-400-001 Task 25-52-44-400-003 Task 25-55-12-400-003 Task 25-55-17-400-001 Task 25-80-00-400-001 Task 28-11-27-400-001 Task 52-30-00-860-002 Task 53-35-13-400-001 Task 53-42-14-400-001 Task 53-42-17-400-001

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

(b) Install the belly fairing panel 197GB, refer to AMM Task 53-35-13-400-001.

(c) If rear underfloor venting is fitted:

1 Install the Sidewall Panels 151JW and 151HW, refer to AMM Task 25-55-12-400-003.

2 Install the air-conditioning ducts between Frame 57 and Frame 58, refer to AMM Task 21-20-00-410-001.

(d) If the semi-automatic loading system is fitted:

1 Install the YZ fixed latches L/H side, refer to AMM Task 25-52-44-400-003.

NOTE: After cold working and extension of one of the fastener holes used for the installation of the YZ-latches of the cargo loading system at frame 50 to frame 58, the original bolt with a diameter of 4.800mm (0.1889in.) can be used.

(e) Install the insulation blankets in the working area as necessary, refer to AMM Task 25-80-00-400-001.

(f) In the AFT and BULK cargo compartments, install the floor panels between frame 49 and frame 64, refer to AMM Task 53-42-14-400-001 and AMM Task 53-42-17-400-001.

(g) If necessary, install the ball mats between Frame 52 and Frame 56, refer to AMM 25-52-22-400-001.

(h) Install the door nets from the AFT and/or BULK cargo compartment(s), if removed, refer to AMM Task 25-55-17-400-001.

(i) Install the Additional Center Tank No. 1 (ACT1) and Additional Center Tank No. 2 (ACT2), refer to AMM Task 28-11-27-400-001.

(j) Do the Test procedures as specified in the Installation of the Additional Center Tank (ACT), refer to AMM Task 28-11-27-400-001.

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(k) Close the AFT cargo-compartment door 826, refer to AMM Task 52-30-00-860-002.

(l) Remove the access platform from the position at the opening of the AFT cargo-compartment door 826.

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

**CONF 008

(1) Subtask 531364-942-201-003 - Close-up

Work Zones and Access Panels		
	Zone	Access/Work location
	150	
	160	

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-410-001 Task 25-52-22-400-001 Task 25-52-44-400-003 Task 25-55-12-400-003 Task 25-55-17-400-001 Task 25-80-00-400-001 Task 28-11-27-400-001 Task 52-30-00-860-002 Task 53-35-13-400-001 Task 53-42-14-400-001 Task 53-42-17-400-001

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

(b) Install the belly fairing panel 197GB, refer to AMM Task 53-35-13-400-001.

(c) If rear underfloor venting is fitted:

1 Install the Sidewall Panels 151JW and 151HW, refer to AMM Task 25-55-12-400-003.

2 Install the air-conditioning ducts between Frame 57 and Frame 58, refer to AMM Task 21-20-00-410-001.

(d) If the semi-automatic loading system is fitted:

1 Install the YZ fixed latches L/H side, refer to AMM Task 25-52-44-400-003.

NOTE: After cold working and extension of one of the fastener holes used for the installation of the YZ-latches of the cargo loading system at frame 50 to frame 58, the original bolt with a diameter of 4.800mm (0.1889in.) can be used.

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(e) Install the insulation blankets in the working area as necessary, refer to AMM Task 25-80-00-400-001.

(f) In the AFT and BULK cargo compartments, install the floor panels between frame 49 and frame 64, refer to AMM Task 53-42-14-400-001 and AMM Task 53-42-17-400-001.

(g) If necessary, install the ball mats between Frame 52 and Frame 56, refer to AMM 25-52-22-400-001.

(h) Install the door nets from the AFT and/or BULK cargo compartment(s), if removed, refer to AMM Task 25-55-17-400-001.

(i) Install the Additional Center Tank No. 1 (ACT1) and Additional Center Tank No. 2 (ACT2), refer to AMM Task 28-11-27-400-001.

(j) Do the Test procedures as specified in the Installation of the Additional Center Tank (ACT), refer to AMM Task 28-11-27-400-001.

(k) Close the AFT cargo-compartment door 826, refer to AMM Task 52-30-00-860-002.

(l) Remove the access platform from the position at the opening of the AFT cargo-compartment door 826.

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

**CONF 009

(1) Subtask 531364-942-201-003 - Close-up

Work Zones and Access Panels		
	Zone	Access/Work location
	150	
	160	

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-410-001 Task 25-52-22-400-001 Task 25-52-44-400-003 Task 25-55-12-400-003 Task 25-55-17-400-001 Task 25-80-00-400-001 Task 28-11-27-400-001 Task 52-30-00-860-002 Task 53-35-13-400-001 Task 53-42-14-400-001 Task 53-42-17-400-001

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

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(b) Install the belly fairing panel 197GB, refer to AMM Task 53-35-13-400-001.

(c) If rear underfloor venting is fitted:

1 Install the Sidewall Panels 151JW and 151HW, refer to AMM Task 25-55-12-400-003.

2 Install the air-conditioning ducts between Frame 57 and Frame 58, refer to AMM Task 21-20-00-410-001.

(d) If the semi-automatic loading system is fitted:

1 Install the YZ fixed latches L/H side, refer to AMM Task 25-52-44-400-003.

NOTE: After cold working and extension of one of the fastener holes used for the installation of the YZ-latches of the cargo loading system at frame 50 to frame 58, the original bolt with a diameter of 4.800mm (0.1889in.) can be used.

(e) Install the insulation blankets in the working area as necessary, refer to AMM Task 25-80-00-400-001.

(f) In the AFT and BULK cargo compartments, install the floor panels between frame 49 and frame 64, refer to AMM Task 53-42-14-400-001 and AMM Task 53-42-17-400-001.

(g) If necessary, install the ball mats between Frame 52 and Frame 56, refer to AMM 25-52-22-400-001.

(h) Install the door nets from the AFT and/or BULK cargo compartment(s), if removed, refer to AMM Task 25-55-17-400-001.

(i) Install the Additional Center Tank No. 1 (ACT1) and Additional Center Tank No. 2 (ACT2), refer to AMM Task 28-11-27-400-001.

(j) Do the Test procedures as specified in the Installation of the Additional Center Tank (ACT), refer to AMM Task 28-11-27-400-001.

(k) Close the AFT cargo-compartment door 826, refer to AMM Task 52-30-00-860-002.

(l) Remove the access platform from the position at the opening of the AFT cargo-compartment door 826.

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

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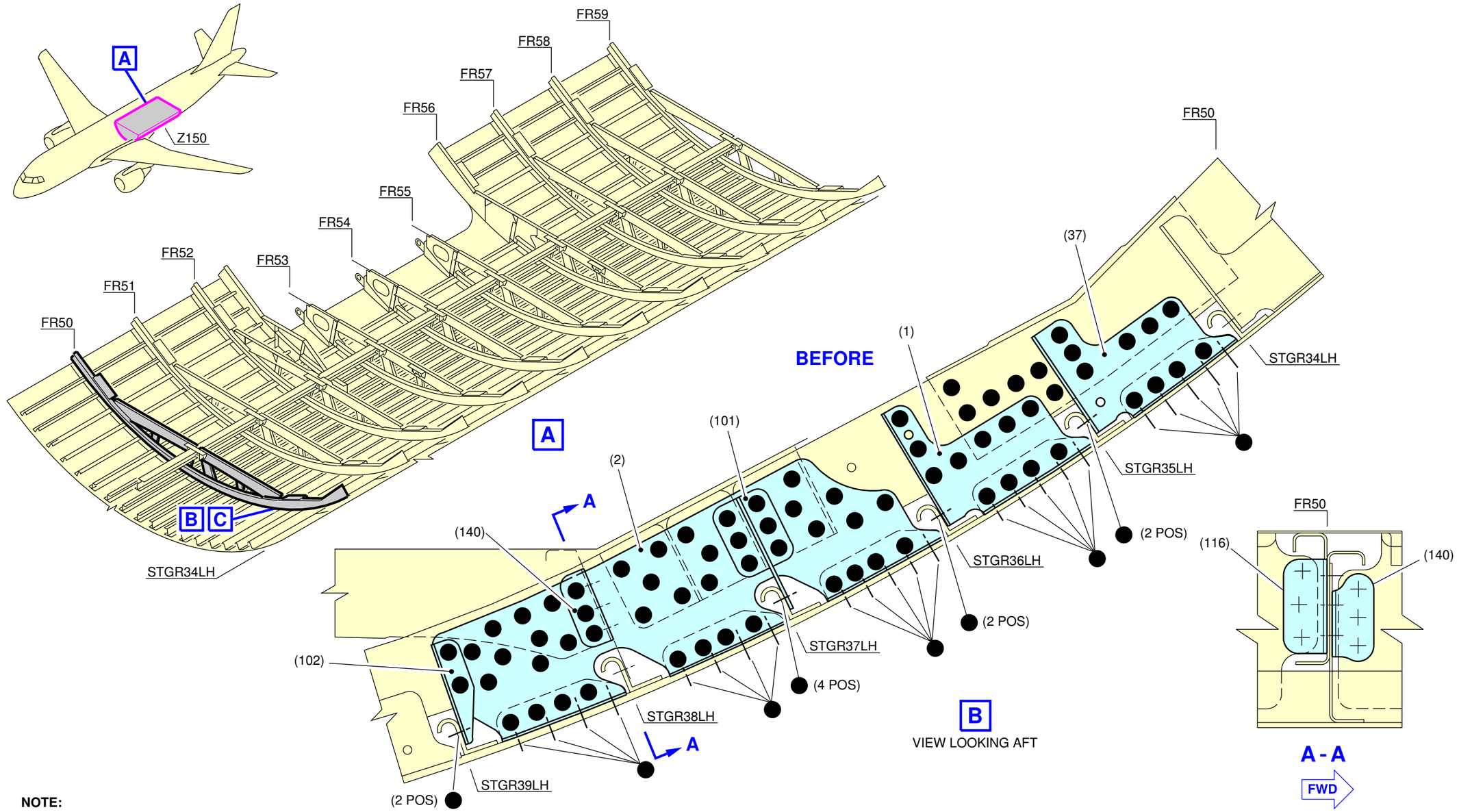
**CONF 001



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BAAA_01_00

Figure A-GBAAA - Sheet 01
Replacement of Webs and Angles at Frame 50

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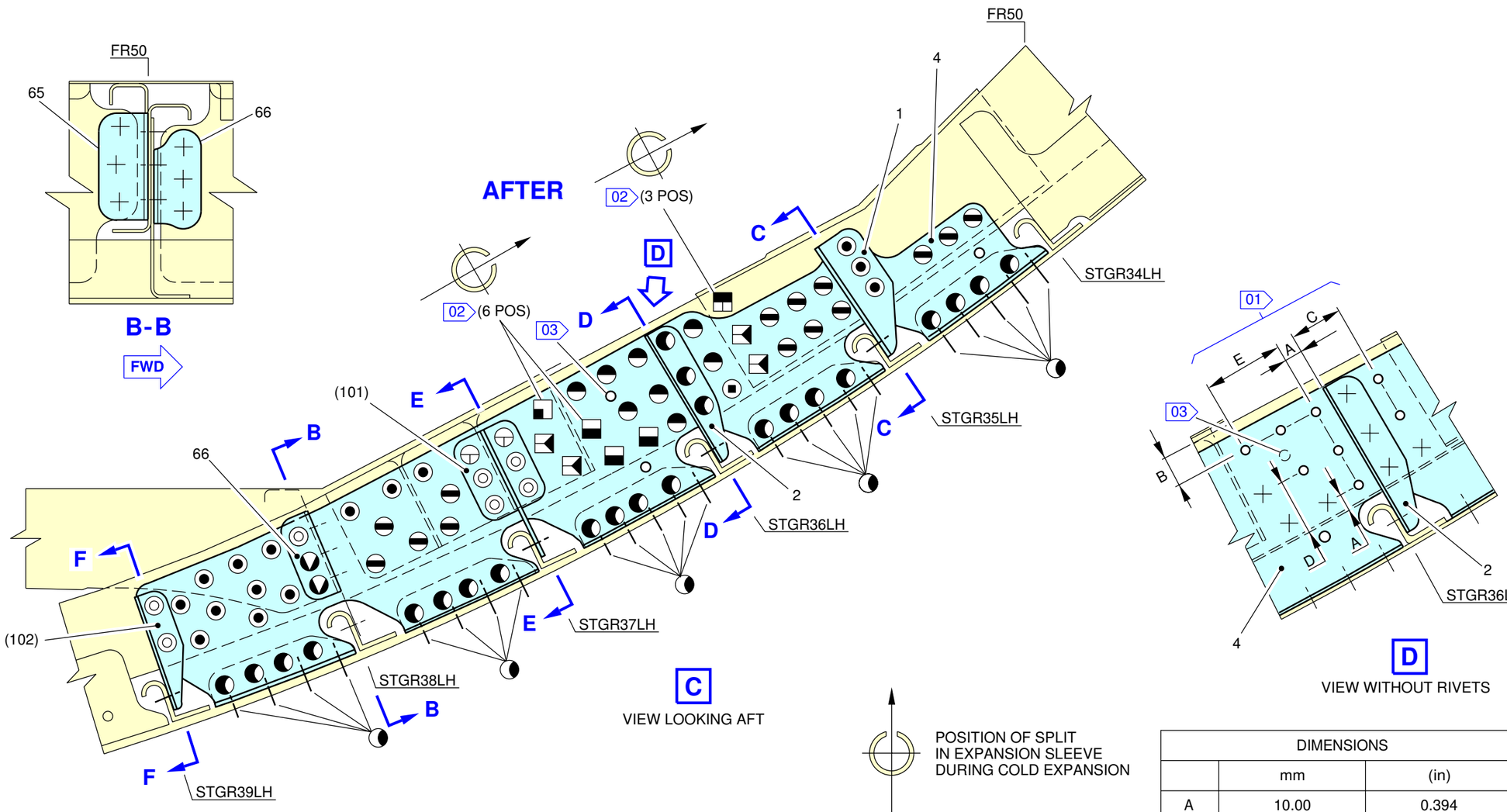
**CONF 001



DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BAAA_02_01

NOTE:

01 NEW HOLES

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4

Figure A-GBAAA - Sheet 02
Replacement of Webs and Angles at Frame 50

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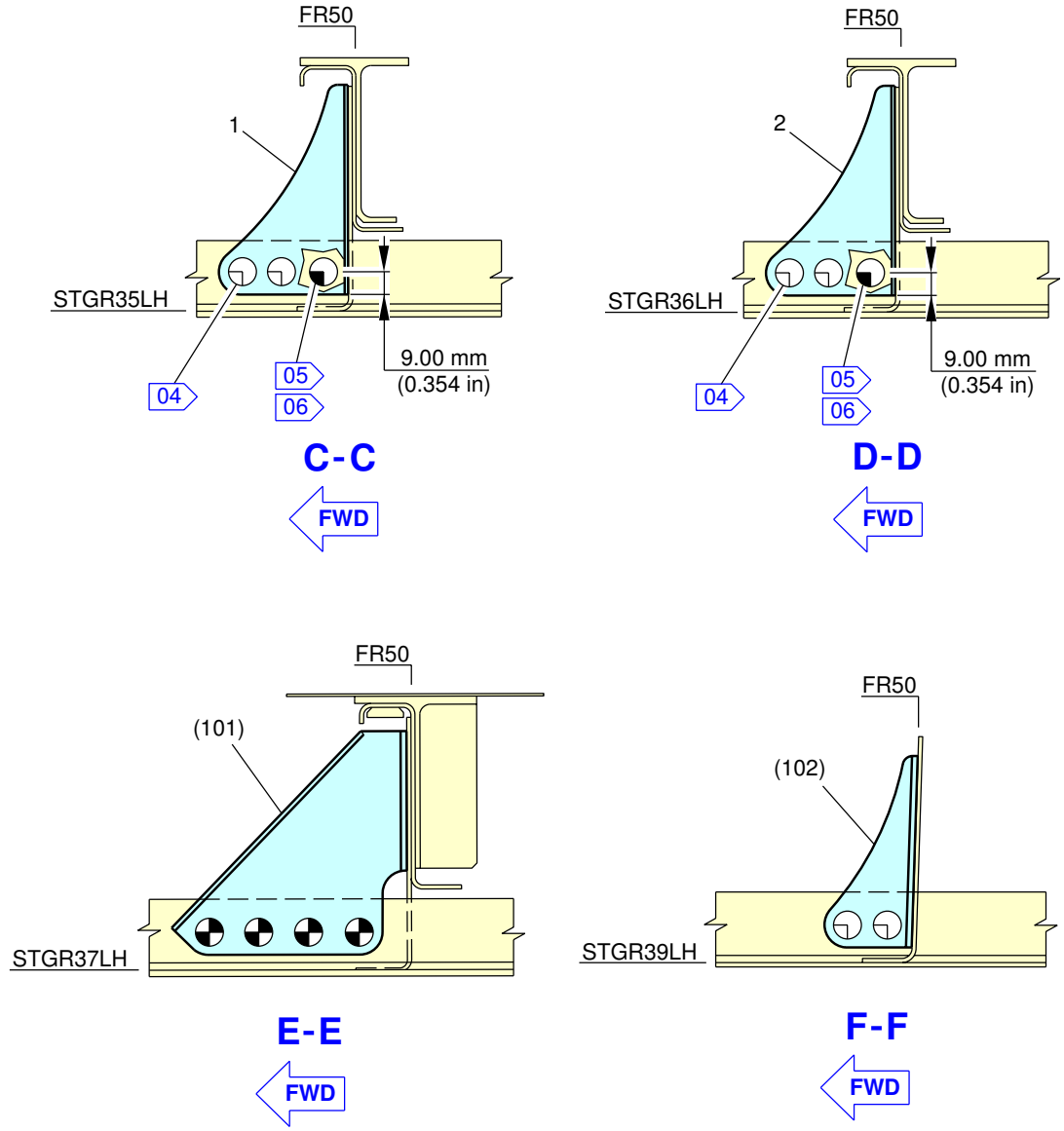
**CONF 001



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BAAA_03_02

Figure A-GBAAA - Sheet 03
Replacement of Webs and Angles at Frame 50

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**CONF 001

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	768	DAN5–6–8X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BAAA_04_02

Figure A-GBAAA - Sheet 04
Replacement of Webs and Angles at Frame 50

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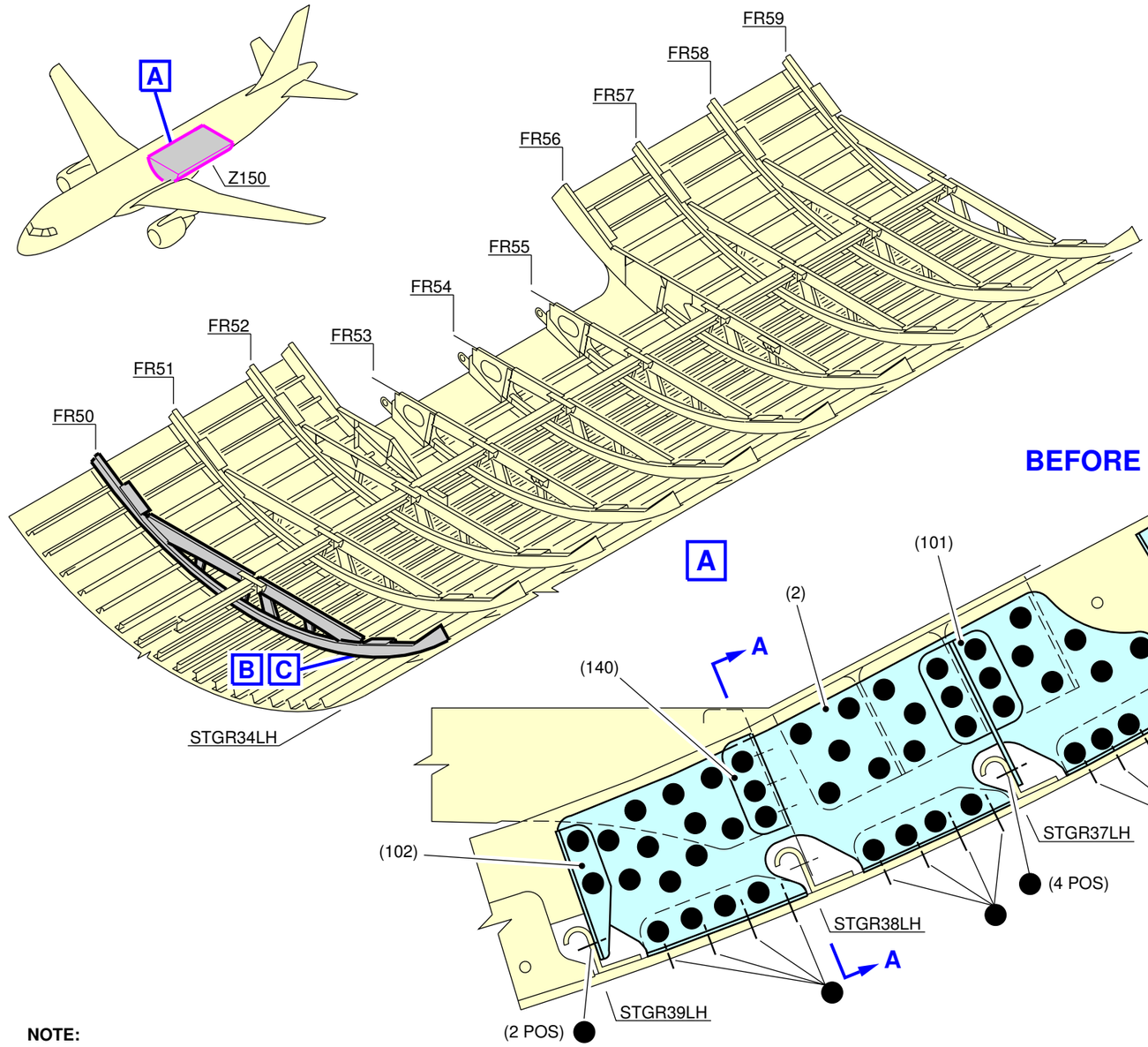
**CONF 002 thru 003



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BAAB_01_00

Figure A-GBAAB - Sheet 01
Replacement of Webs and Angles at Frame 50

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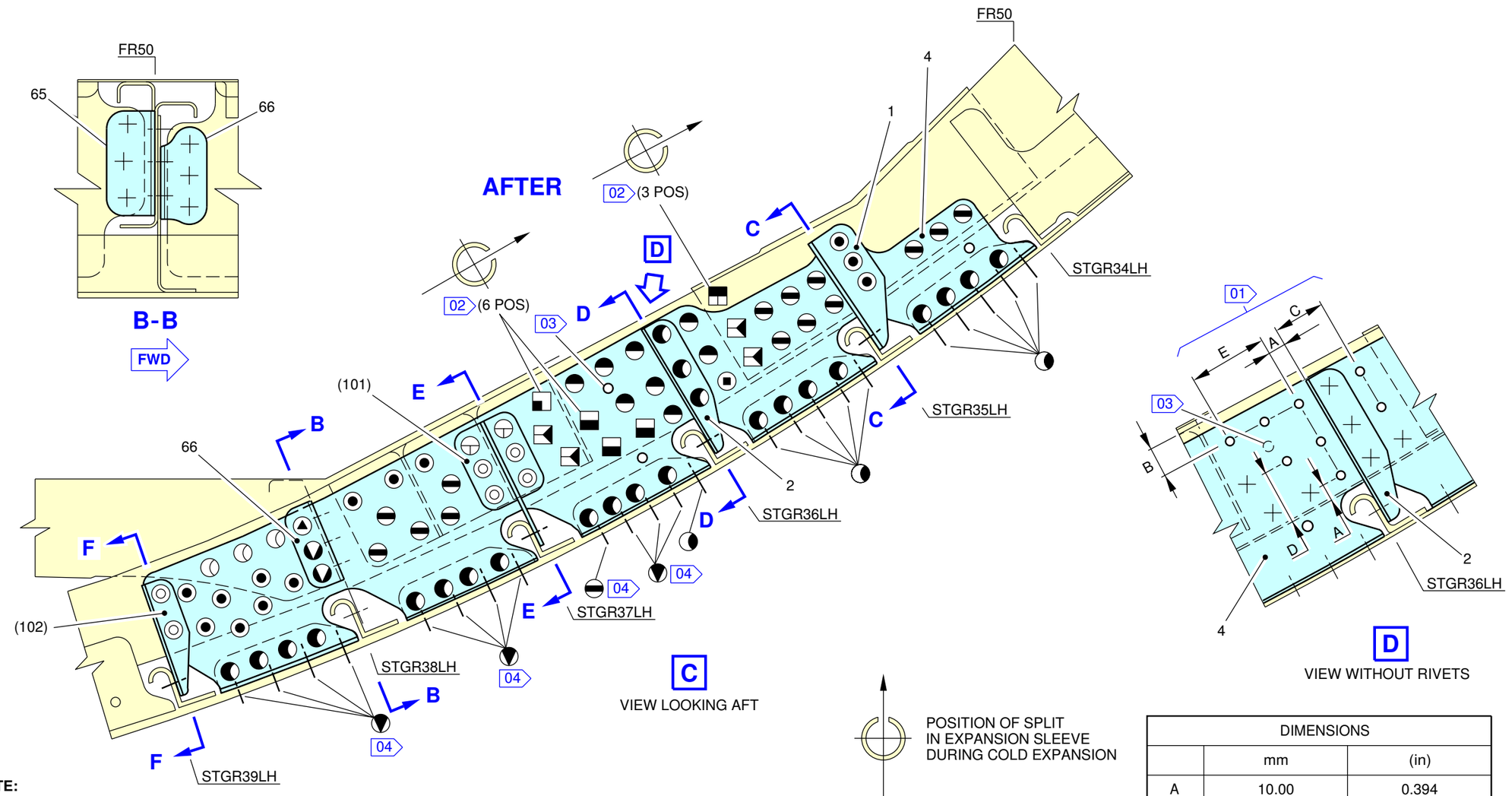
**CONF 002 thru 003

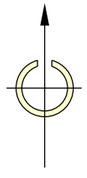


C

VIEW LOOKING AFT

D

VIEW WITHOUT RIVETS



POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

04 RIVETED/INSTALLED WITH BELLY FAIRING ANGLE.

EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4

N_SB_531364_6_BAAB_02_01

Figure A-GBAAB - Sheet 02
Replacement of Webs and Angles at Frame 50

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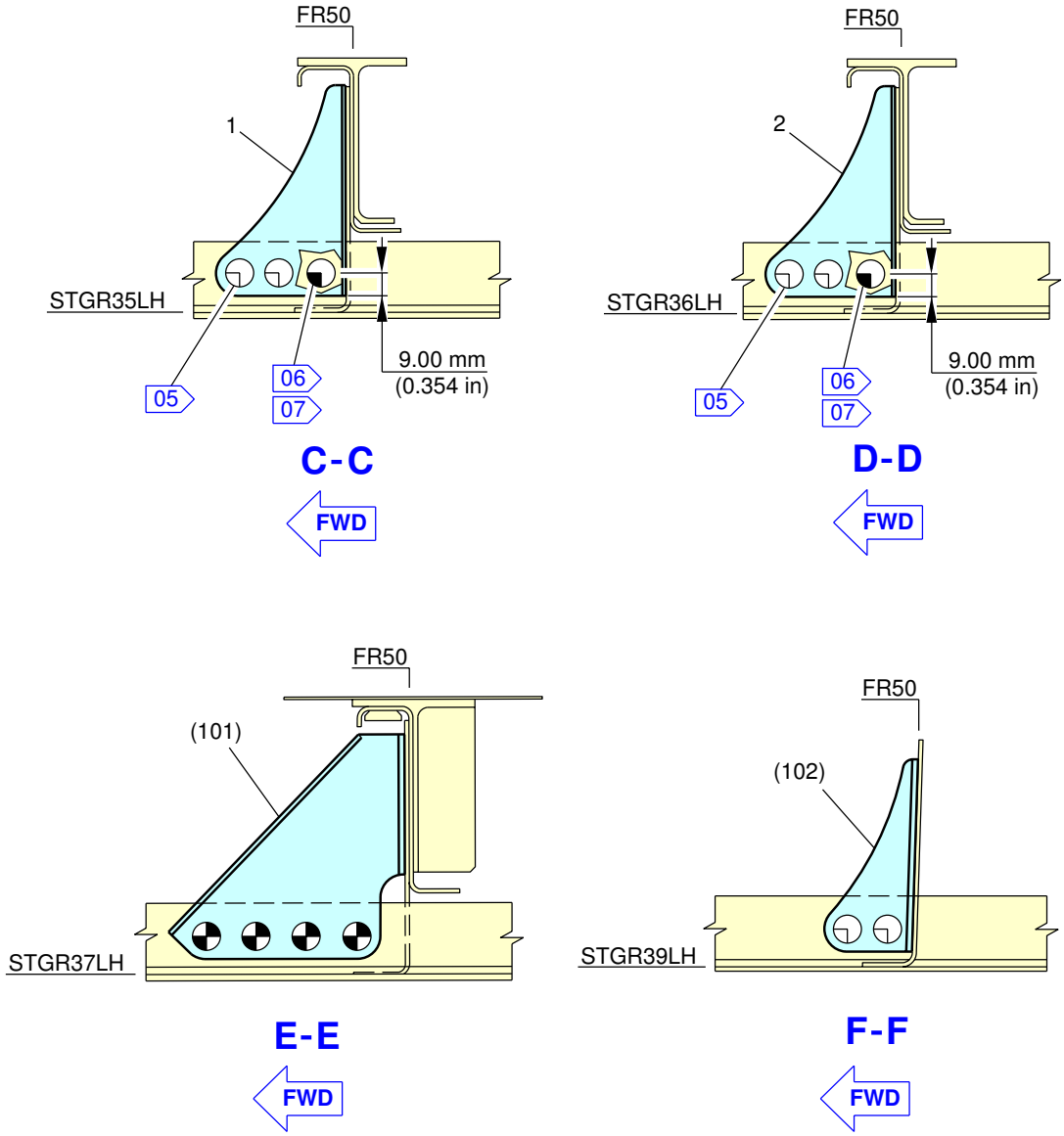
****CONF 002 thru 003**



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BAAB_03_01

Figure A-GBAAB - Sheet 03
Replacement of Webs and Angles at Frame 50

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**CONF 002 thru 003

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	768	DAN5–6–8X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	786	DAN5–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BAAB_04_01

Figure A-GBAAB - Sheet 04
Replacement of Webs and Angles at Frame 50

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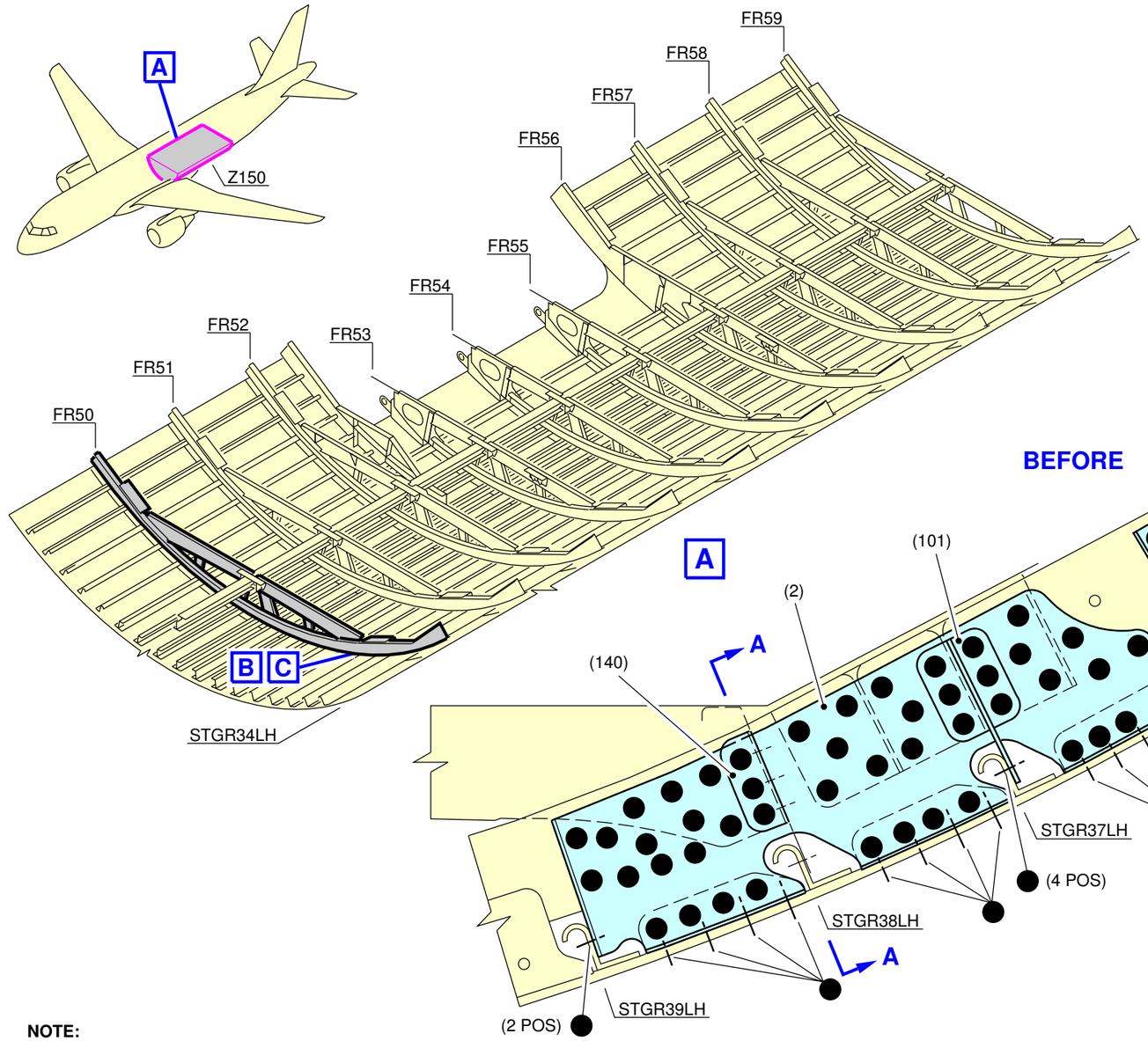
**CONF 004, 006



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BAAD_01_00

Figure A-GBAAD - Sheet 01
Replacement of Webs and Angles at Frame 50

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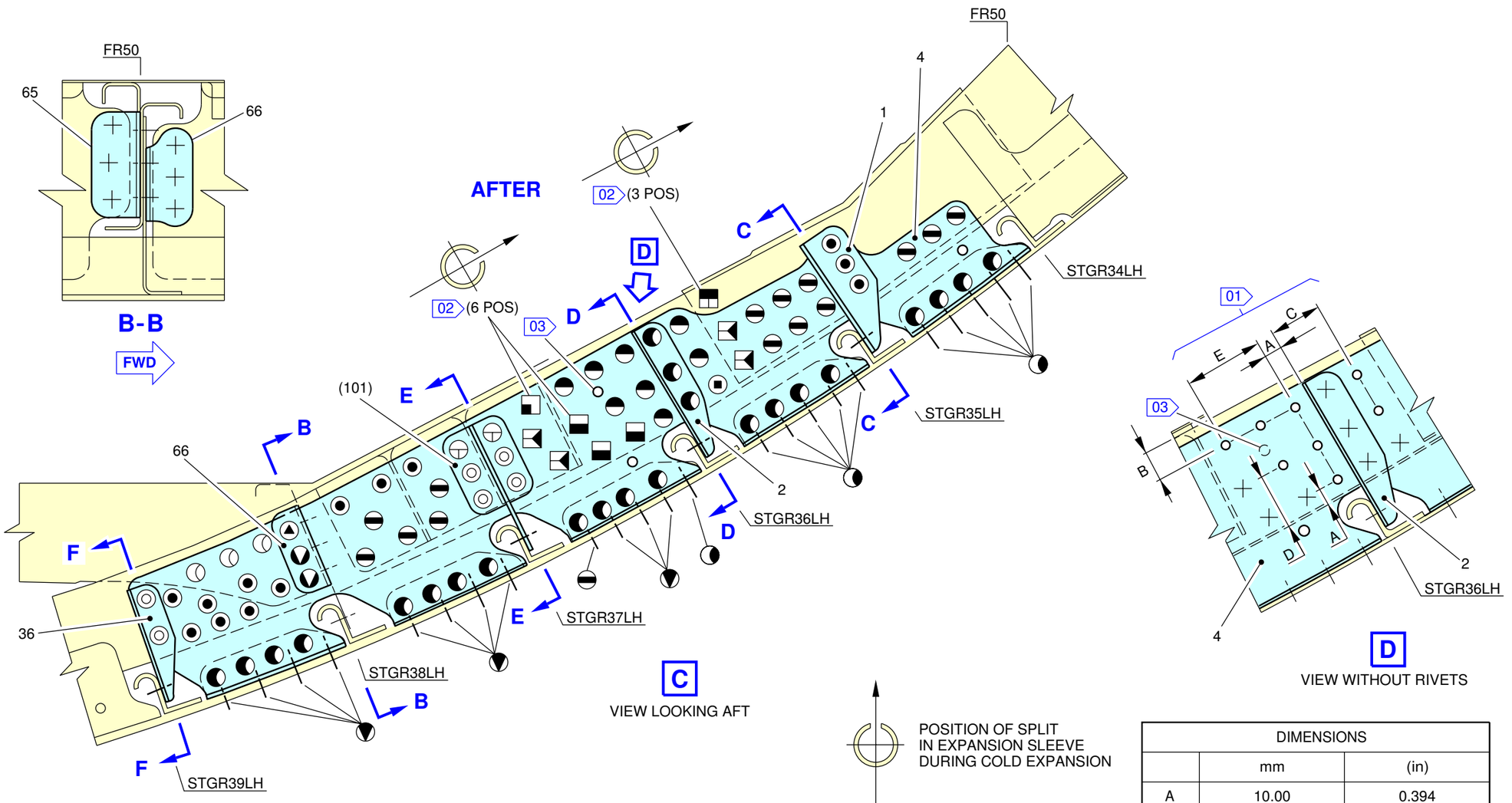
**CONF 004, 006



C
VIEW LOOKING AFT

D
VIEW WITHOUT RIVETS

POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BAAD_02_01

NOTE:

01 NEW HOLES

02 ▬ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, ◪ ◧ ◨ COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

┼ EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4

Figure A-GBAAD - Sheet 02
Replacement of Webs and Angles at Frame 50

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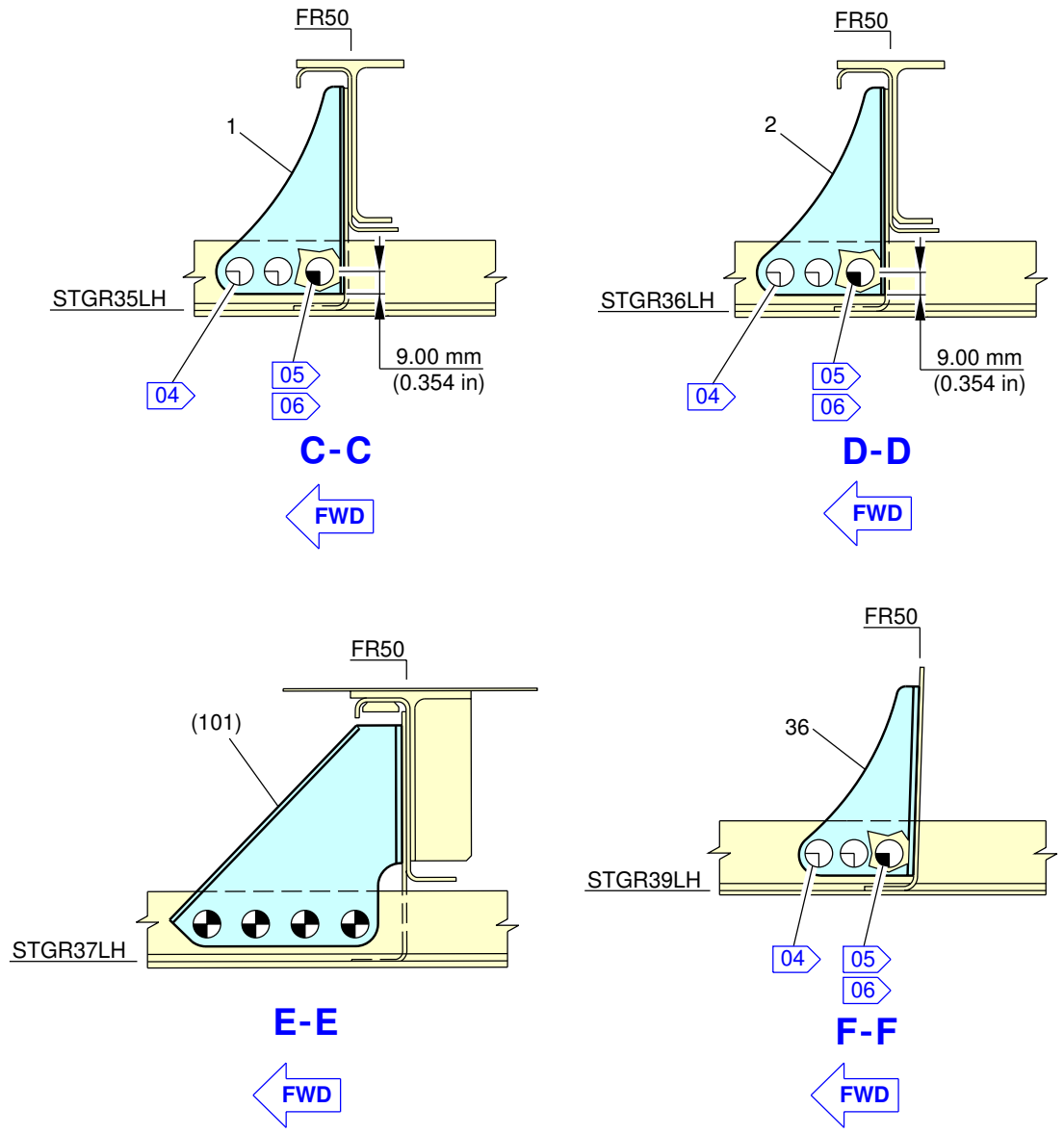
****CONF 004, 006**



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BAAD_03_01

Figure A-GBAAD - Sheet 03
Replacement of Webs and Angles at Frame 50

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**CONF 004, 006

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	768	DAN5–6–8X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	786	DAN5–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	875	DAN6–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BAAD_04_01

Figure A-GBAAD - Sheet 04
Replacement of Webs and Angles at Frame 50

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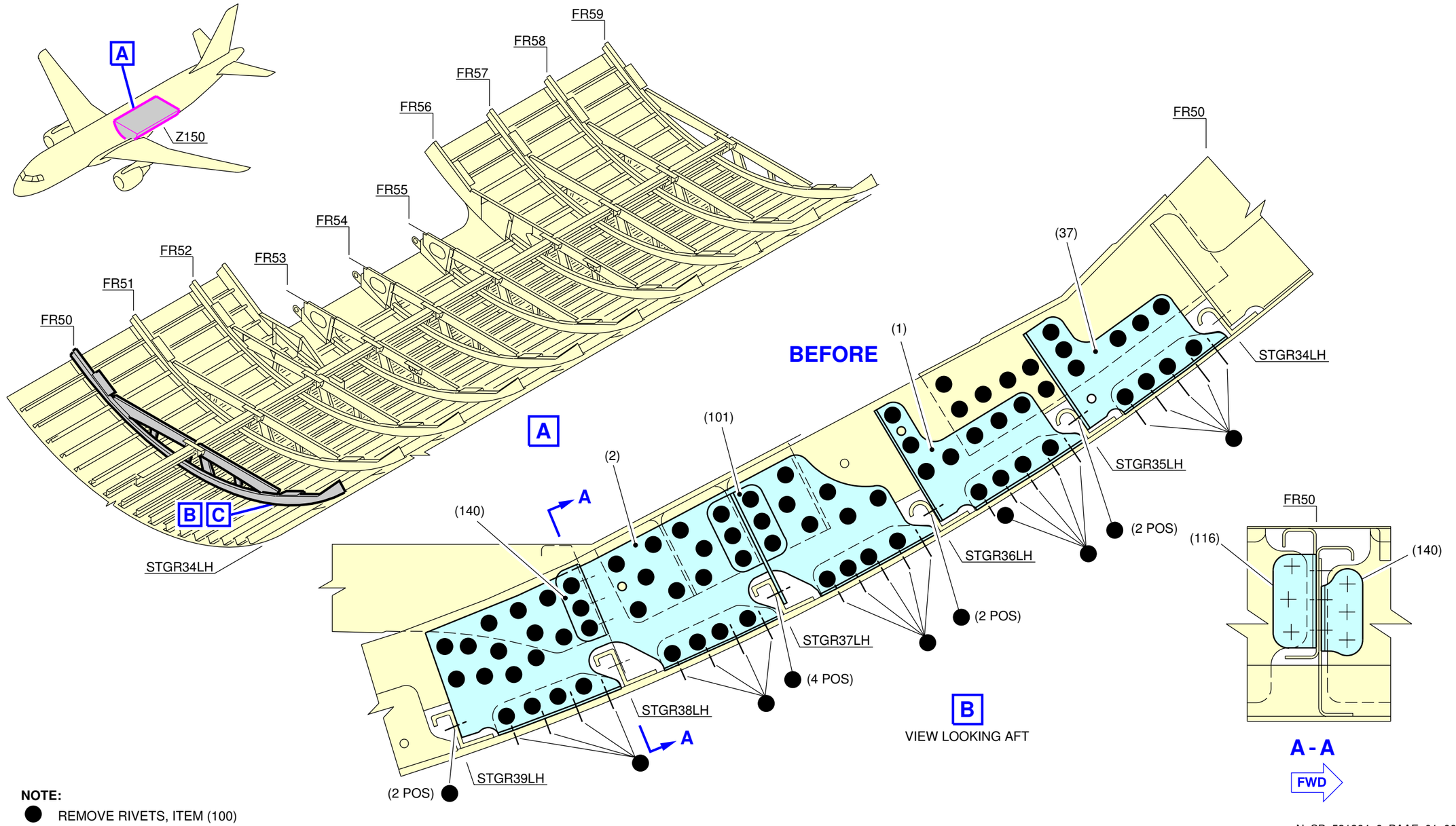
**CONF 005, 007



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BAAE_01_00

Figure A-GBAAE - Sheet 01
Replacement of Webs and Angles at Frame 50

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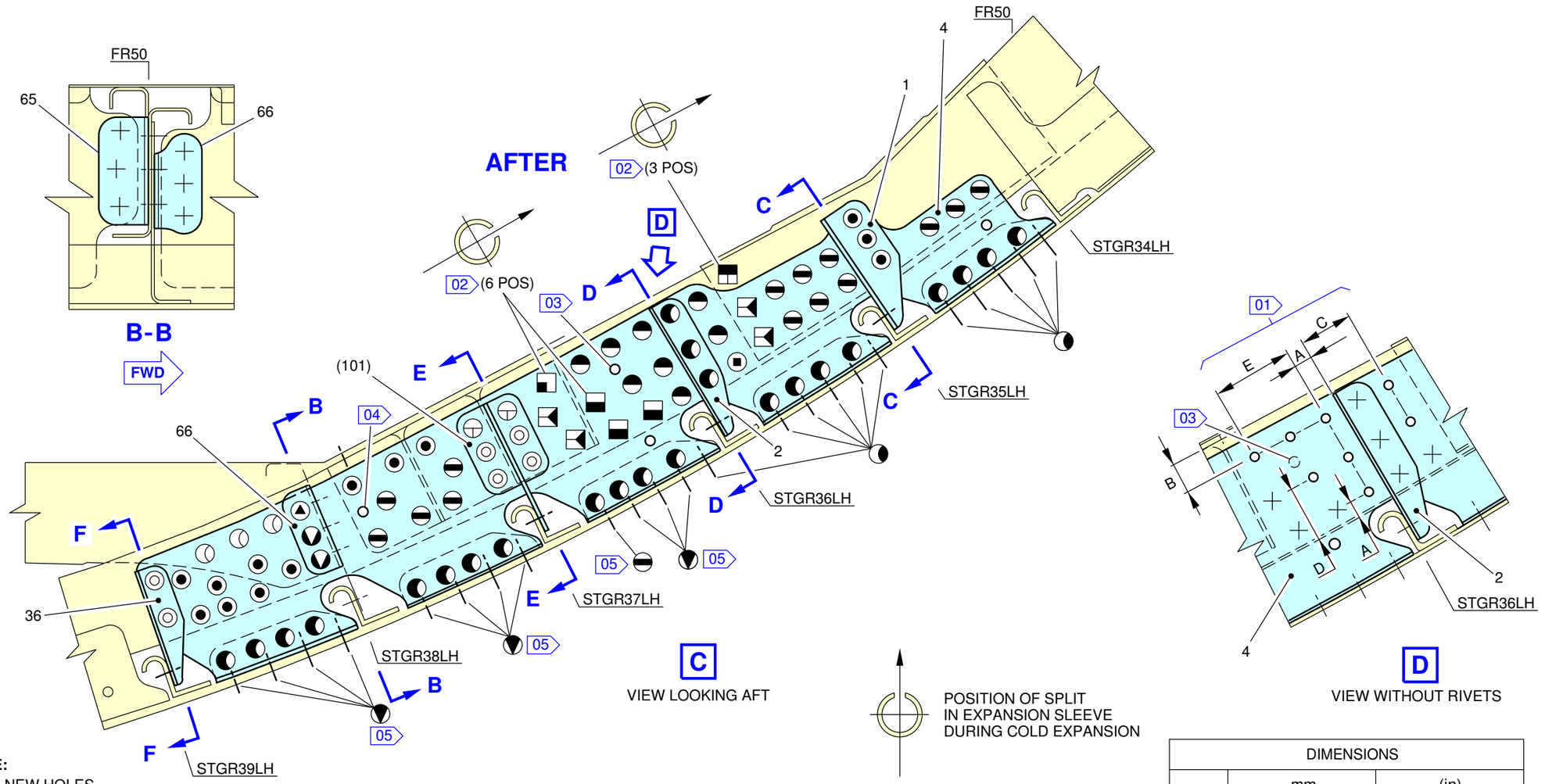
**CONF 005, 007



NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in), FOR MSN 3999 AND SUBSEQUENT.

05 RIVETED WITH BELLY FAIRING ANGLE.

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BAAE_02_01

Figure A-GBAAE - Sheet 02
Replacement of Webs and Angles at Frame 50

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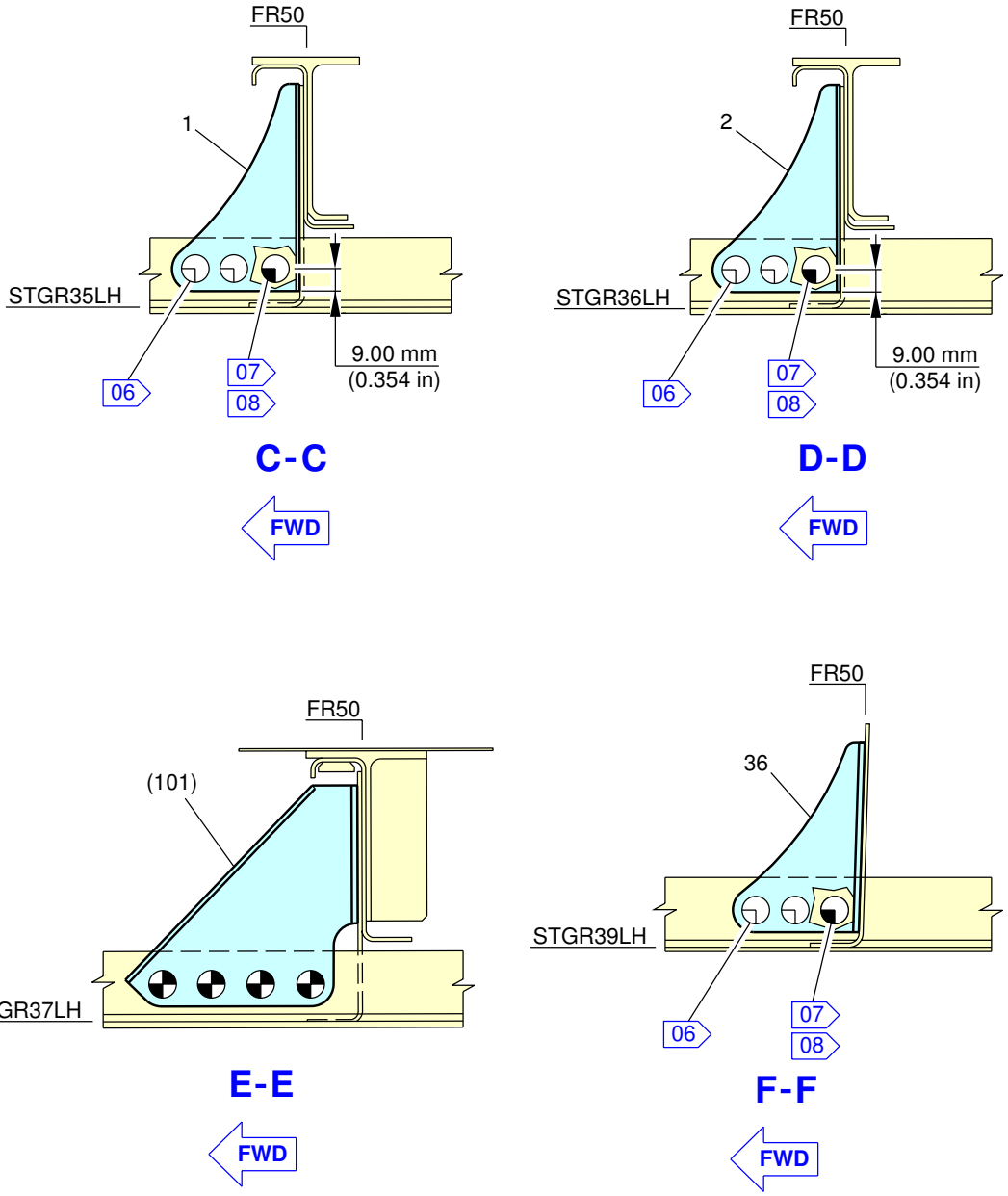
**CONF 005, 007



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BAAE_03_02

Figure A-GBAAE - Sheet 03
Replacement of Webs and Angles at Frame 50

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**CONF 005, 007

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	768	DAN5–6–8X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	786	DAN5–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BAAE_04_02

Figure A-GBAAE - Sheet 04
Replacement of Webs and Angles at Frame 50

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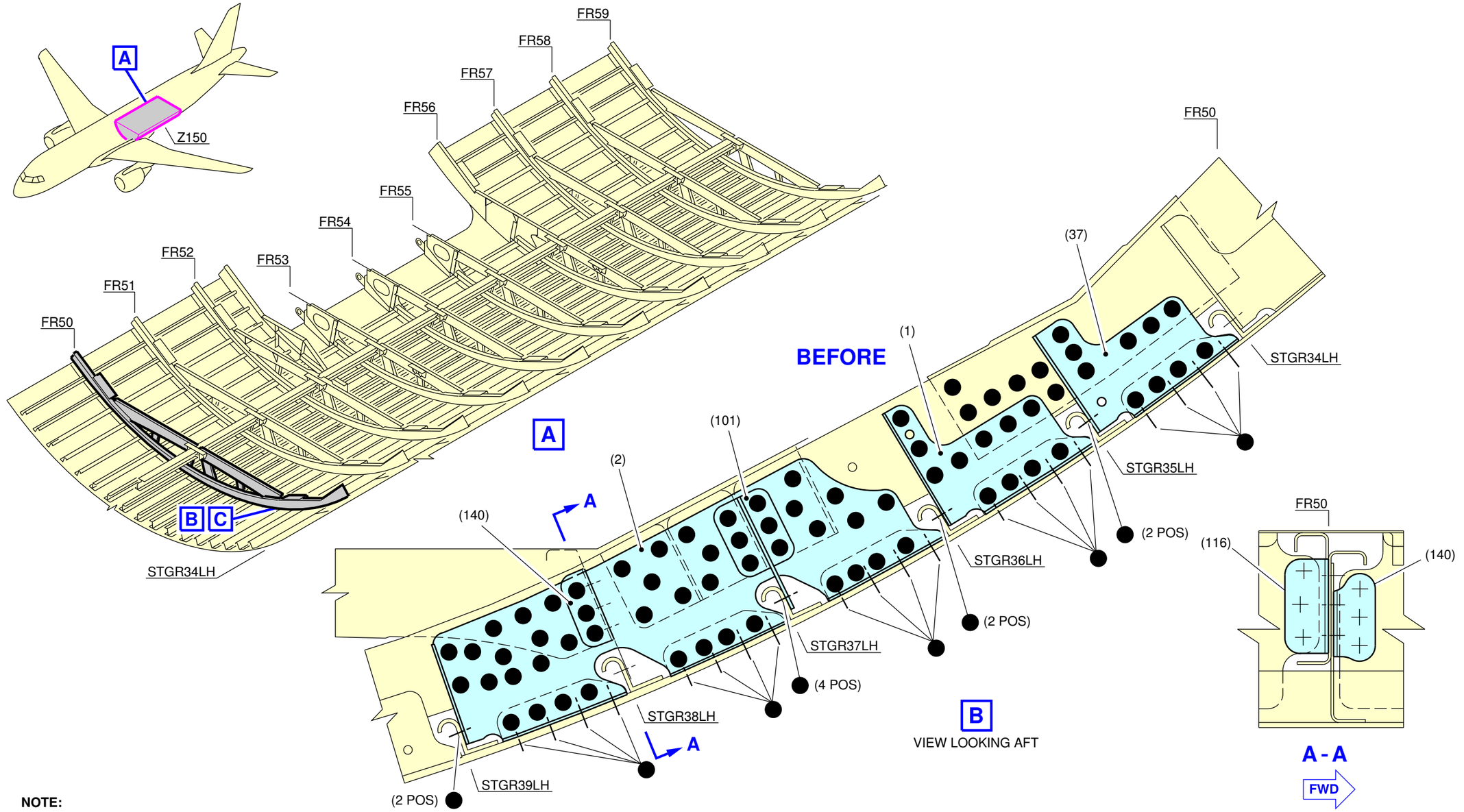
**CONF 008



NOTE:

● REMOVE RIVETS, ITEM (100)

Figure A-GBAAH - Sheet 01
Replacement of Webs and Angles at Frame 50

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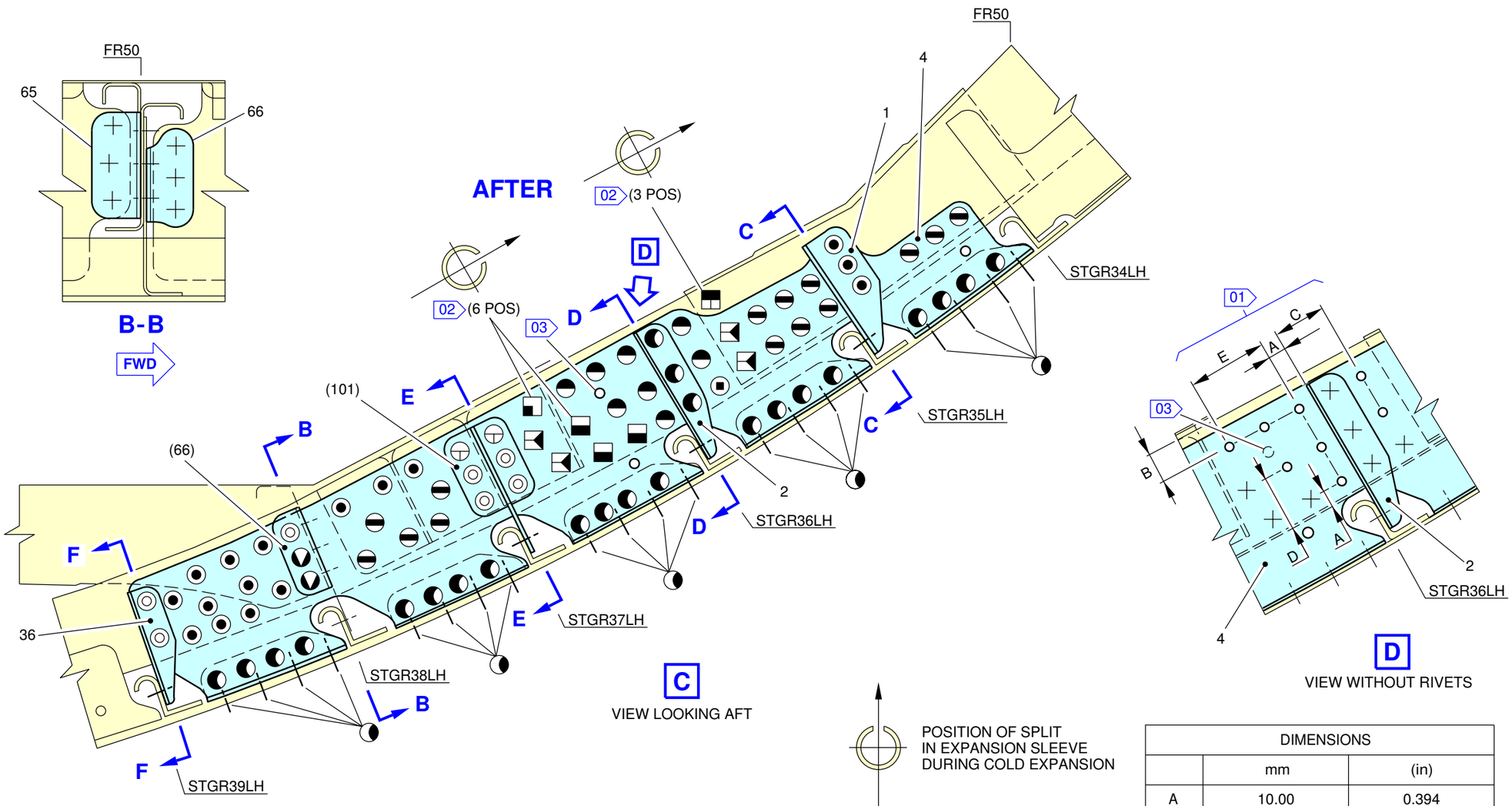
**CONF 008



C
VIEW LOOKING AFT

D
VIEW WITHOUT RIVETS

POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BAAH_02_01

Figure A-GBAAH - Sheet 02
Replacement of Webs and Angles at Frame 50

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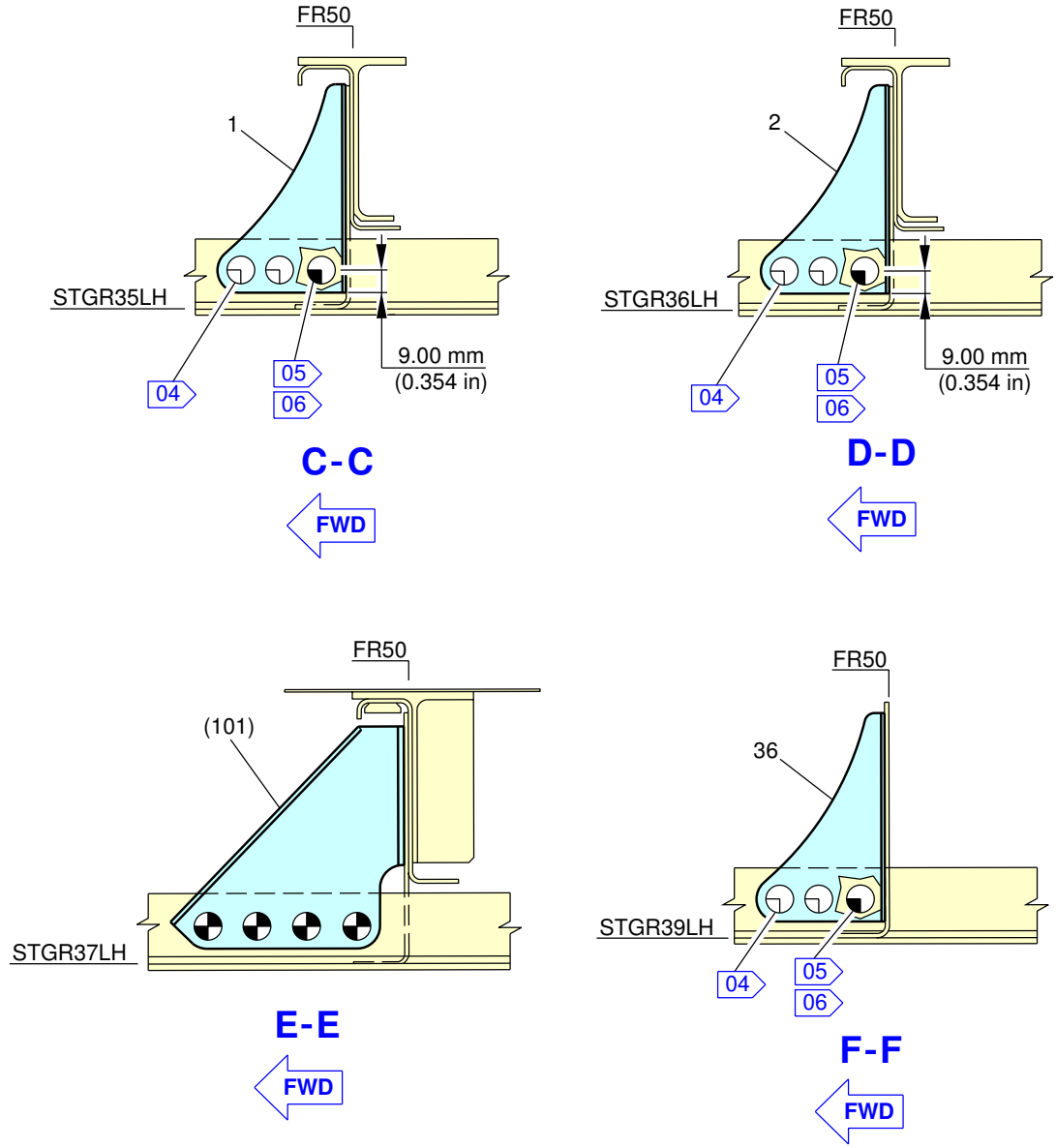
****CONF 008**



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BAAH_03_02

Figure A-GBAAH - Sheet 03
Replacement of Webs and Angles at Frame 50

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**CONF 008

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	768	DAN5–6–8X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BAAH_04_02

Figure A-GBAAH - Sheet 04
Replacement of Webs and Angles at Frame 50

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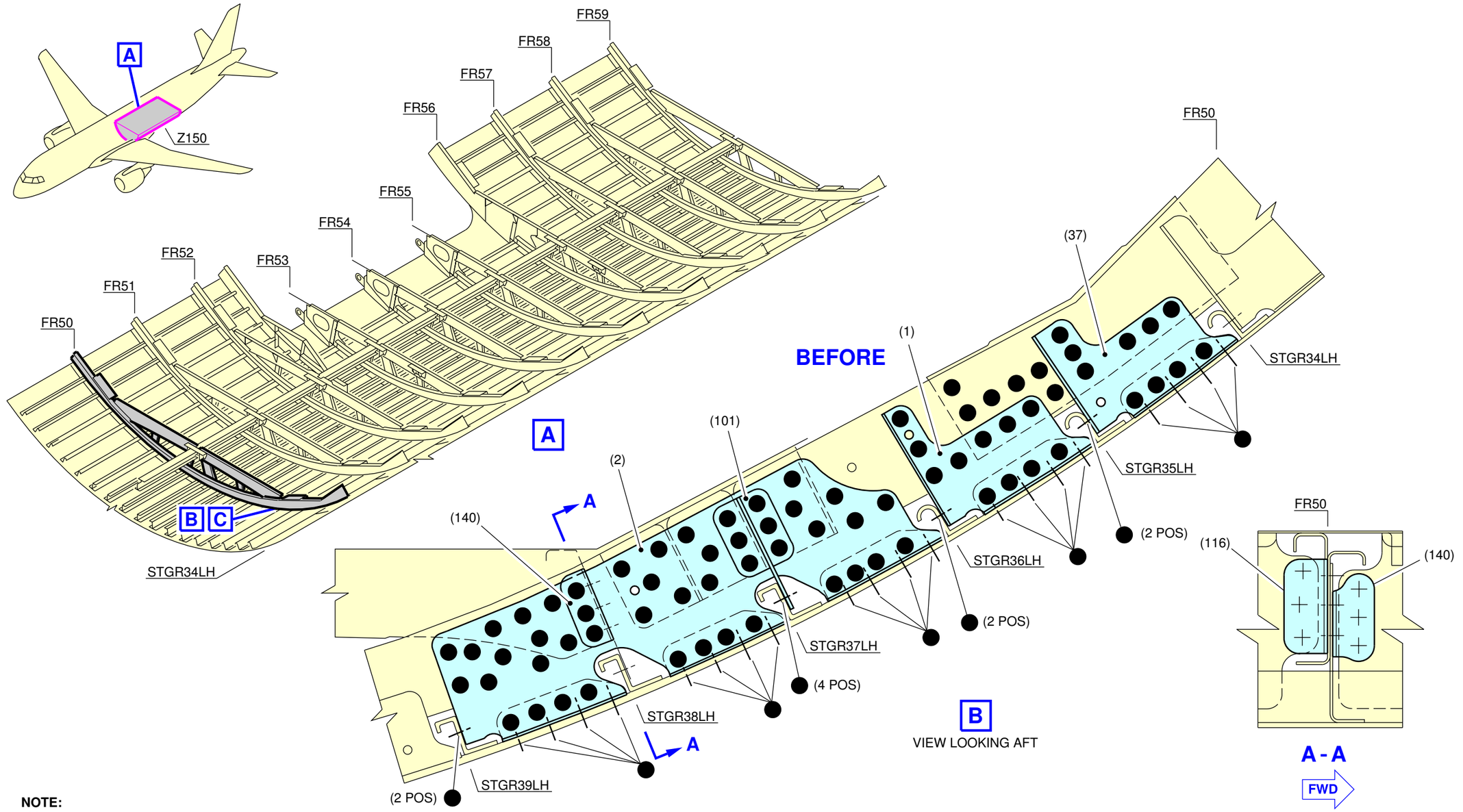
**CONF 009



N_SB_531364_6_BAAJ_01_00

NOTE:

● REMOVE RIVETS, ITEM (100)

Figure A-GBAAJ - Sheet 01
Replacement of Webs and Angles at Frame 50

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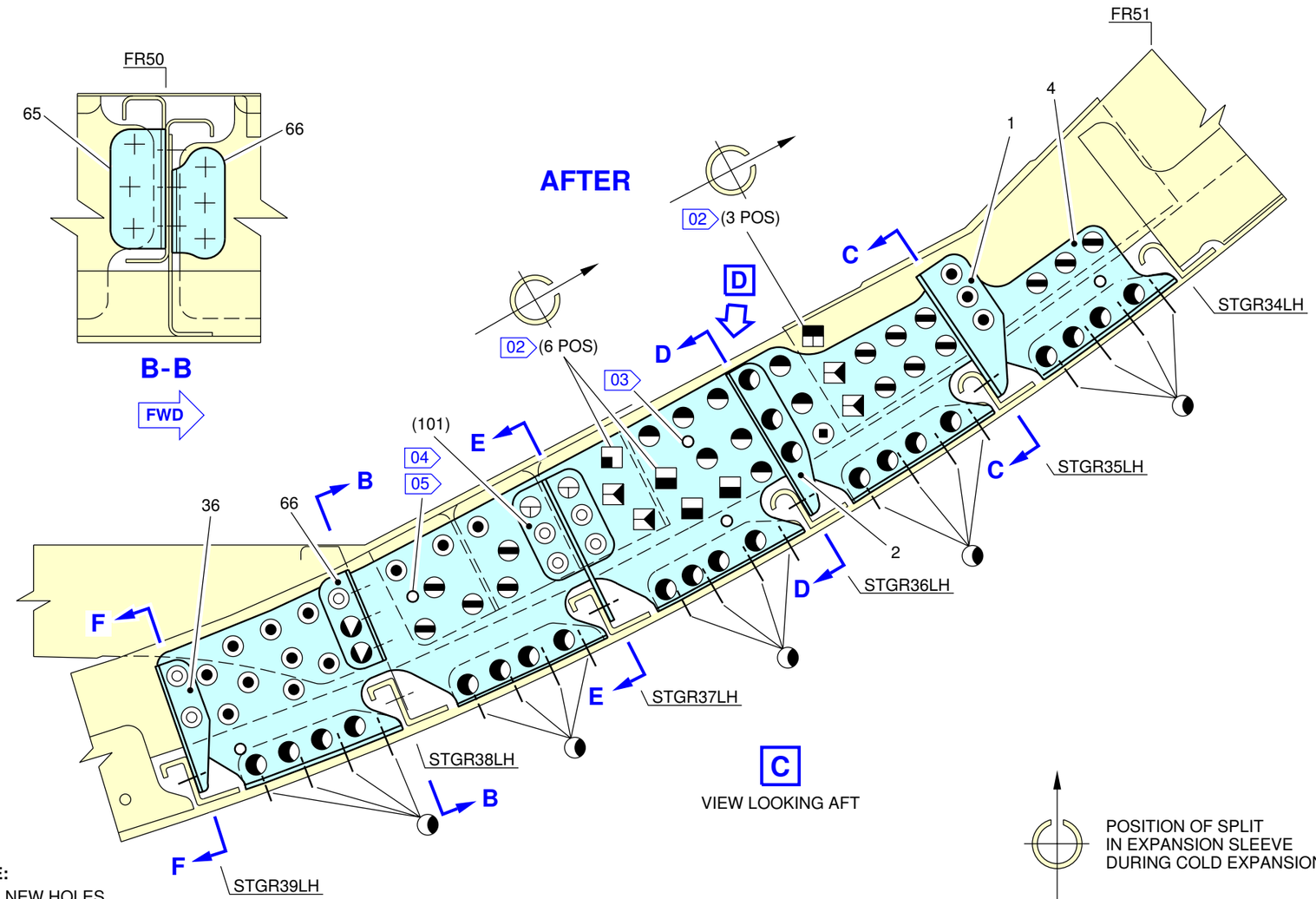
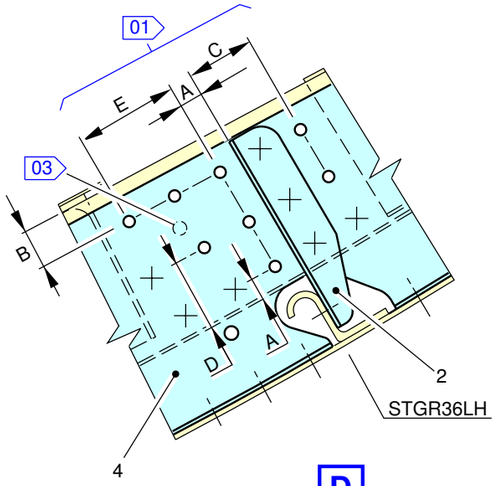
**CONF 009



C

VIEW LOOKING AFT



D

VIEW WITHOUT RIVETS

POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BAAJ_02_01

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in).

05 VALID FOR MSN 4005 AND SUBSEQUENT.

+ EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

Figure A-GBAAJ - Sheet 02
Replacement of Webs and Angles at Frame 50

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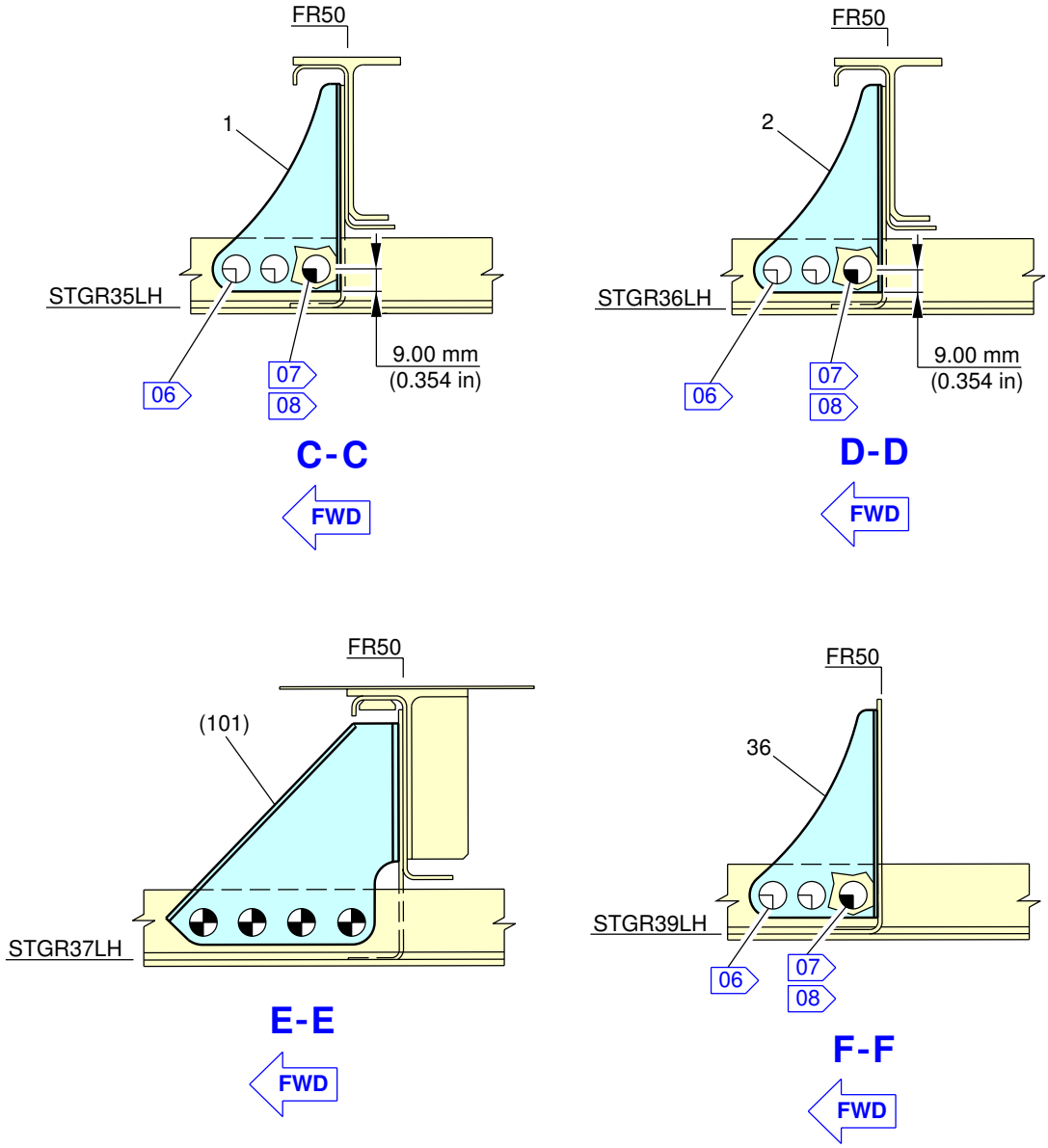
**CONF 009



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BAAJ_03_02

Figure A-GBAAJ - Sheet 03
Replacement of Webs and Angles at Frame 50

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**CONF 009

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	768	DAN5–6–8X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BAAJ_04_02

Figure A-GBAAJ - Sheet 04
Replacement of Webs and Angles at Frame 50

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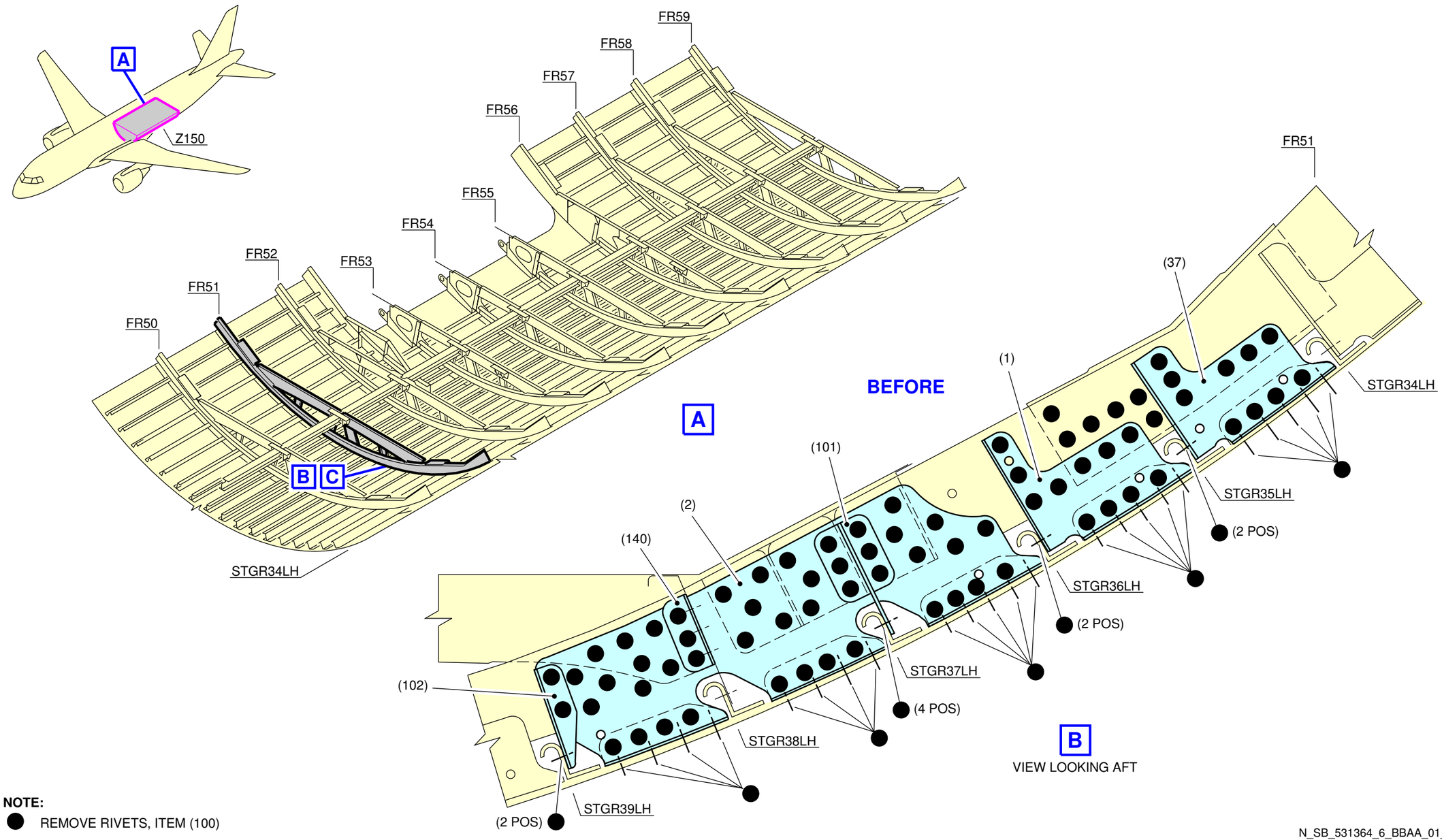
**CONF 001



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BBAA_01_00

Figure A-GBBAA - Sheet 01
Replacement of Webs and Angles at Frame 51

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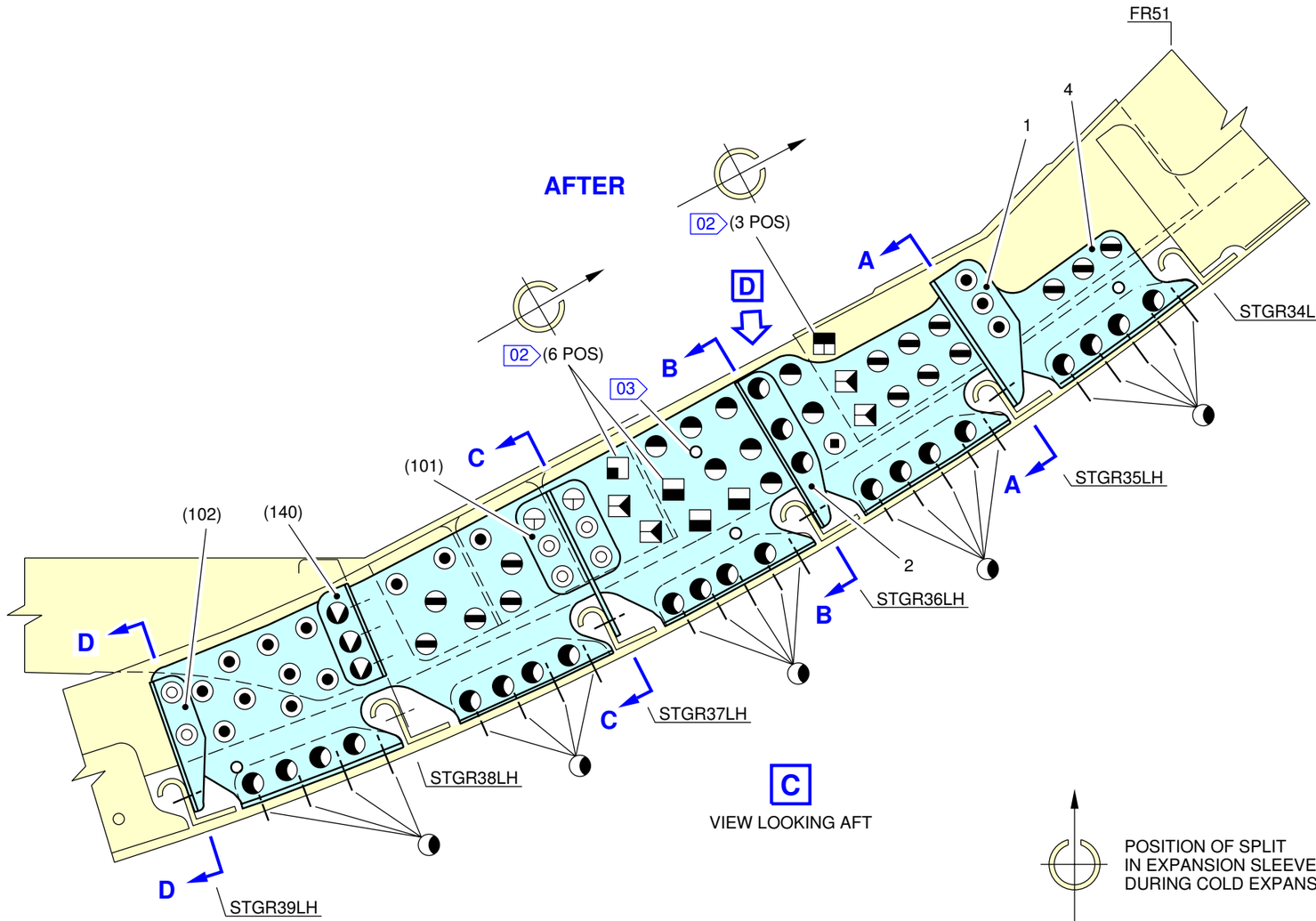
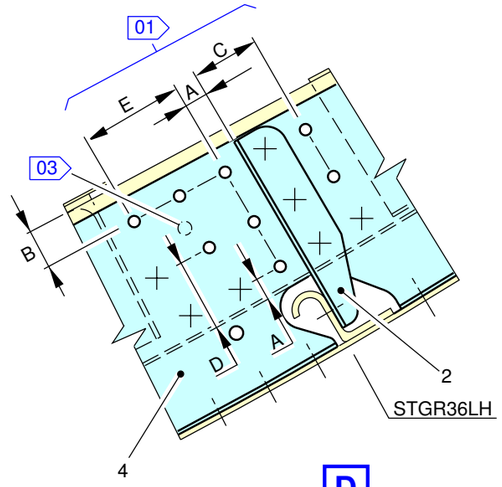
**CONF 001





POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BBAA_02_01

NOTE:

01 NEW HOLES

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4

Figure A-GBBAA - Sheet 02
Replacement of Webs and Angles at Frame 51

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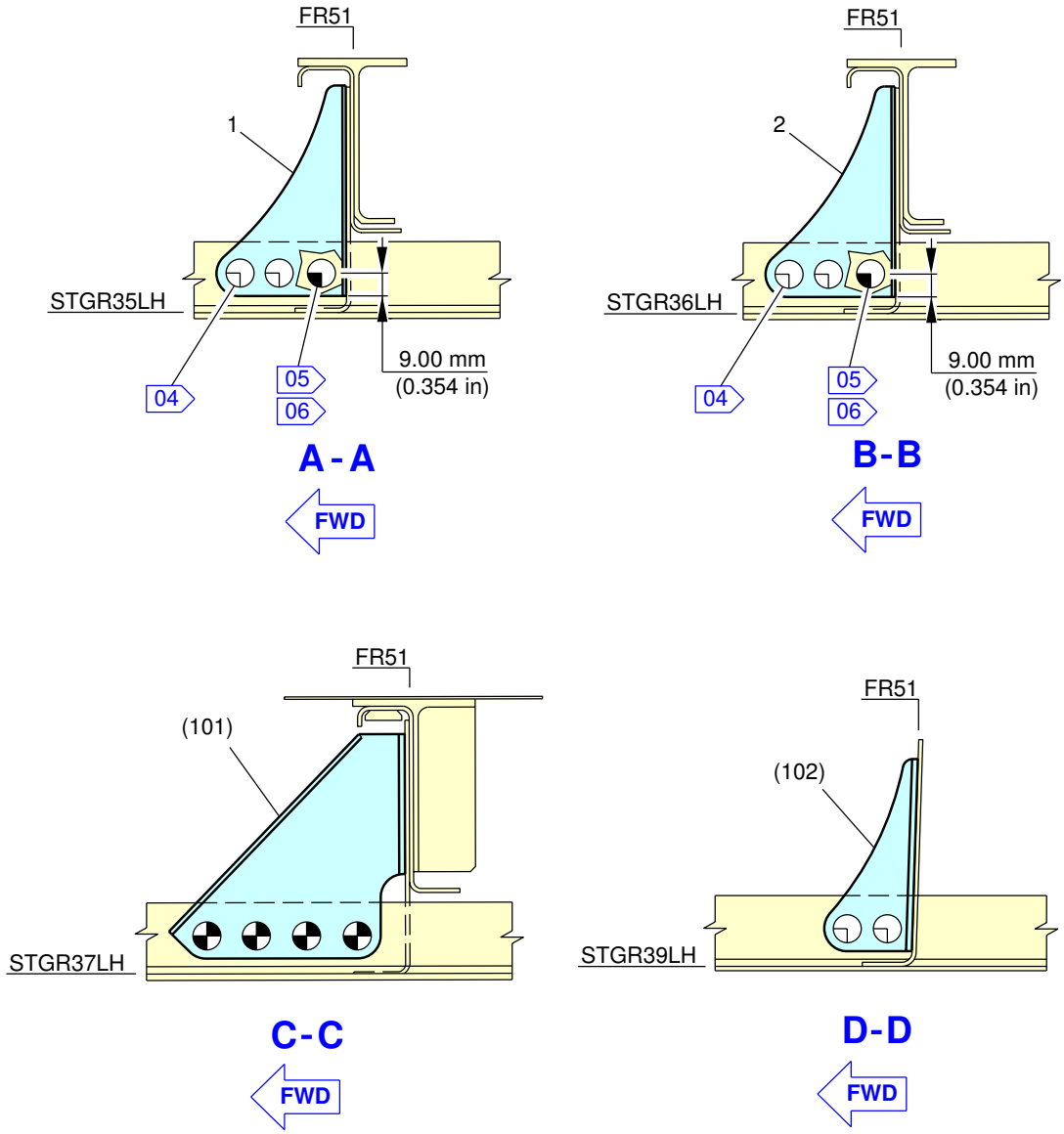
**CONF 001



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BBAA_03_02

Figure A-GBBAA - Sheet 03
Replacement of Webs and Angles at Frame 51

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**CONF 001

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	768	DAN5–6–8X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BBAA_04_02

Figure A-GBBAA - Sheet 04
Replacement of Webs and Angles at Frame 51

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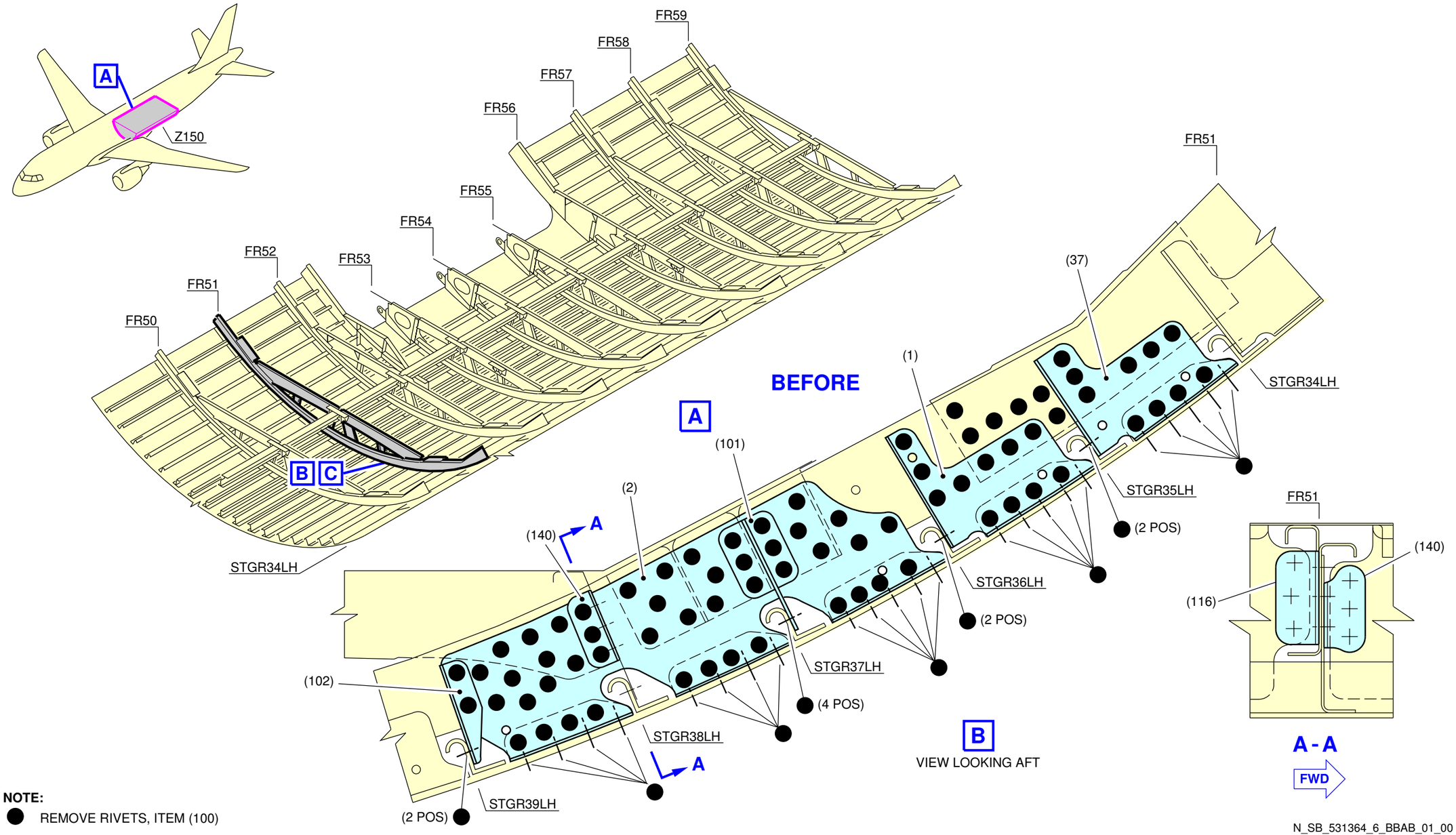
**CONF 002 thru 003



NOTE:

● REMOVE RIVETS, ITEM (100)

Figure A-GBBAB - Sheet 01
Replacement of Webs and Angles at Frame 51

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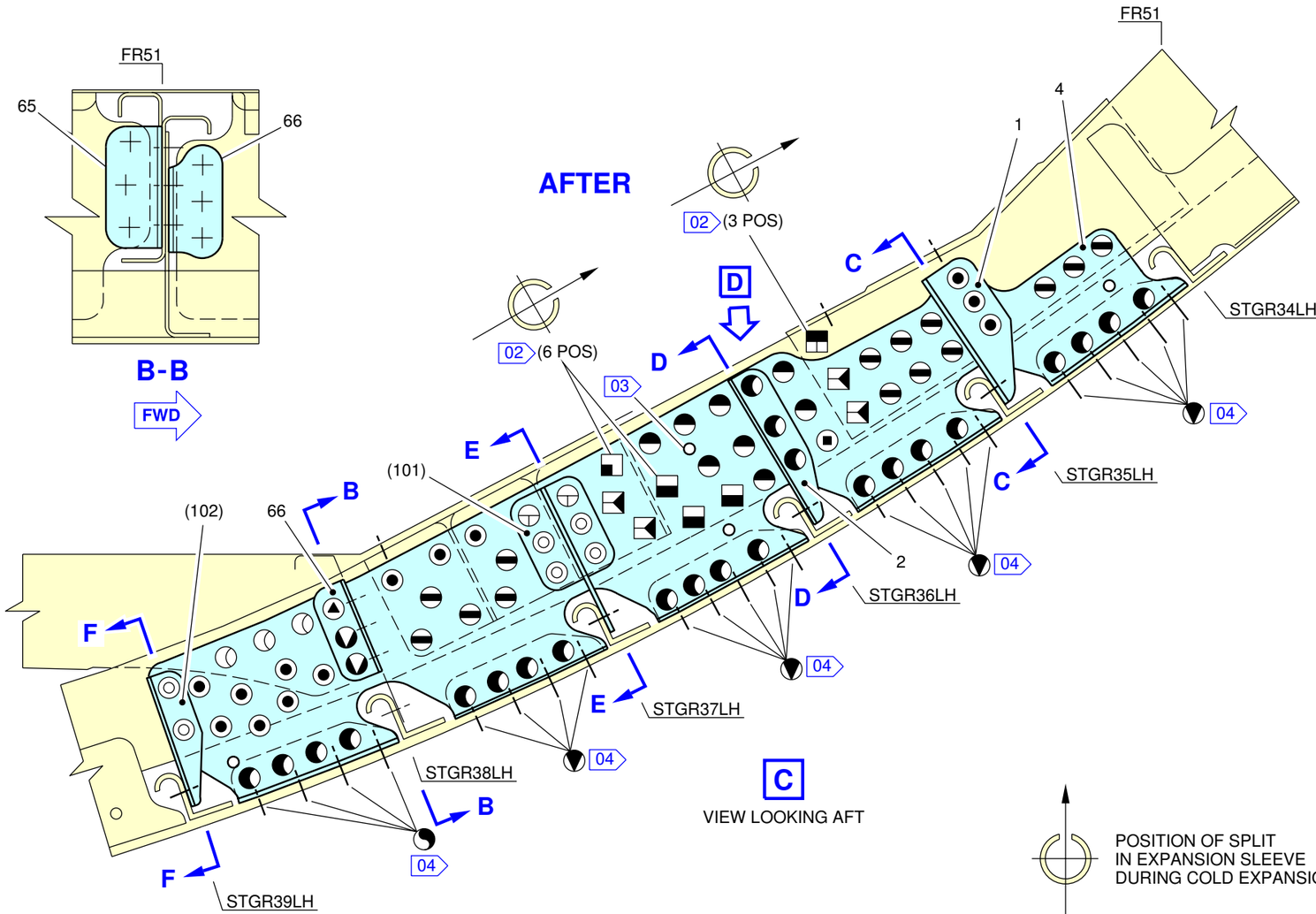
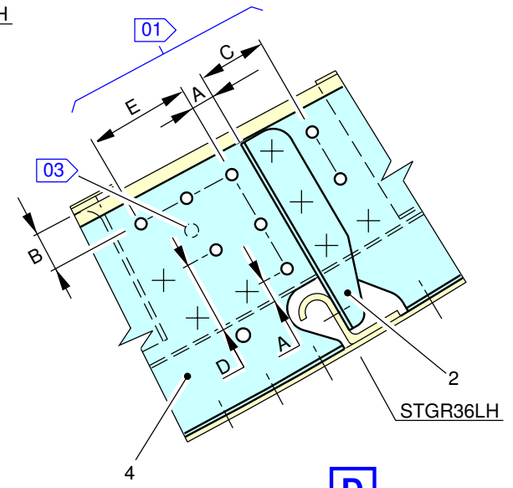
**CONF 002 thru 003





POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BBAB_02_01

NOTE:

01 NEW HOLES

02 ▬ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, ◧ ◨ ▬ COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

04 RIVETED WITH BELLY FAIRING ANGLE.

┼ EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4

Figure A-GBBAB - Sheet 02
Replacement of Webs and Angles at Frame 51

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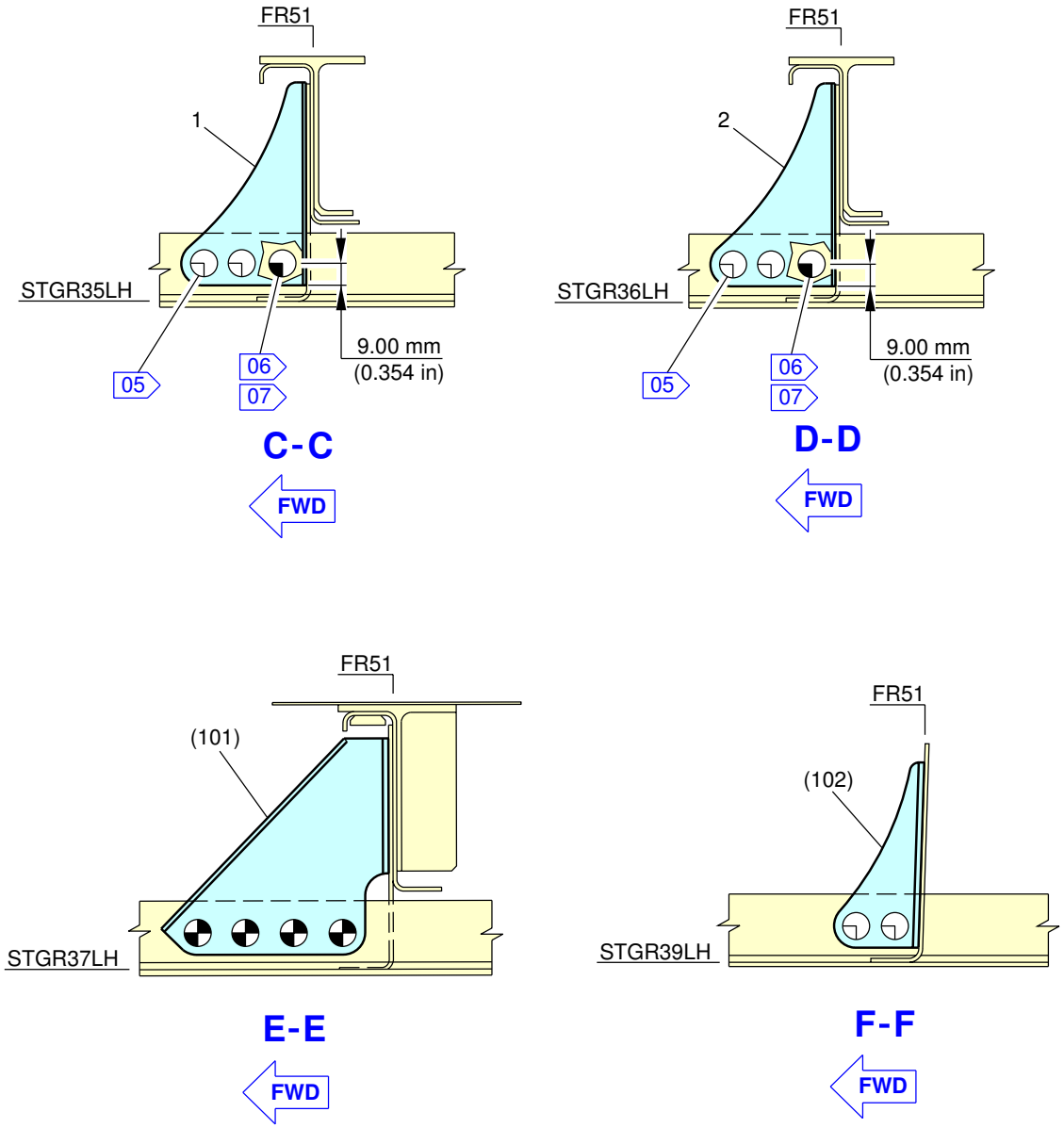
**CONF 002 thru 003



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BBAB_03_01

Figure A-GBBAB - Sheet 03
Replacement of Webs and Angles at Frame 51

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**CONF 002 thru 003

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	768	DAN5–6–8X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	786	DAN5–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BBAB_04_01

Figure A-GBBAB - Sheet 04
Replacement of Webs and Angles at Frame 51

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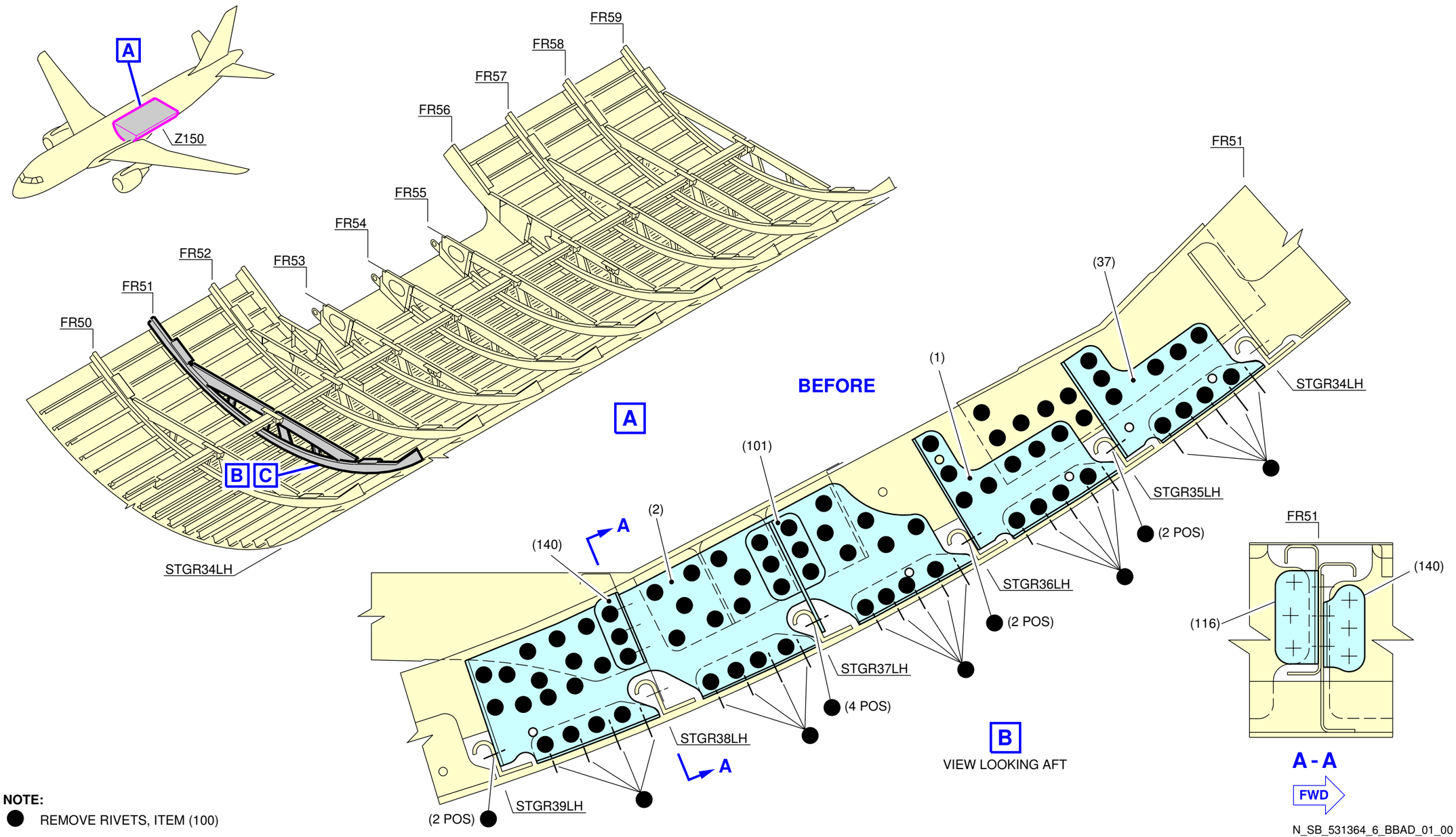
**CONF 004, 006



NOTE:

● REMOVE RIVETS, ITEM (100)

Figure A-GBBAD - Sheet 01
Replacement of Webs and Angles at Frame 51

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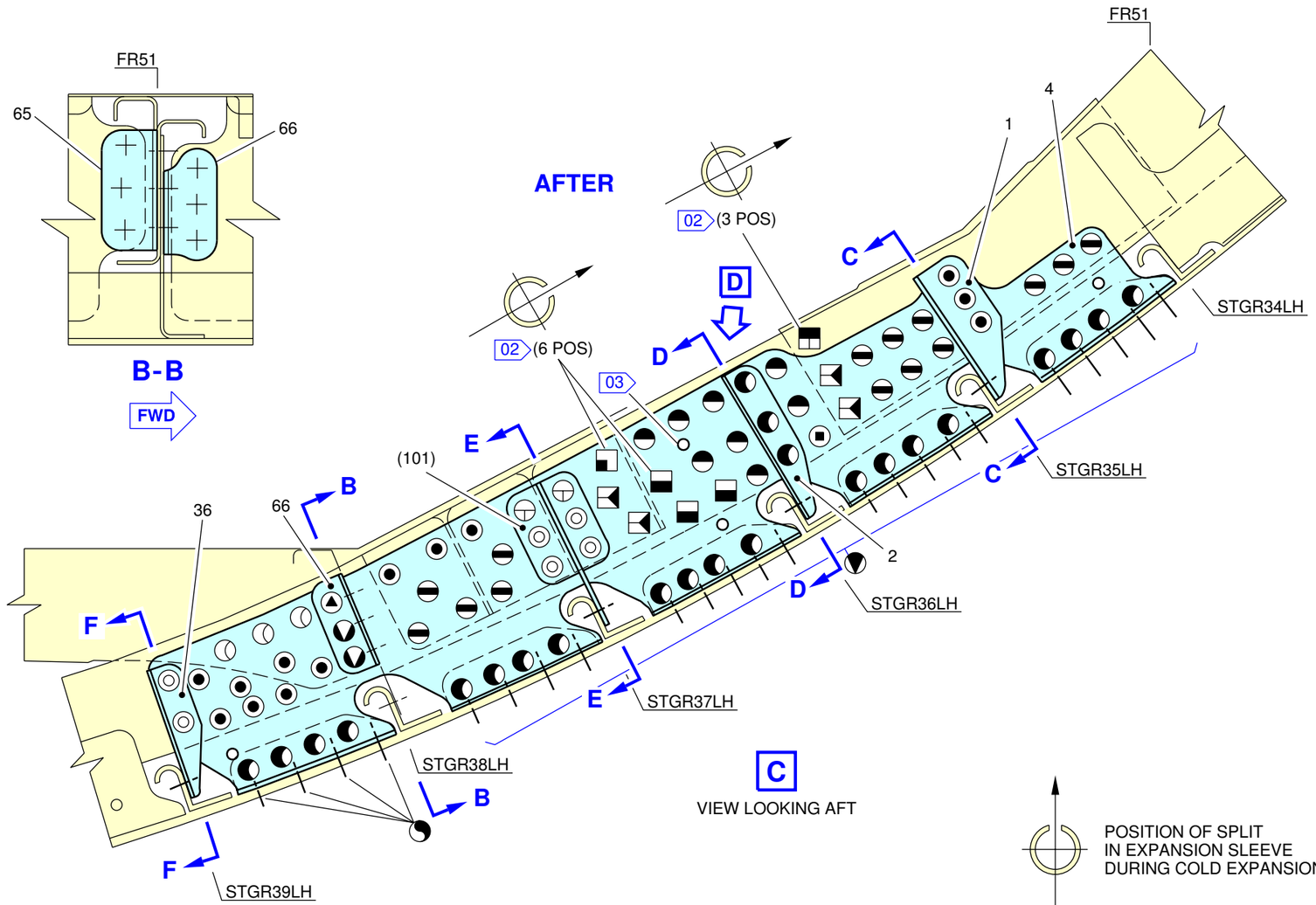
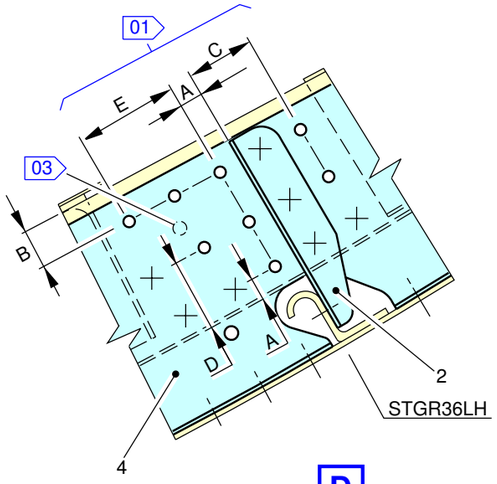
**CONF 004, 006



C

VIEW LOOKING AFT



D

VIEW WITHOUT RIVETS

POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BBAD_02_01

NOTE:

01 NEW HOLES

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4

Figure A-GBBAD - Sheet 02
Replacement of Webs and Angles at Frame 51

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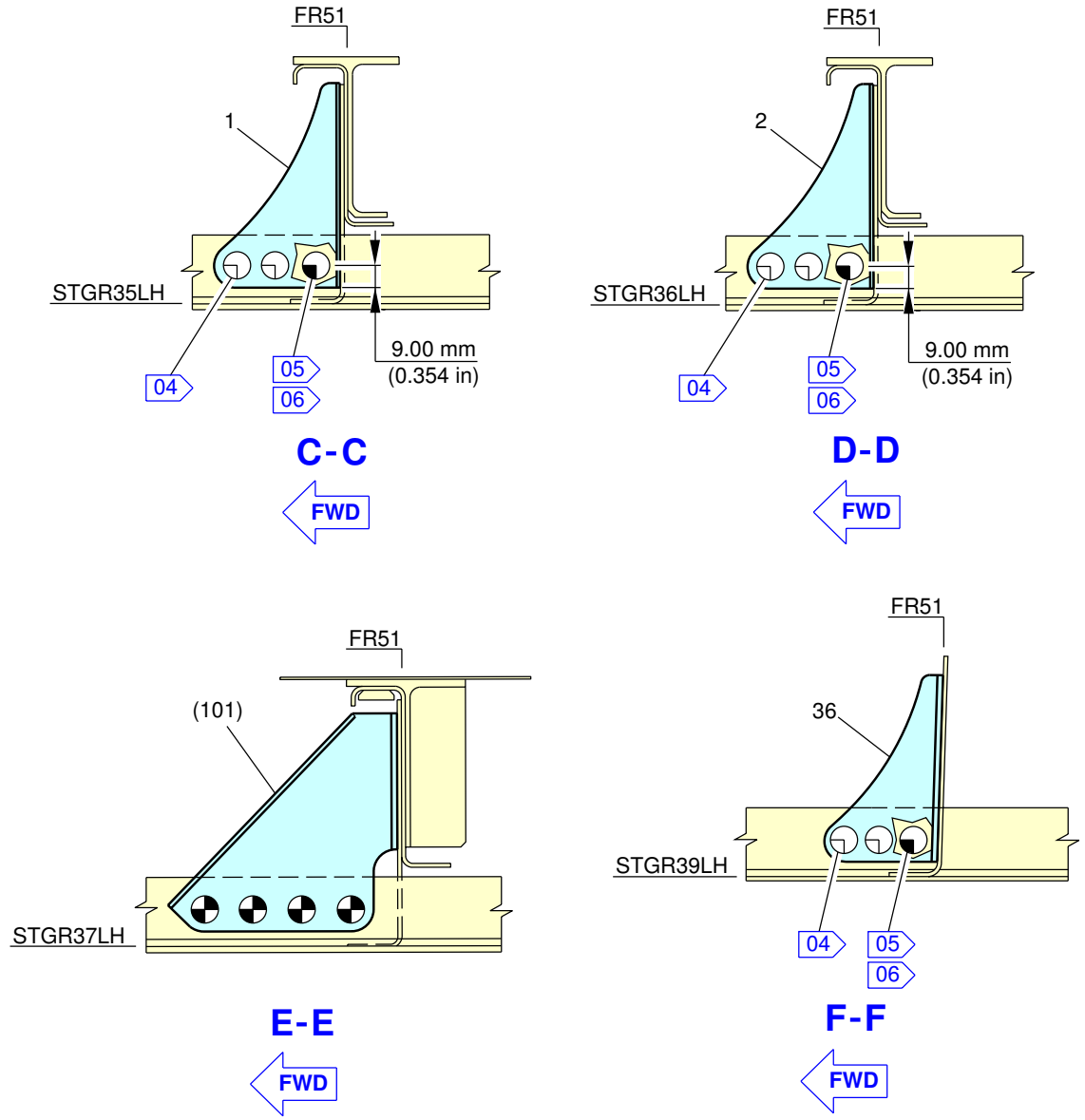
**CONF 004, 006



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BBAD_03_02

Figure A-GBBAD - Sheet 03
Replacement of Webs and Angles at Frame 51

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**CONF 004, 006

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	768	DAN5–6–8X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	786	DAN5–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BBAD_04_02

Figure A-GBBAD - Sheet 04
Replacement of Webs and Angles at Frame 51

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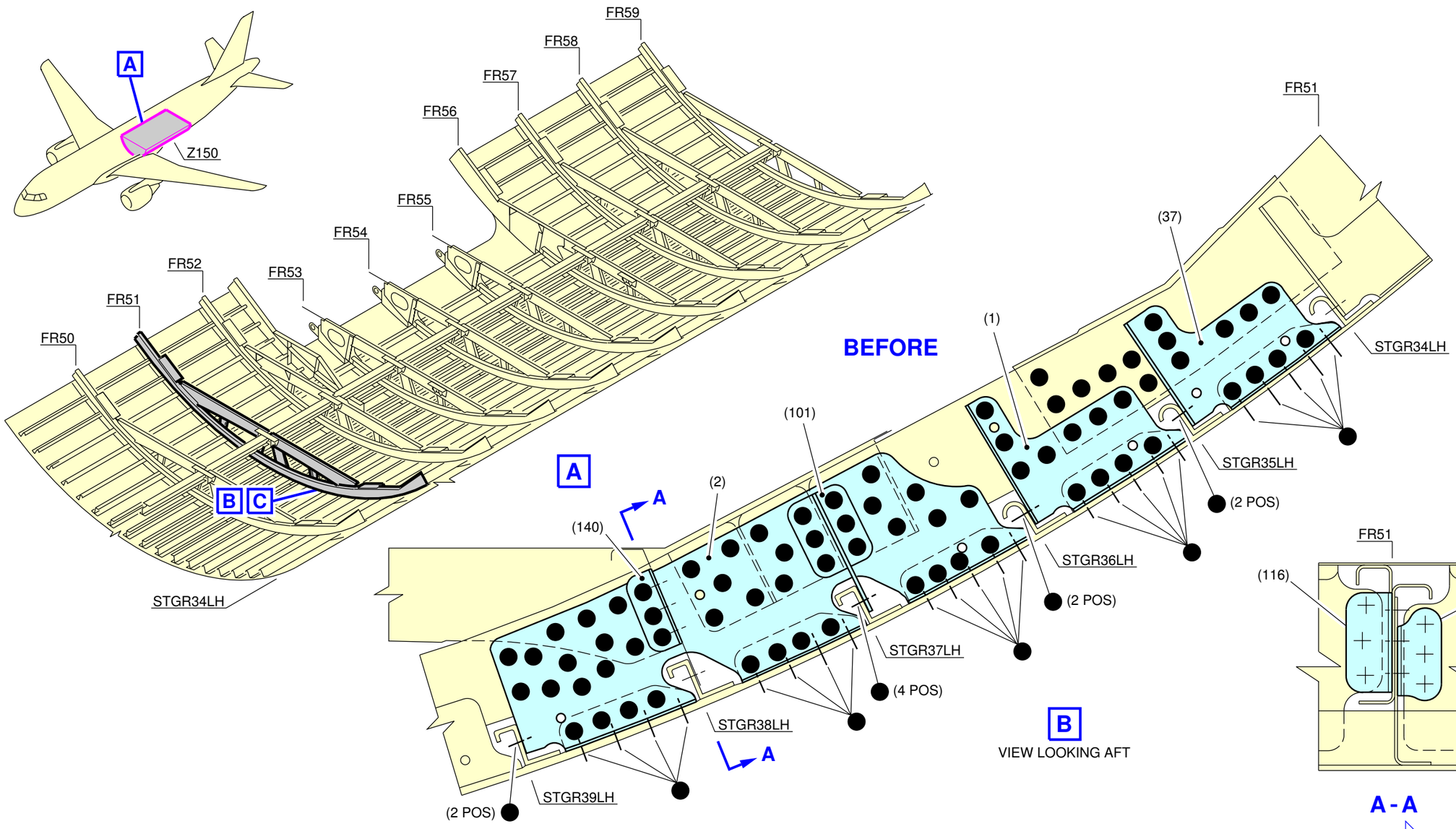
**CONF 005, 007



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BBAE_01_00

Figure A-GBBAE - Sheet 01
Replacement of Webs and Angles at Frame 51

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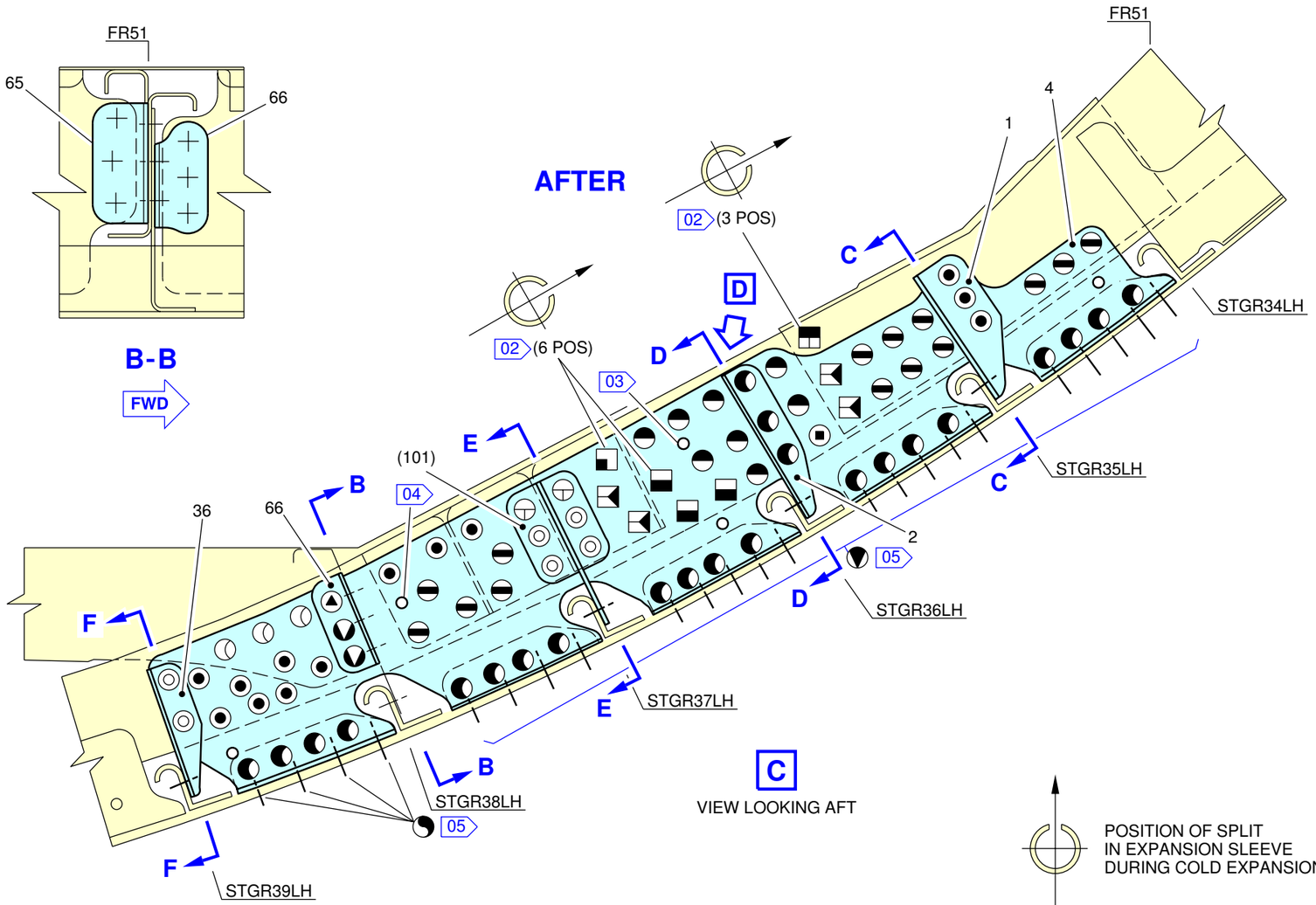
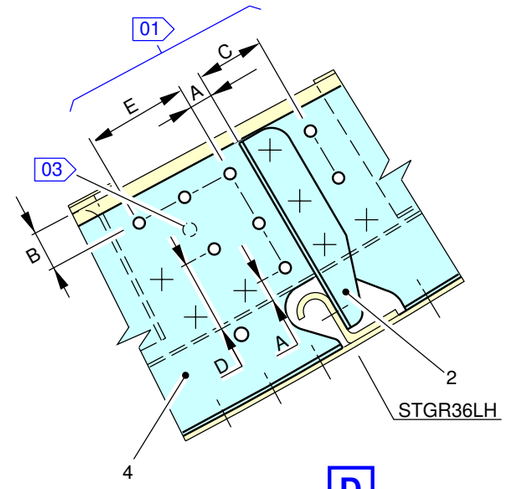
**CONF 005, 007





POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in), FOR MSN 3999 AND SUBSEQUENT.

05 RIVETED WITH BELLY FAIRING ANGLE.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BBAE_02_02

Figure A-GBBAE - Sheet 02
Replacement of Webs and Angles at Frame 51

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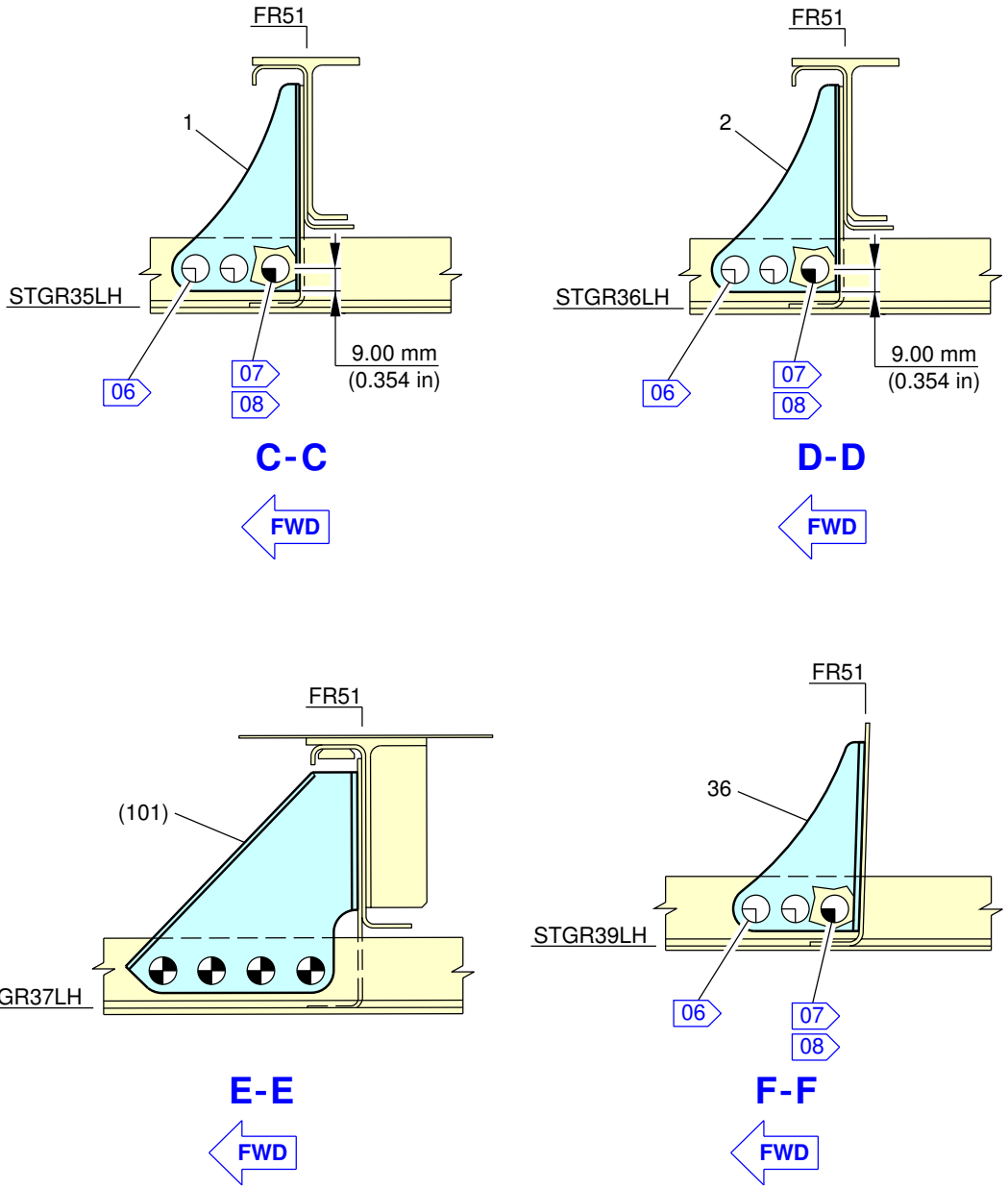
**CONF 005, 007



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BBAE_03_01

Figure A-GBBAE - Sheet 03
Replacement of Webs and Angles at Frame 51

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**CONF 005, 007

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	768	DAN5–6–8X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	786	DAN5–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BBAE_04_01

Figure A-GBBAE - Sheet 04
Replacement of Webs and Angles at Frame 51

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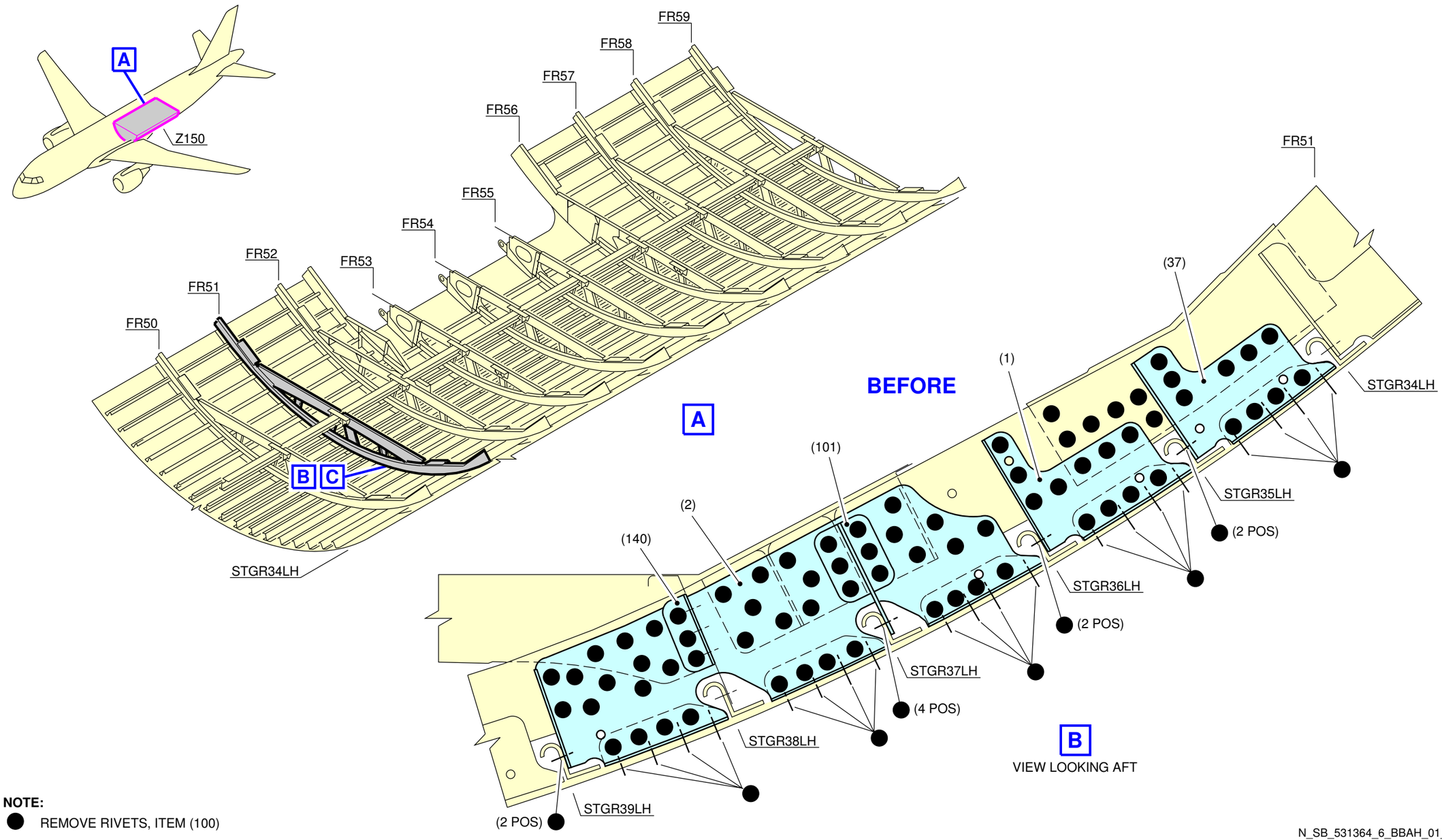
**CONF 008



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BBAH_01_00

Figure A-GBBAH - Sheet 01
Replacement of Webs and Angles at Frame 51

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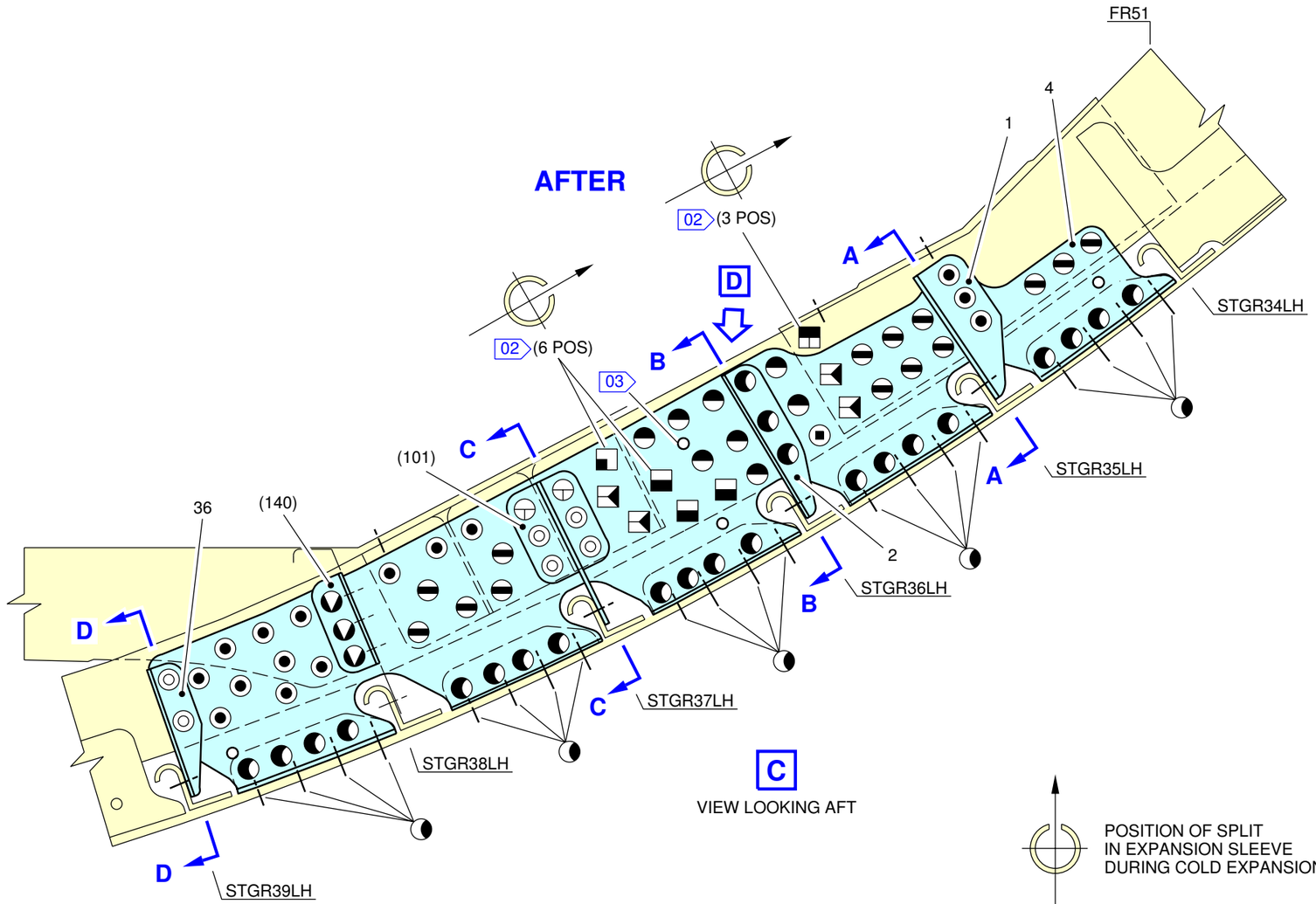
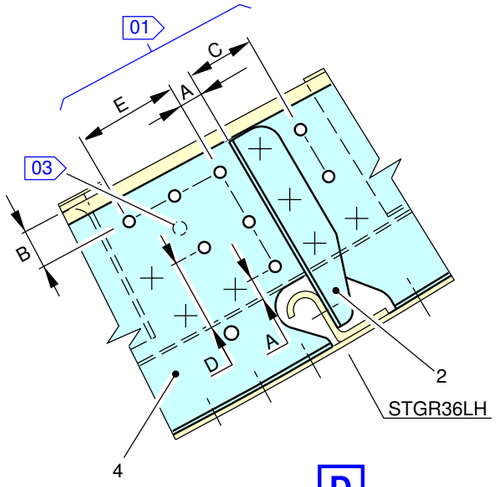
**CONF 008





POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BBAH_02_01

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

Figure A-GBBAH - Sheet 02
Replacement of Webs and Angles at Frame 51

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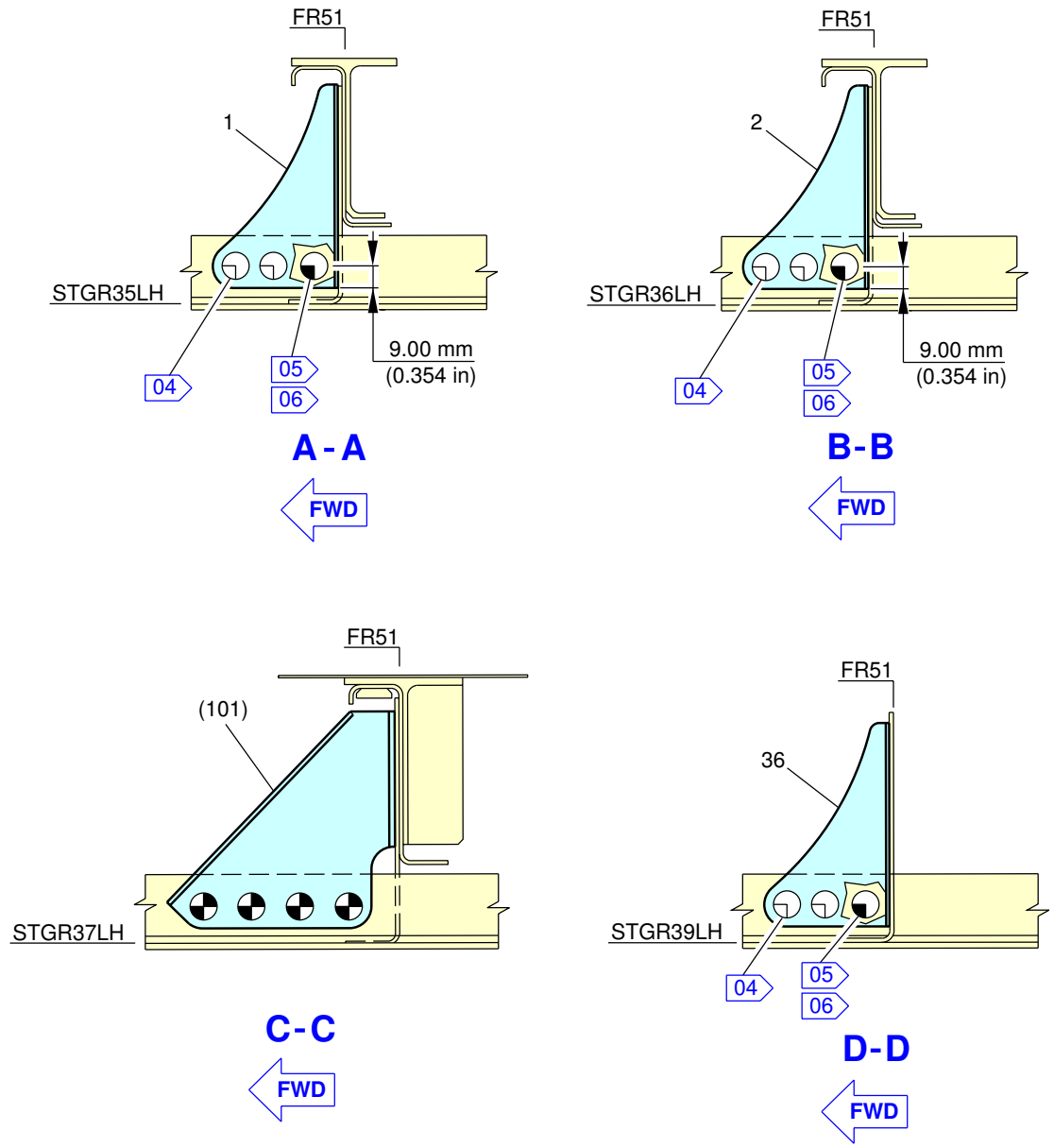
**CONF 008



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BBAH_03_01

Figure A-GBBAH - Sheet 03
Replacement of Webs and Angles at Frame 51

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**CONF 008

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	768	DAN5–6–8X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BBAH_04_01

Figure A-GBBAH - Sheet 04
Replacement of Webs and Angles at Frame 51

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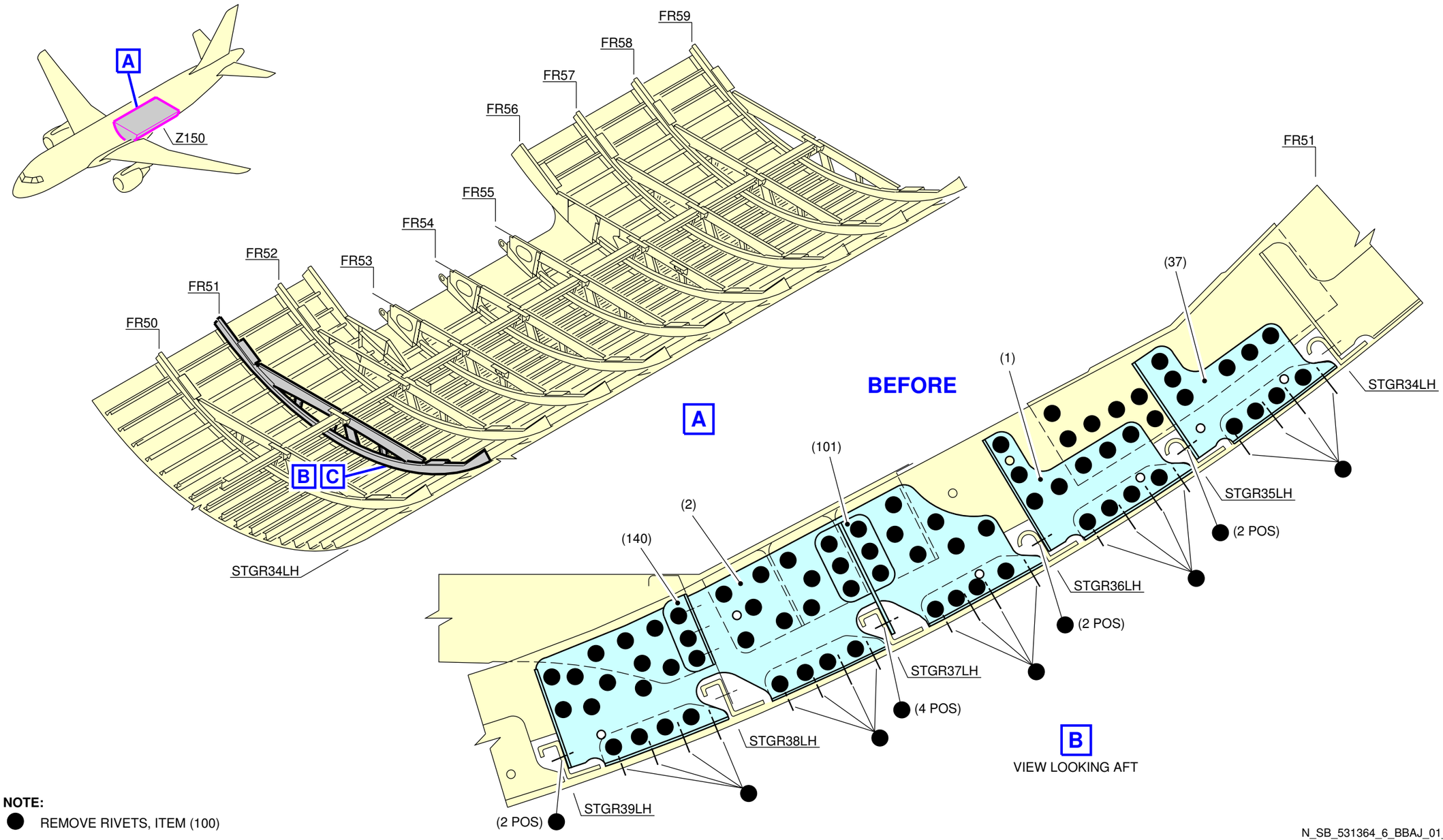
**CONF 009



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BBAJ_01_00

Figure A-GBBAJ - Sheet 01
Replacement of Webs and Angles at Frame 51

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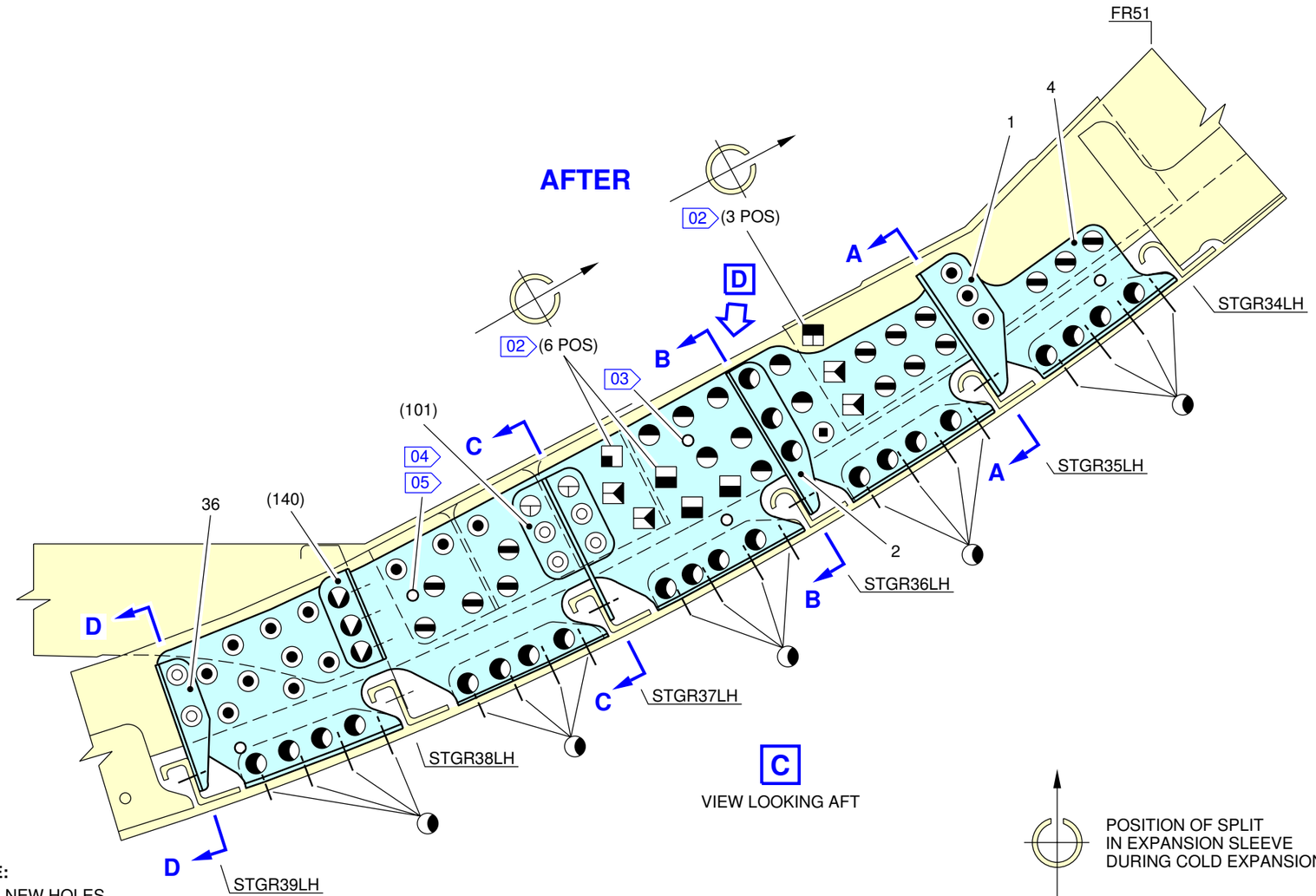
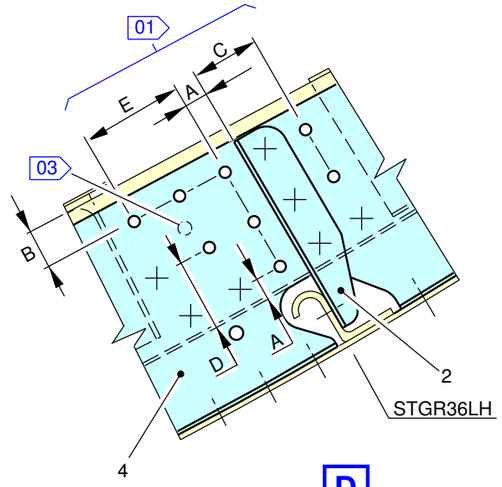
**CONF 009





POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BBAJ_02_01

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in).

05 VALID FOR MSN 4005 AND SUBSEQUENT.

EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

Figure A-GBBAJ - Sheet 02
Replacement of Webs and Angles at Frame 51

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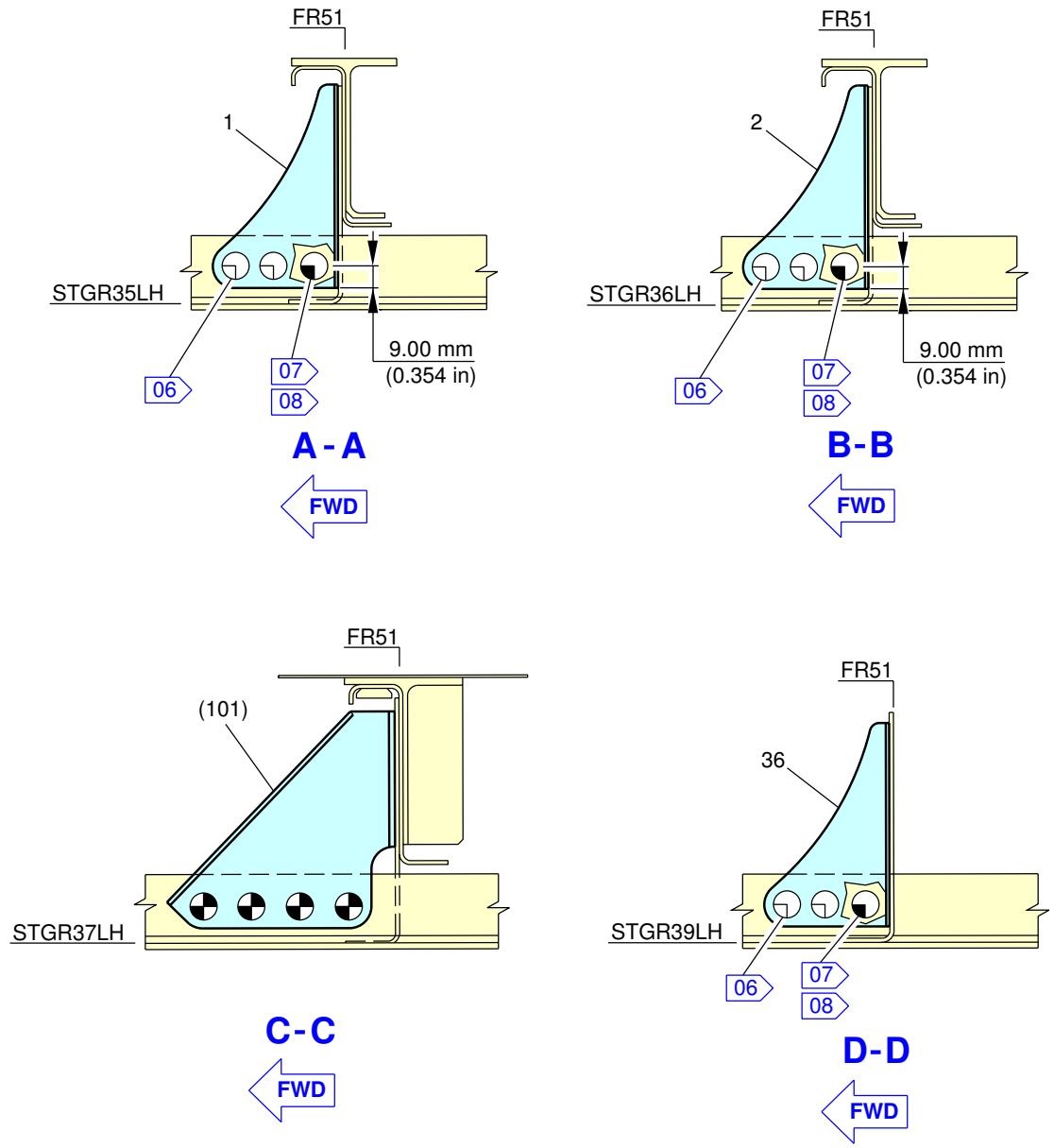
**CONF 009



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BBAJ_03_01

Figure A-GBBAJ - Sheet 03
Replacement of Webs and Angles at Frame 51

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**CONF 009

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	768	DAN5–6–8X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BBAJ_04_01

Figure A-GBBAJ - Sheet 04
Replacement of Webs and Angles at Frame 51

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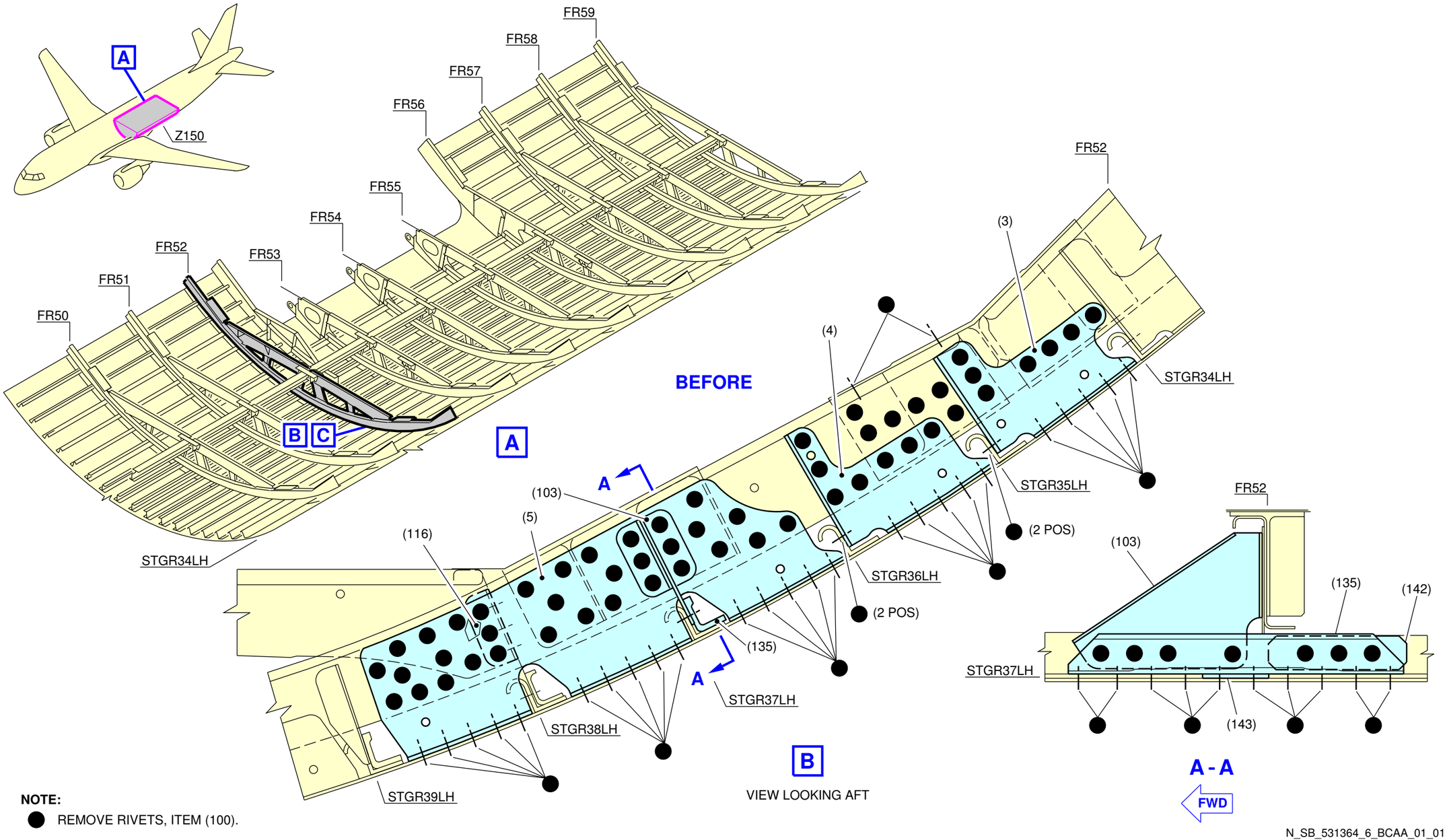
**CONF 001, 008



NOTE:

● REMOVE RIVETS, ITEM (100).

N_SB_531364_6_BCAA_01_01

Figure A-GBCAA - Sheet 01
Replacement of Webs and Angles at Frame 52

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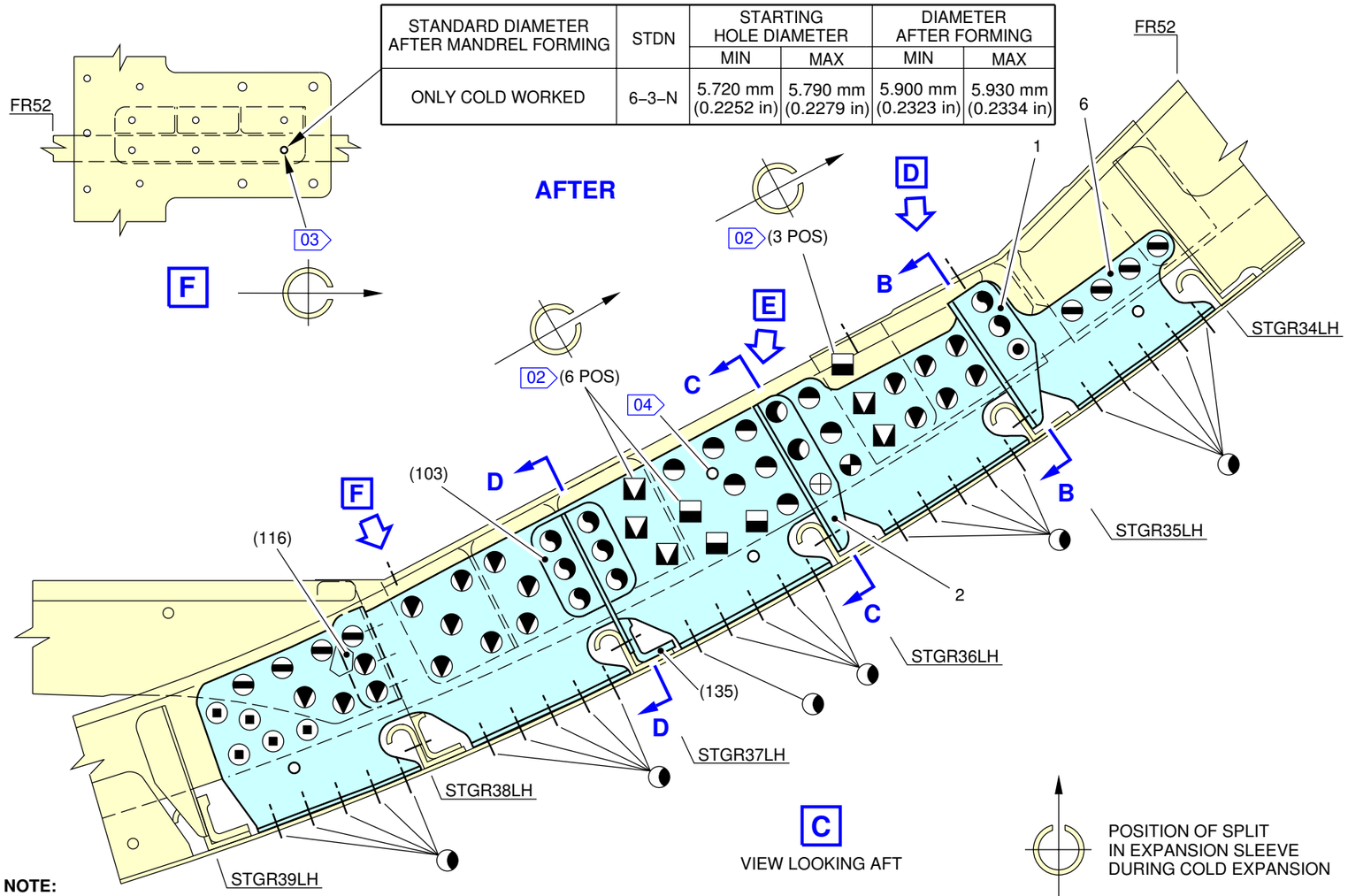
**CONF 001, 008

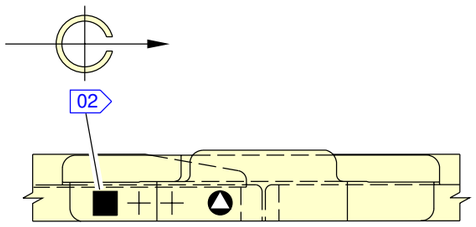
STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)

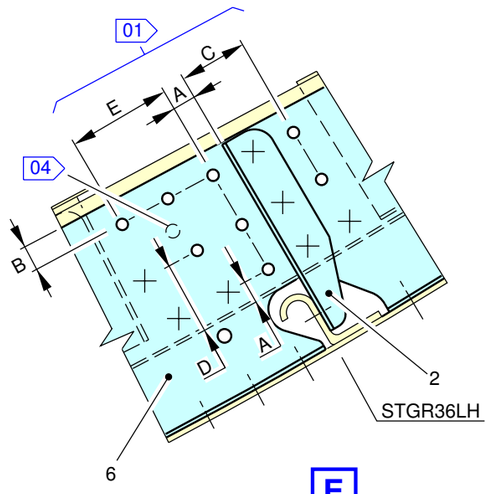


C

VIEW LOOKING AFT

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION





E

VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

NOTE:

┼ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

01 NEW HOLES.

02 ◥◒■ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

N_SB_531364_6_BCAA_02_01

Figure A-GBCAA - Sheet 02
Replacement of Webs and Angles at Frame 52

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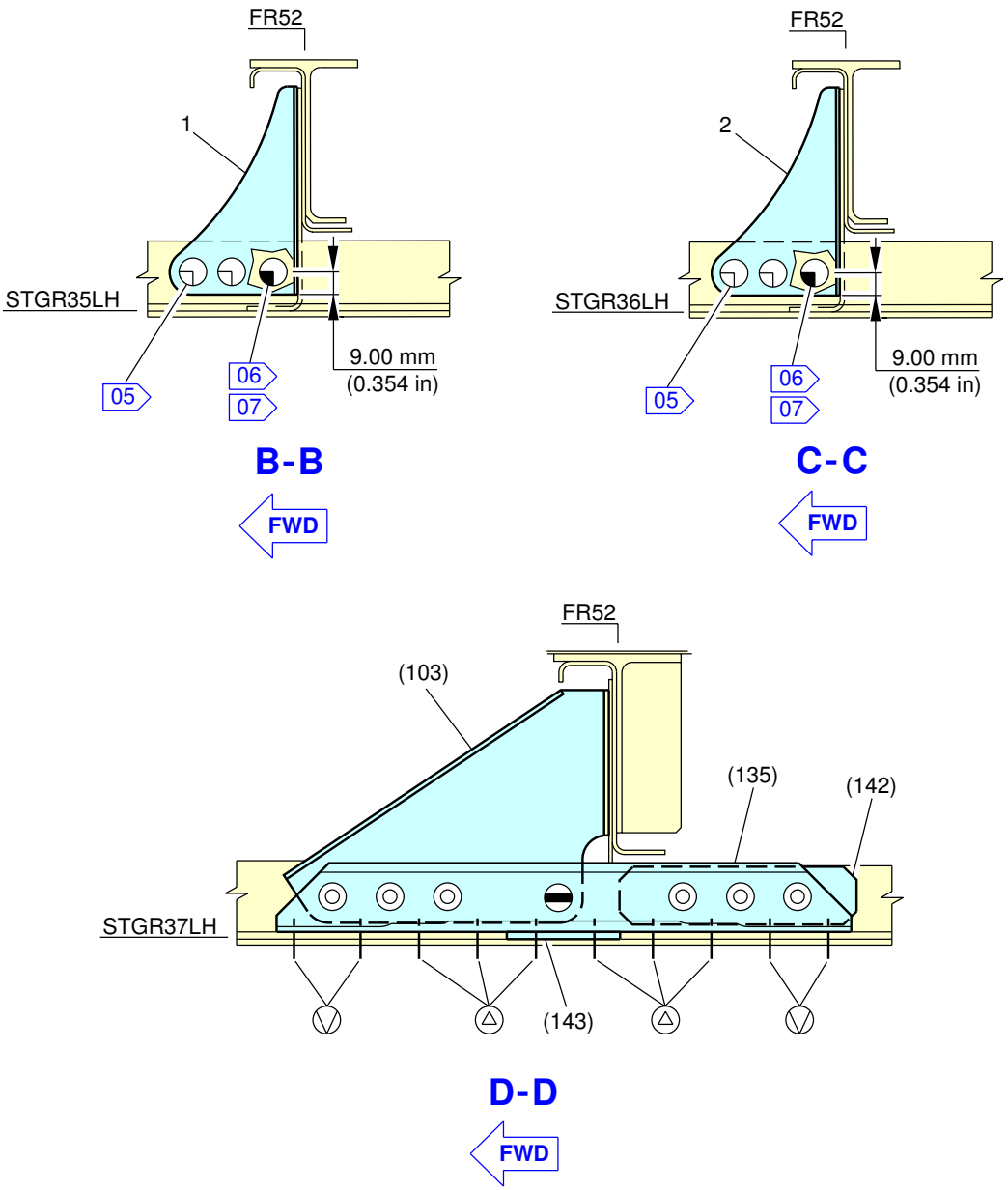
****CONF 001, 008**



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BCAA_03_01

Figure A-GBCAA - Sheet 03
Replacement of Webs and Angles at Frame 52

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**CONF 001, 008

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	865	DAN6–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	866	DAN6–6–6	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BCAA_04_01

Figure A-GBCAA - Sheet 04
Replacement of Webs and Angles at Frame 52

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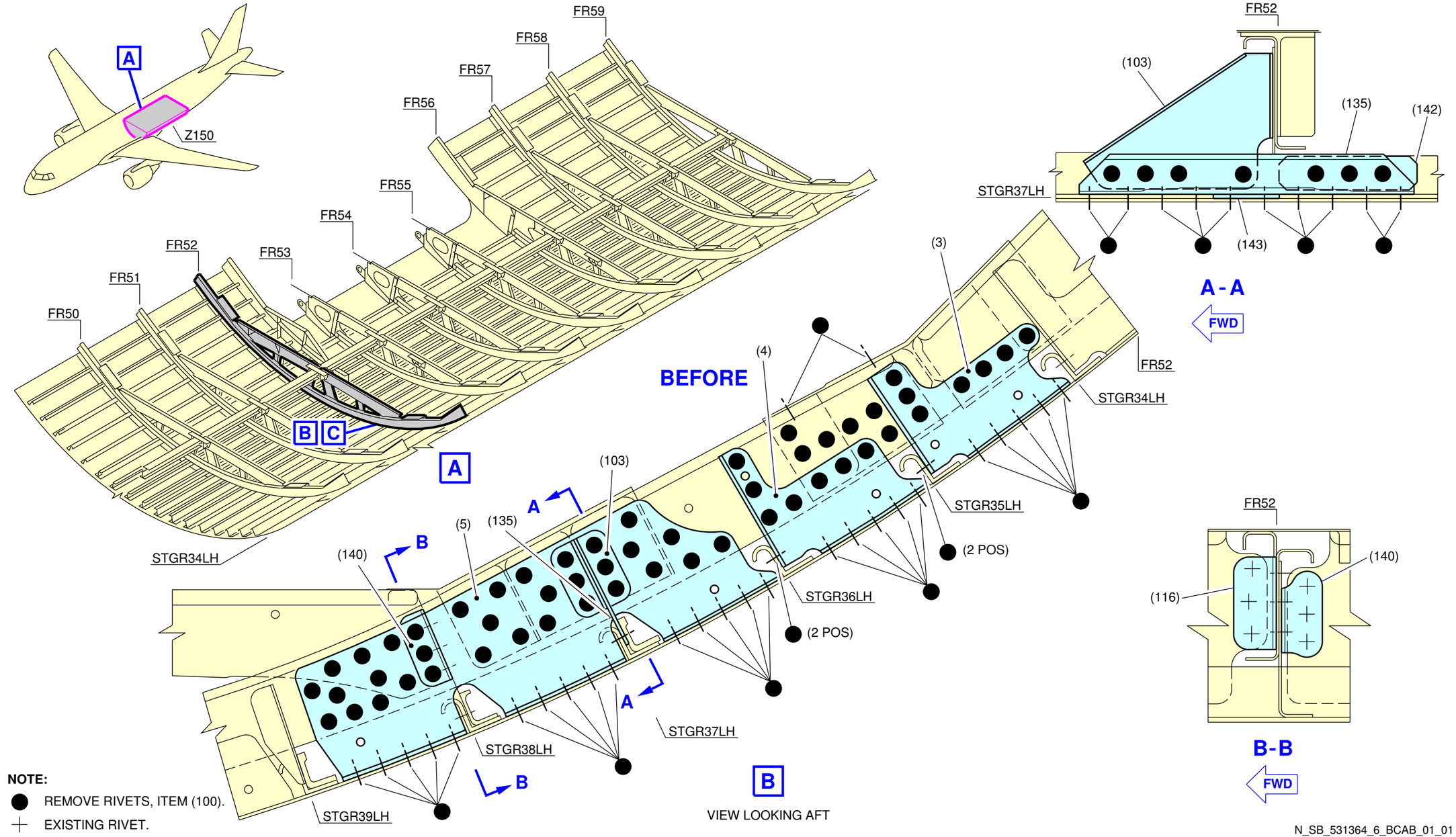
**CONF 002



NOTE:

● REMOVE RIVETS, ITEM (100).

┼ EXISTING RIVET.

Figure A-GBCAB - Sheet 01
Replacement of Webs and Angles at Frame 52

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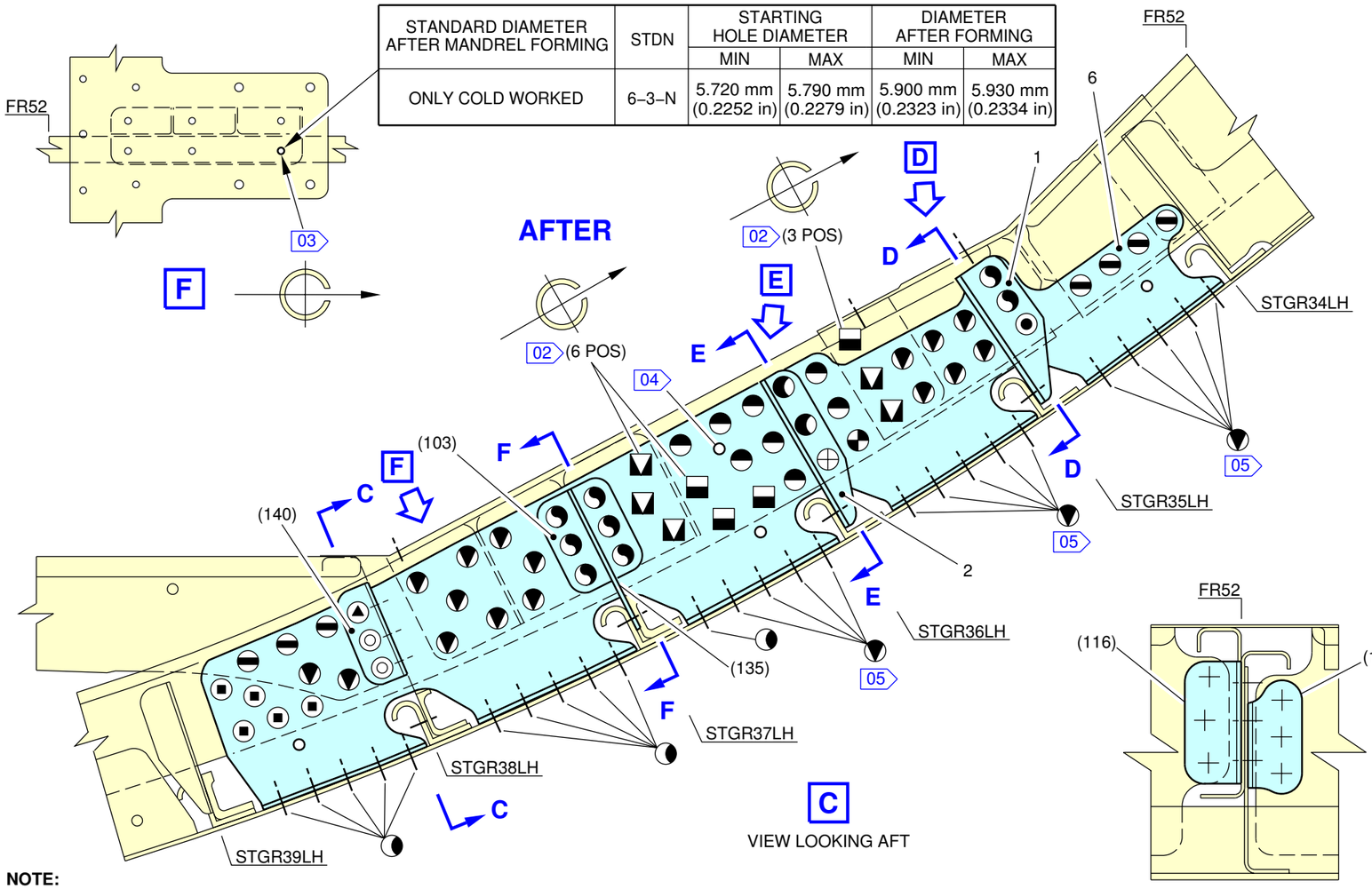
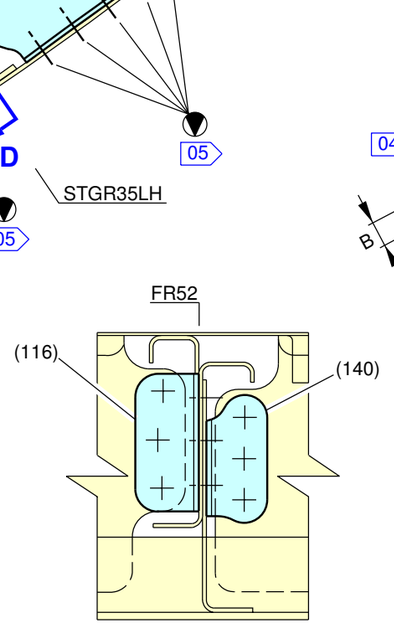
**CONF 002

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



C

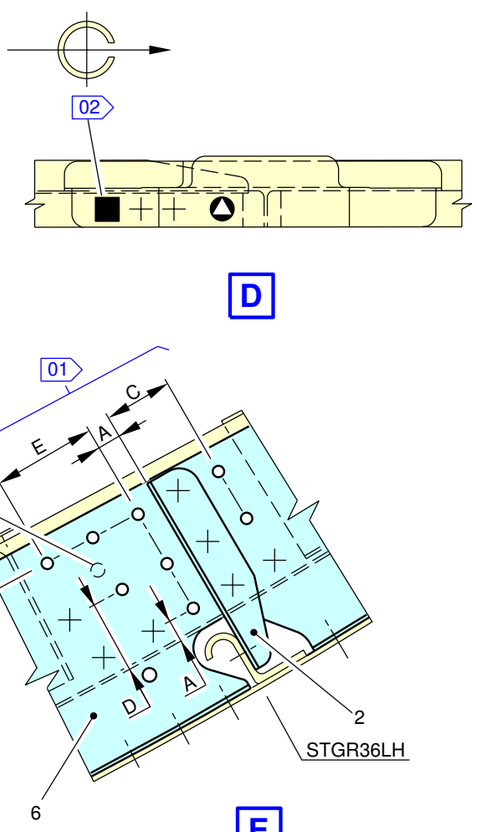
VIEW LOOKING AFT



C-C

FWD

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION



E

VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

05 RIVETED WITH BELLY FAIRING ANGLE.

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BCAB_02_01

Figure A-GBCAB - Sheet 02
Replacement of Webs and Angles at Frame 52

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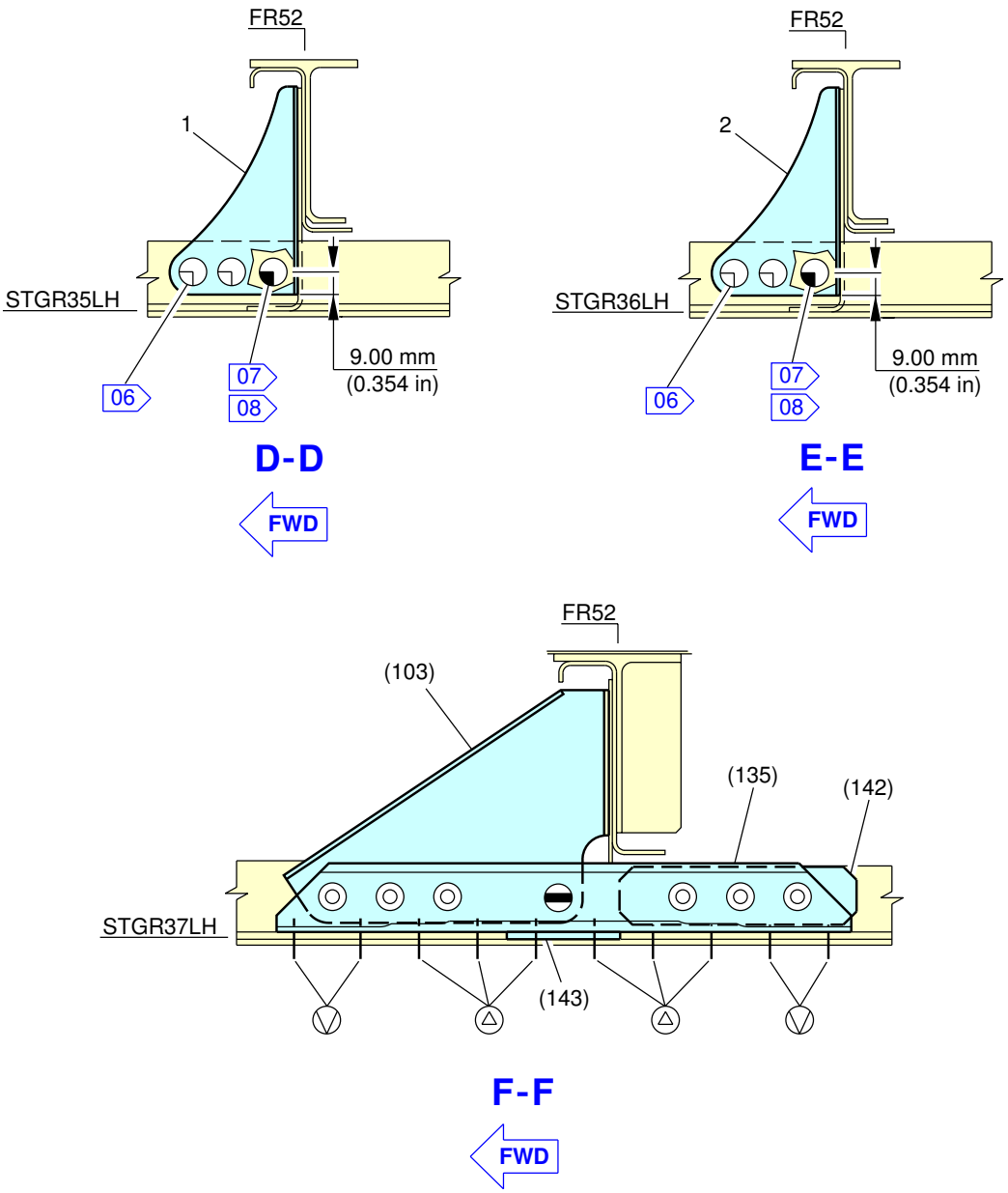
**CONF 002



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BCAB_03_01

Figure A-GBCAB - Sheet 03
Replacement of Webs and Angles at Frame 52

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**CONF 002

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	786	DAN5–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	865	DAN6–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	866	DAN6–6–6	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BCAB_04_01

Figure A-GBCAB - Sheet 04
Replacement of Webs and Angles at Frame 52

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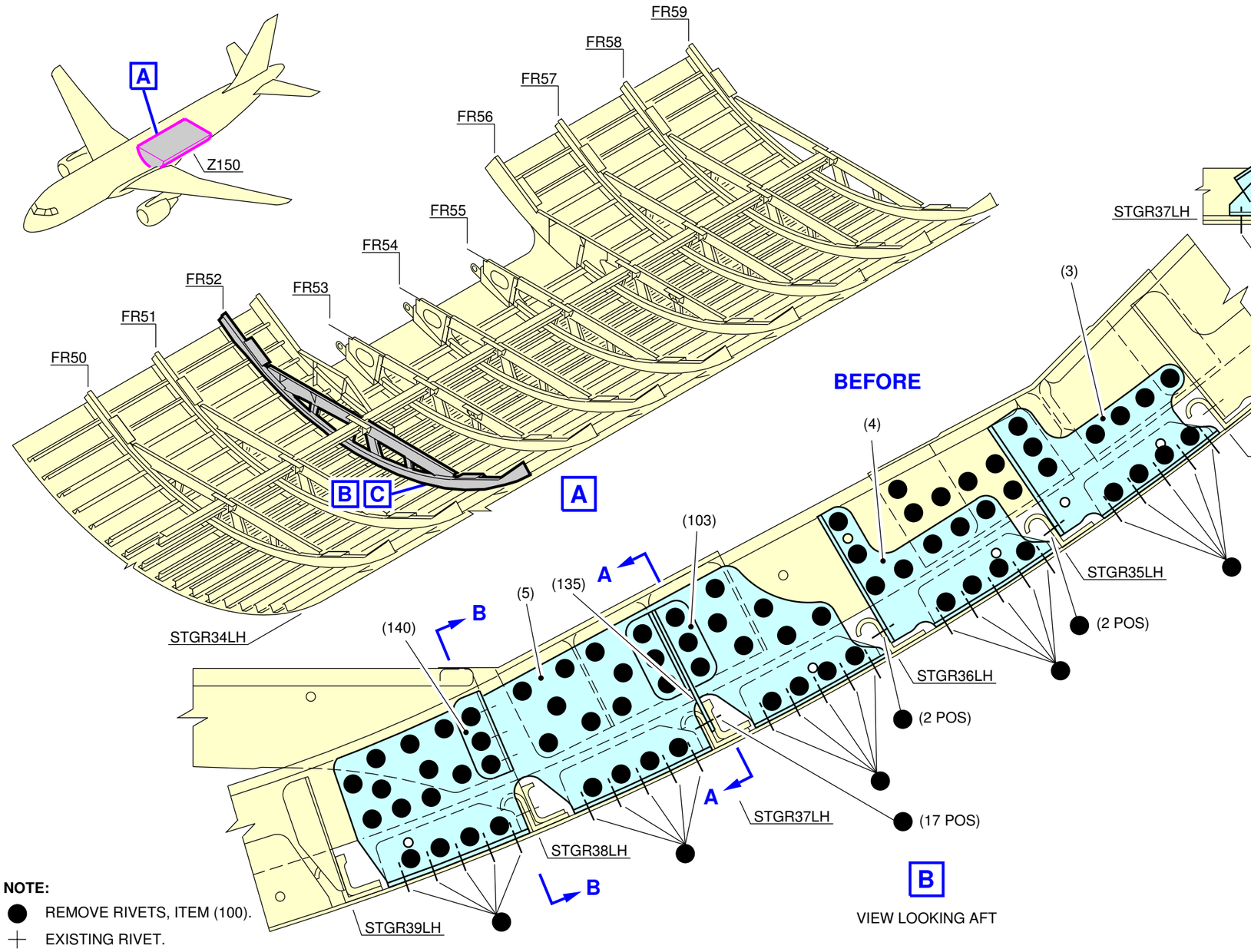
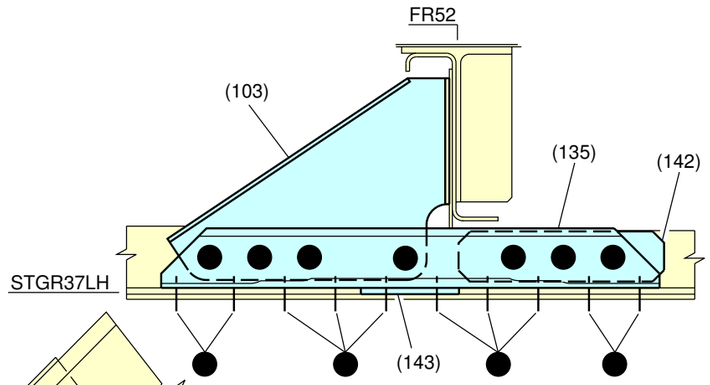
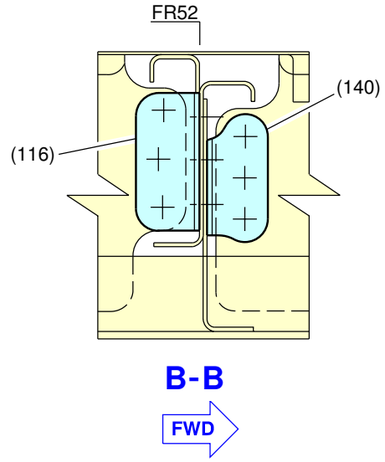
**CONF 003







NOTE:

- ● REMOVE RIVETS, ITEM (100).
- ┼ EXISTING RIVET.

N_SB_531364_6_BCAC_01_01

Figure A-GBCAC - Sheet 01
Replacement of Webs and Angles at Frame 52

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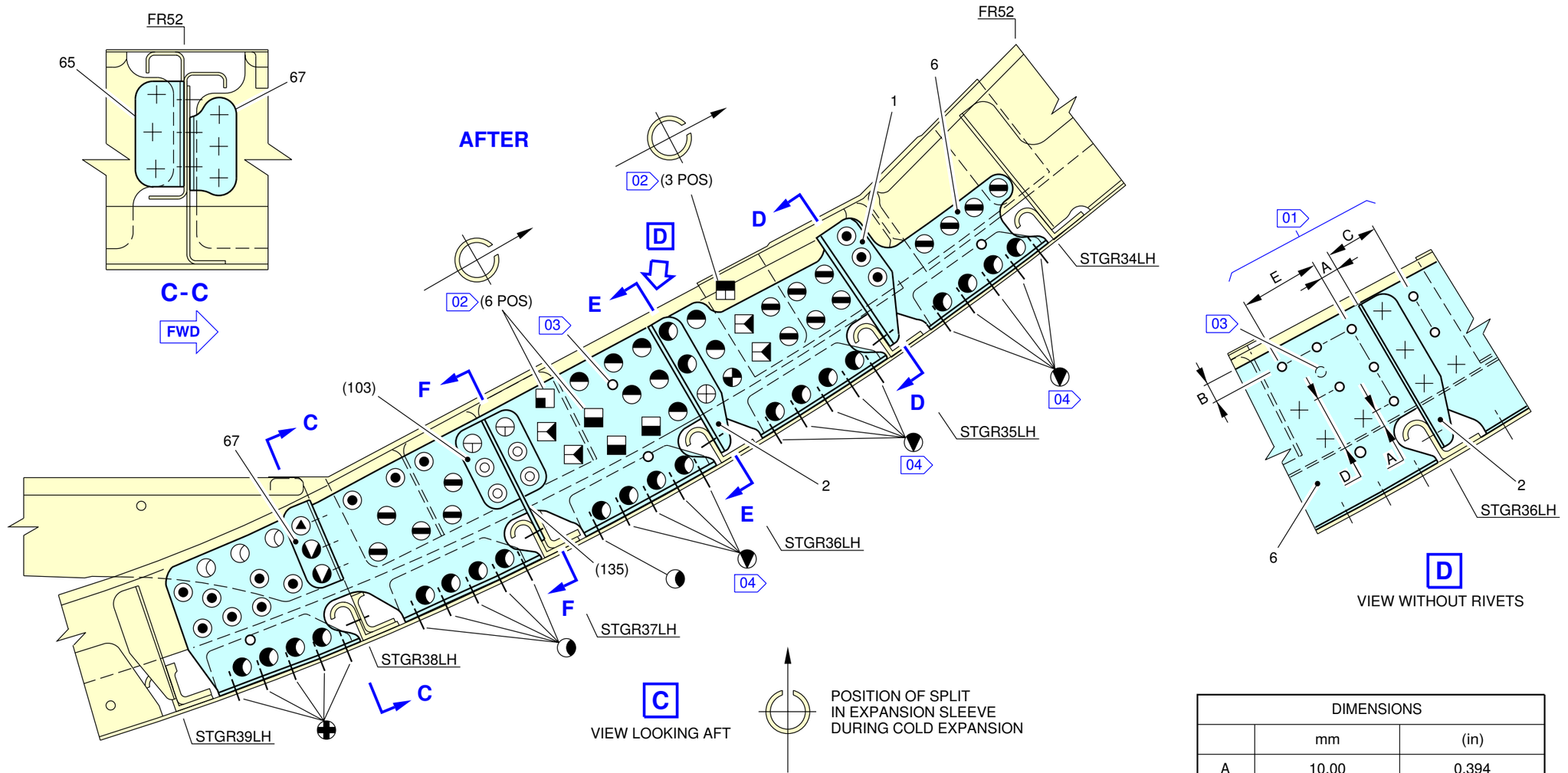
**CONF 003



DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

04 RIVETED WITH BELLY FAIRING ANGLE.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

Figure A-GBCAC - Sheet 02
Replacement of Webs and Angles at Frame 52

N_SB_531364_6_BCAC_02_01

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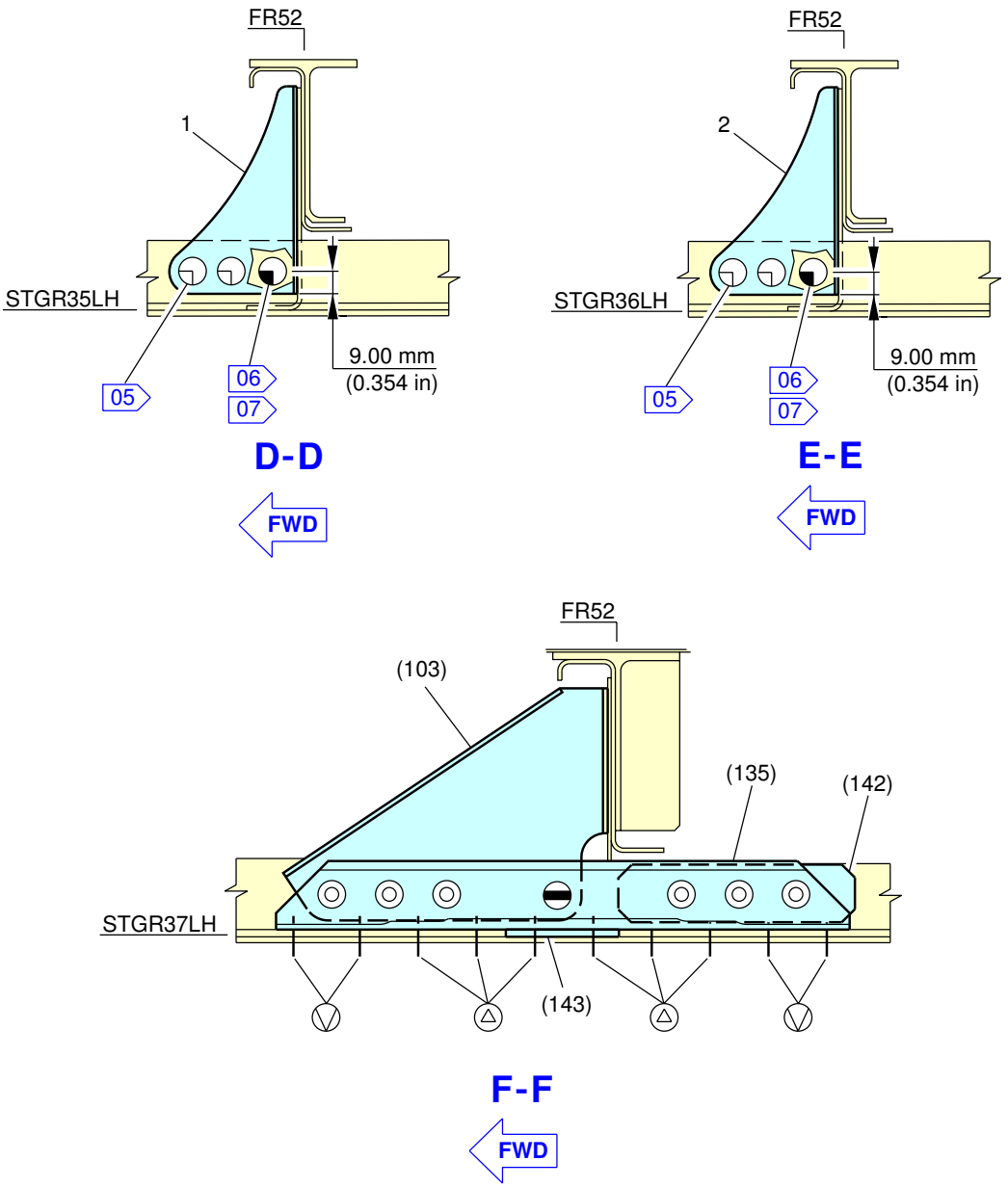
****CONF 003**



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BCAC_03_01

Figure A-GBCAC - Sheet 03
Replacement of Webs and Angles at Frame 52

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**CONF 003

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	768	DAN5–6–8X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	786	DAN5–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	865	DAN6–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	866	DAN6–6–6	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	873	DAN6–6–3X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BCAC_04_01

Figure A-GBCAC - Sheet 04
Replacement of Webs and Angles at Frame 52

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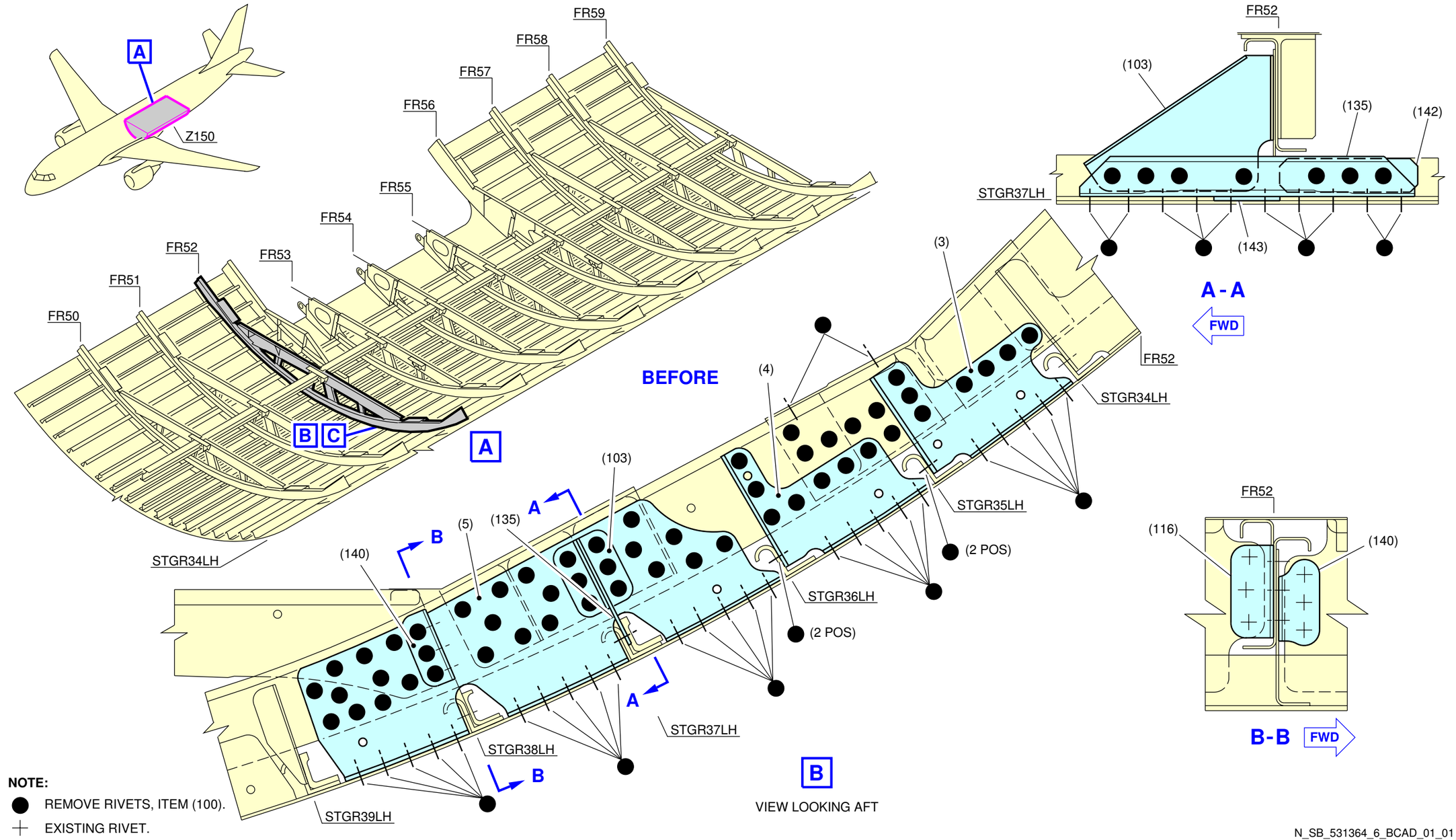
**CONF 004



NOTE:

● REMOVE RIVETS, ITEM (100).

┼ EXISTING RIVET.

Figure A-GBCAD - Sheet 01
Replacement of Webs and Angles at Frame 52

N_SB_531364_6_BCAD_01_01

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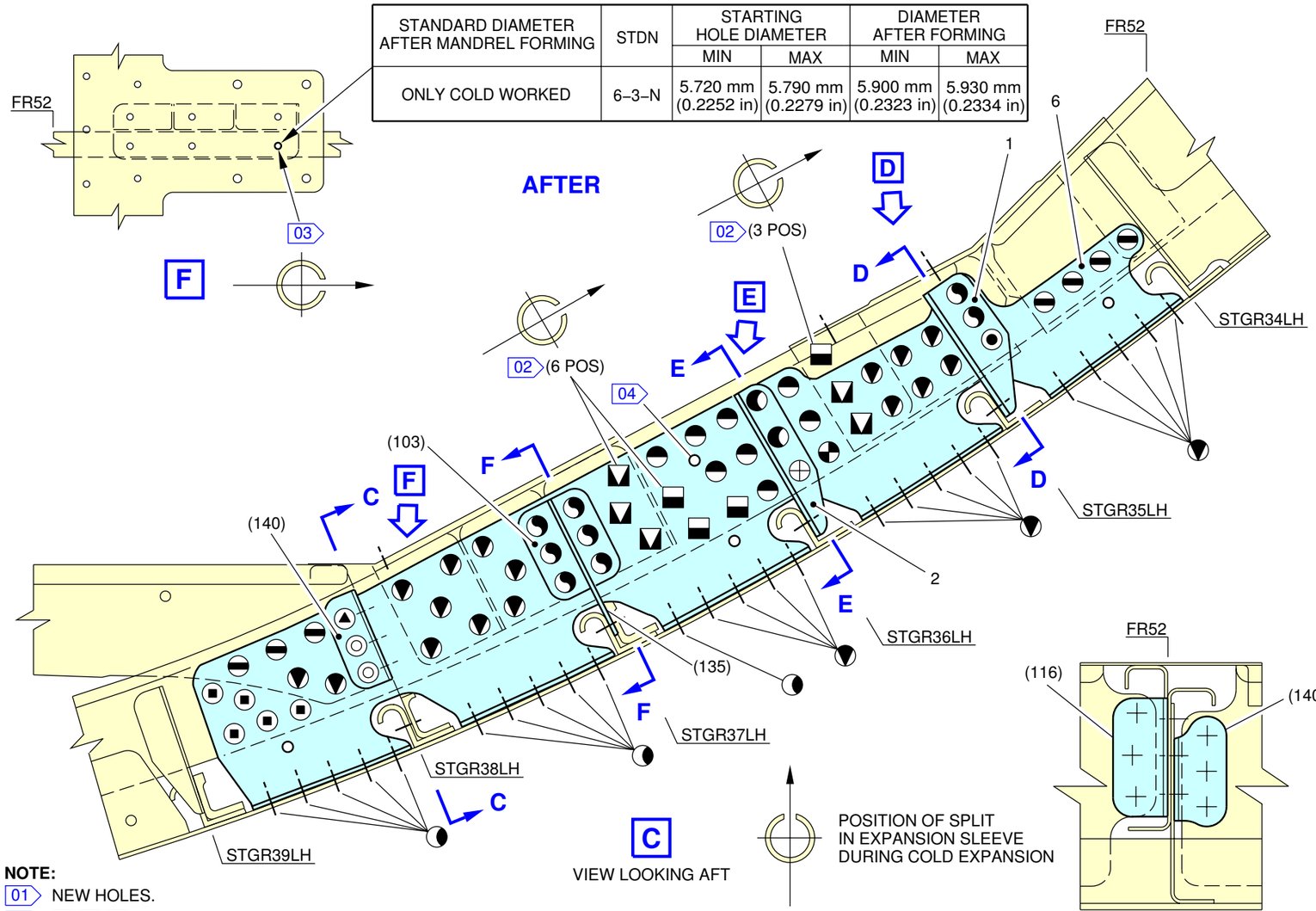
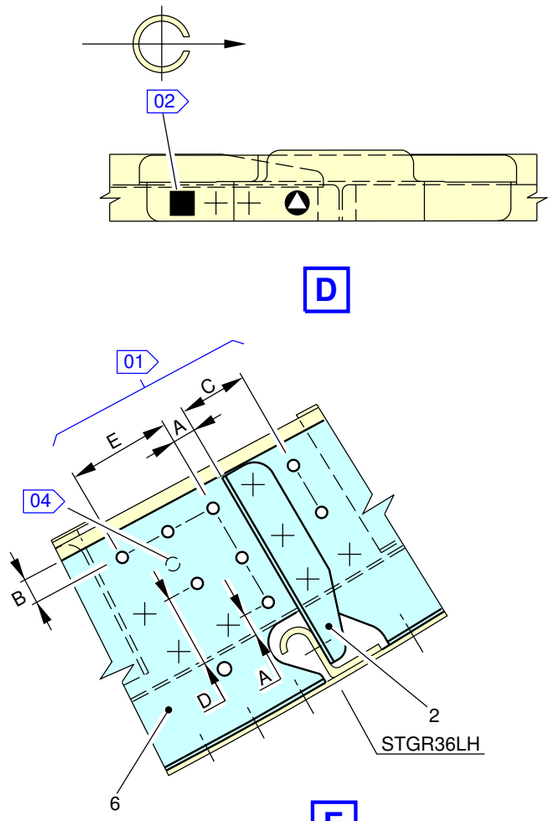
**CONF 004

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)





DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BCAD_02_01

Figure A-GBCAD - Sheet 02
Replacement of Webs and Angles at Frame 52

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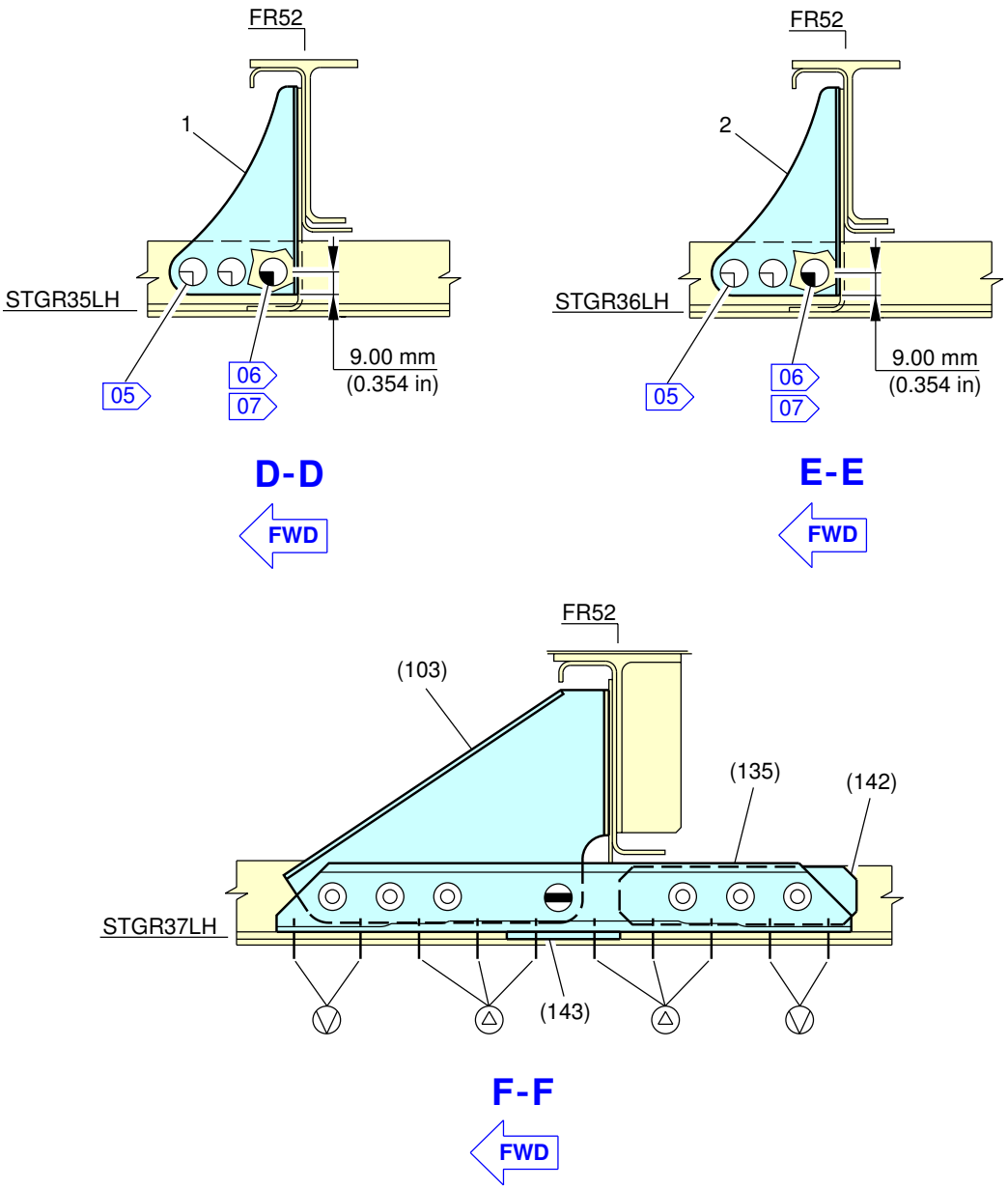
****CONF 004**



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BCAD_03_01

Figure A-GBCAD - Sheet 03
Replacement of Webs and Angles at Frame 52

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**CONF 004

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
◒	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
▽	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
■	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
◔	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◑	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◓	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◵	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◉	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◐	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◒	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◔	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
◒	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
◉	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
◎	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
▲	786	DAN5–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
▲	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
▽	865	DAN6–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
△	866	DAN6–6–6	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
◒	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
⊕	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BCAD_04_01

Figure A-GBCAD - Sheet 04
Replacement of Webs and Angles at Frame 52

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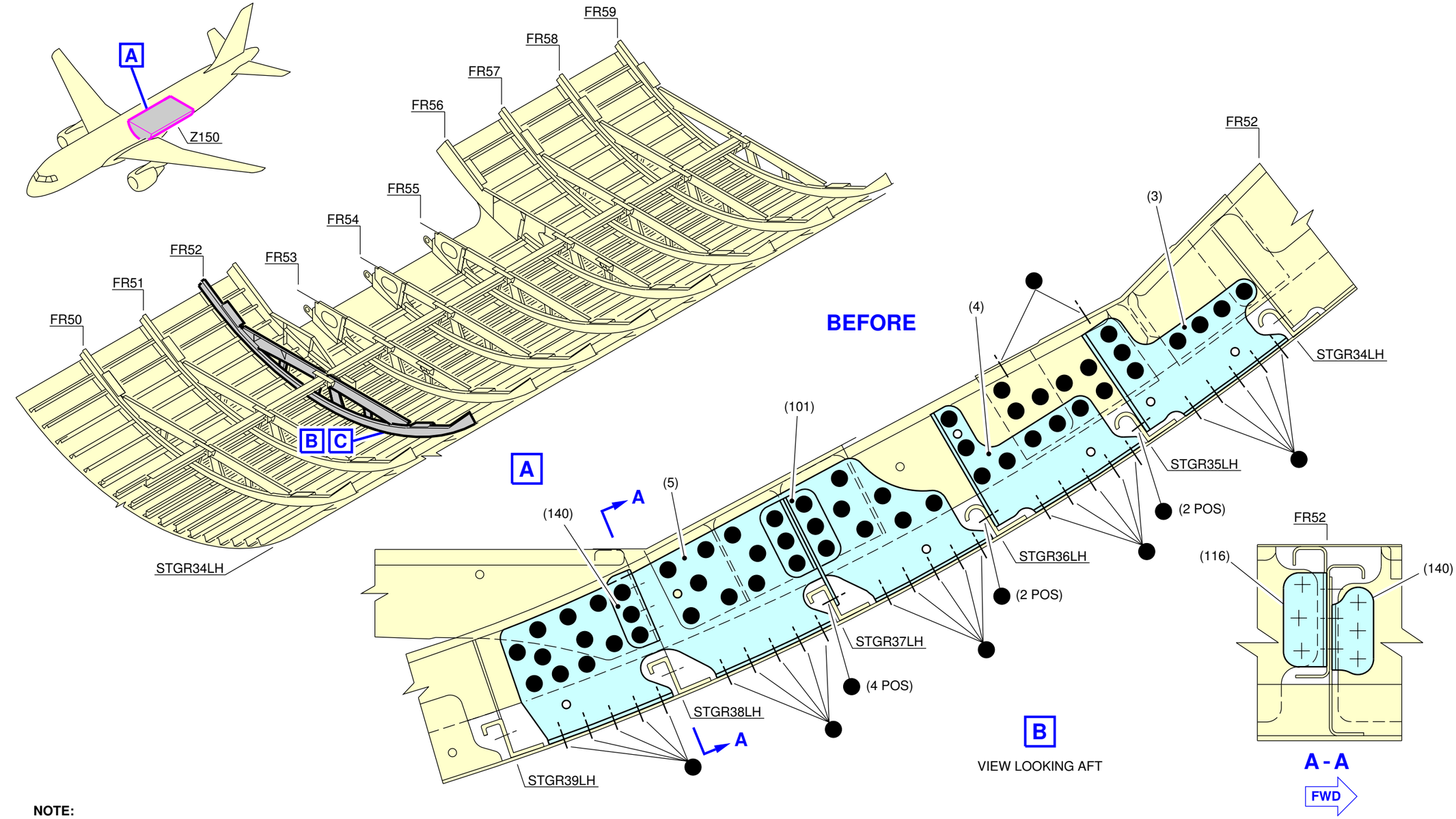
**CONF 005



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BCAE_01_00

Figure A-GBCAE - Sheet 01
Replacement of Webs and Angles at Frame 52

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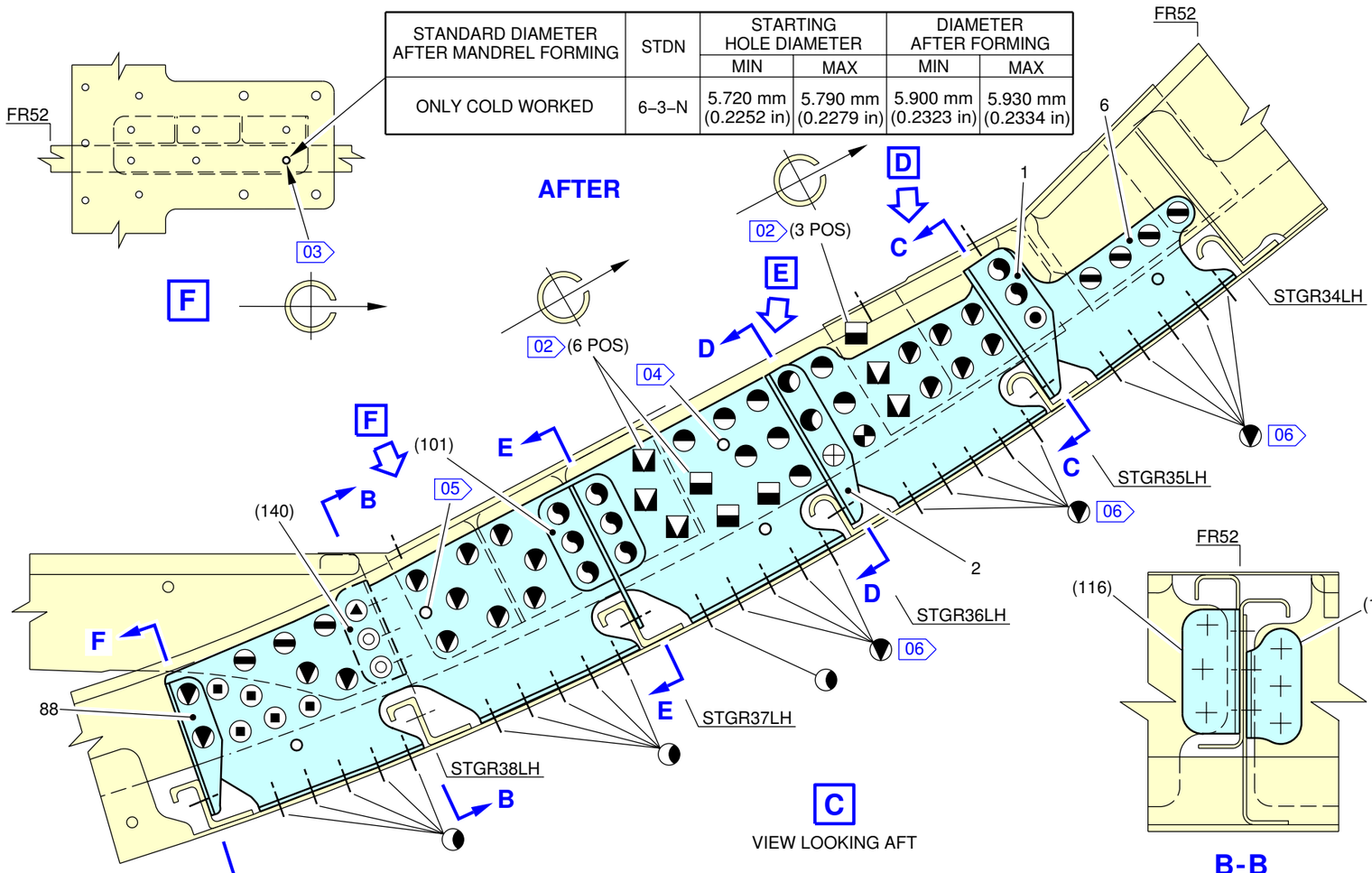
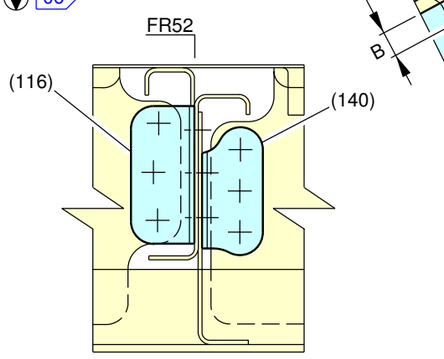
**CONF 005

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)

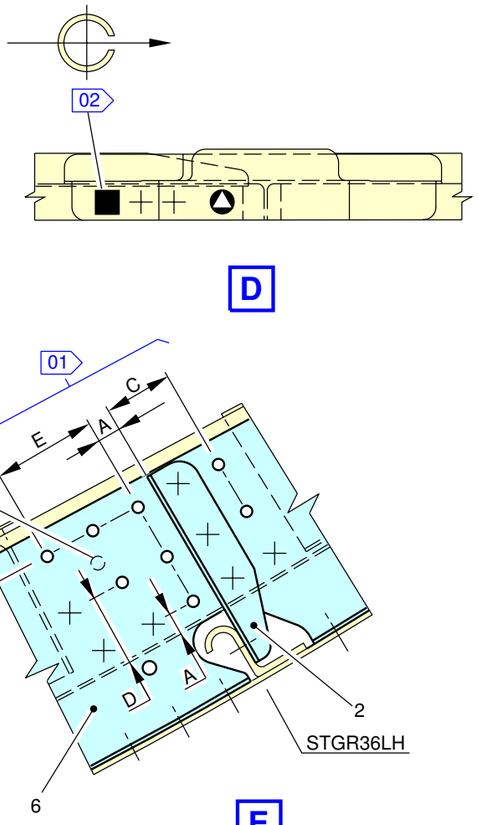


C
VIEW LOOKING AFT



B-B

POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION



E
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

05 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in). FOR MSN 3999 AND SUBSEQUENT.

06 RIVETED WITH BELLY FAIRING ANGLE.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BCAE_02_01

Figure A-GBCAE - Sheet 02
Replacement of Webs and Angles at Frame 52

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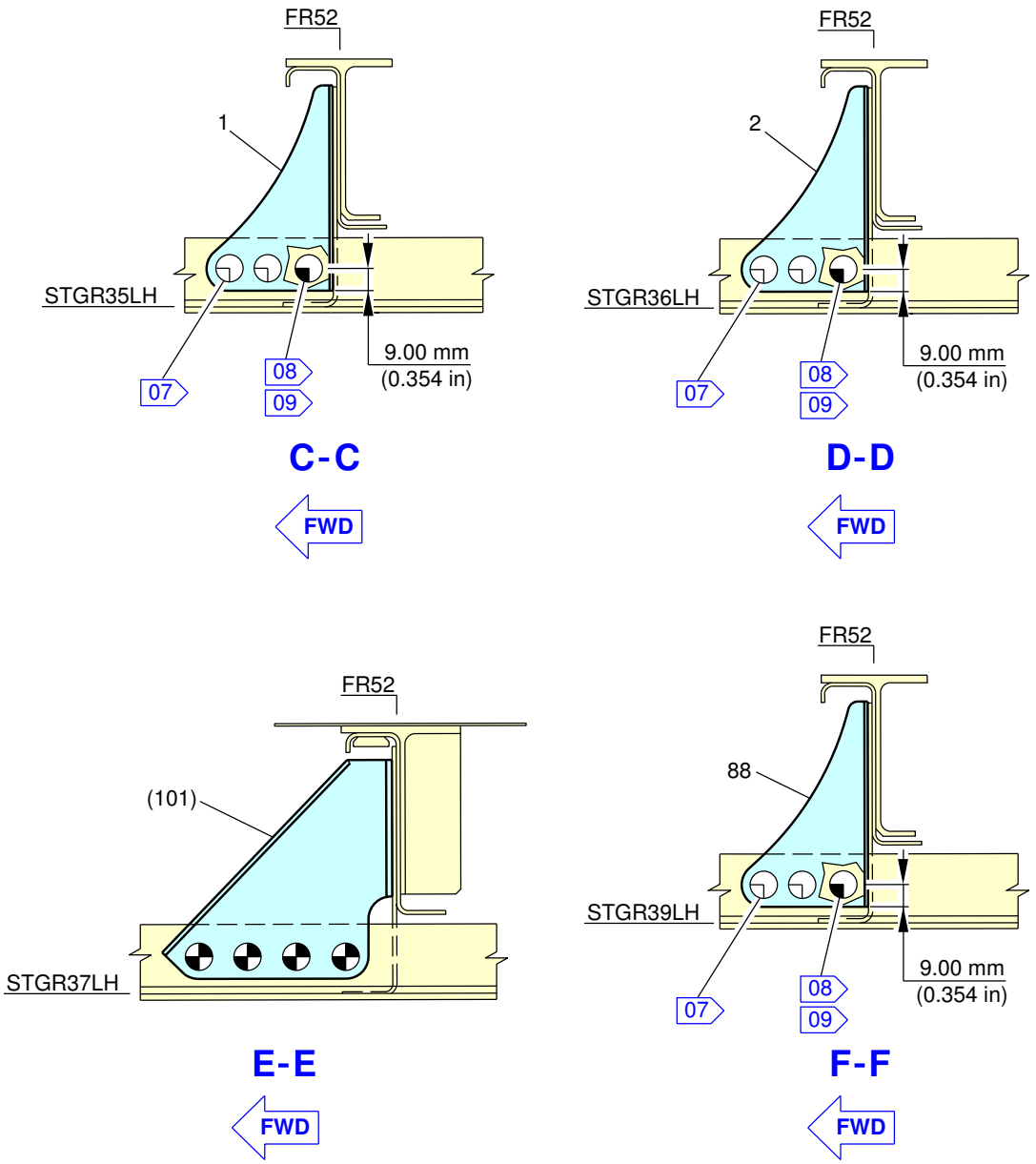
****CONF 005**



NOTE:

07 EXISTING PILOT HOLES.

08 COUNTERSINK EXISTING HOLE IN THE STRINGER.

09 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BCAE_03_01

Figure A-GBCAE - Sheet 03
Replacement of Webs and Angles at Frame 52

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**CONF 005

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	786	DAN5–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BCAE_04_02

Figure A-GBCAE - Sheet 04
Replacement of Webs and Angles at Frame 52

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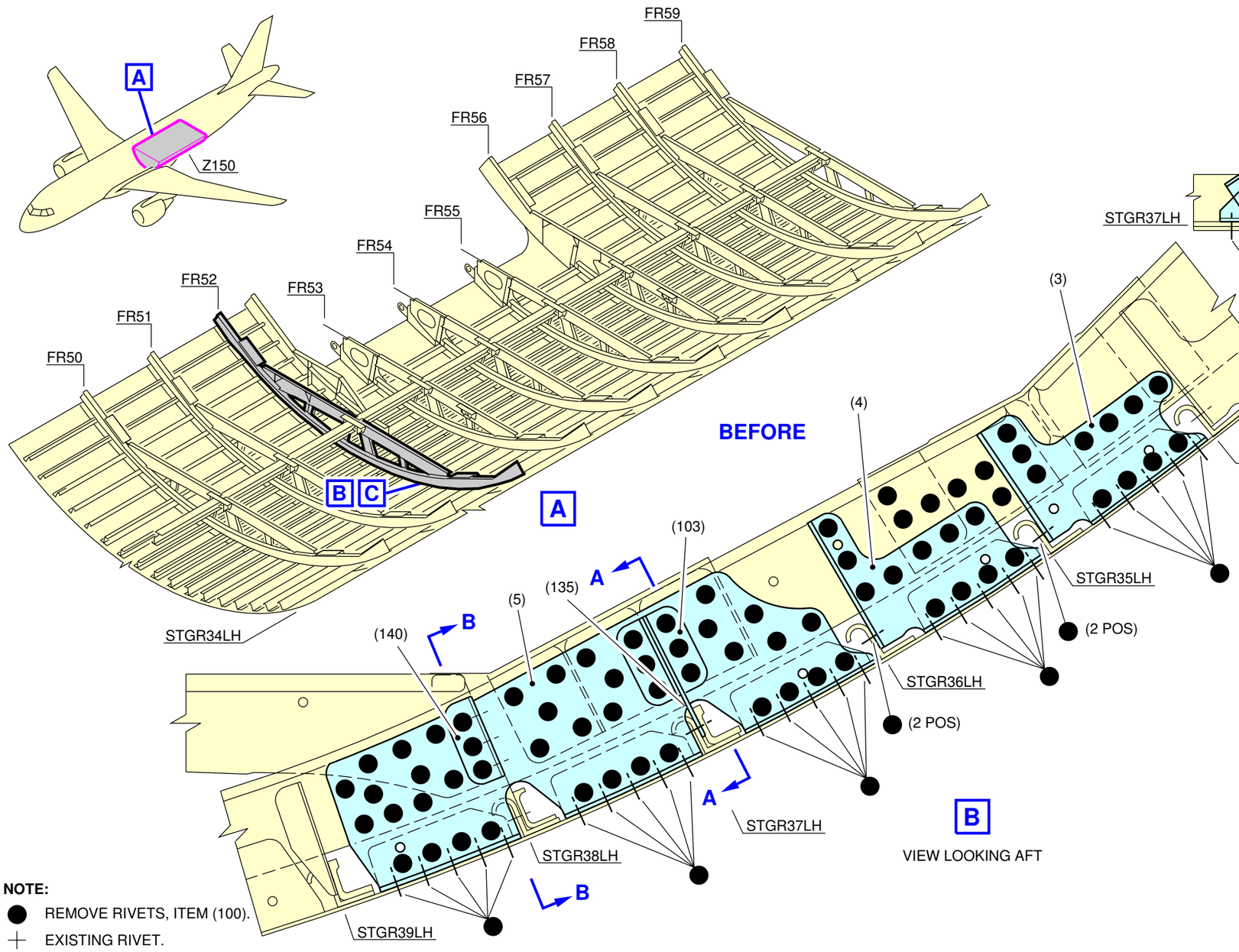
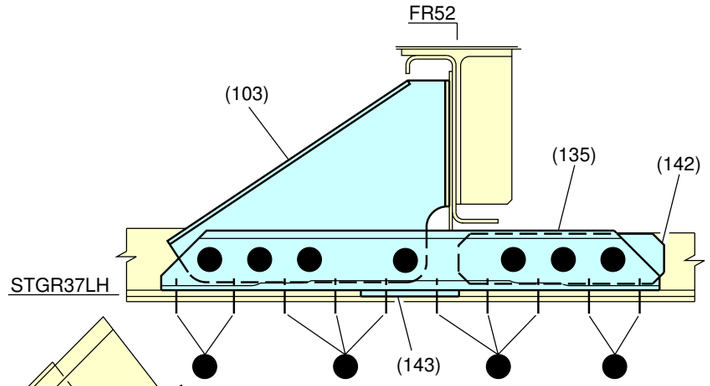
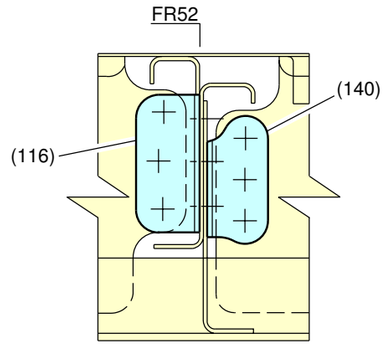
**CONF 006







NOTE:

- REMOVE RIVETS, ITEM (100).
- EXISTING RIVET.

N_SB_531364_6_BCAF_01_01

Figure A-GBCAF - Sheet 01
Replacement of Webs and Angles at Frame 52

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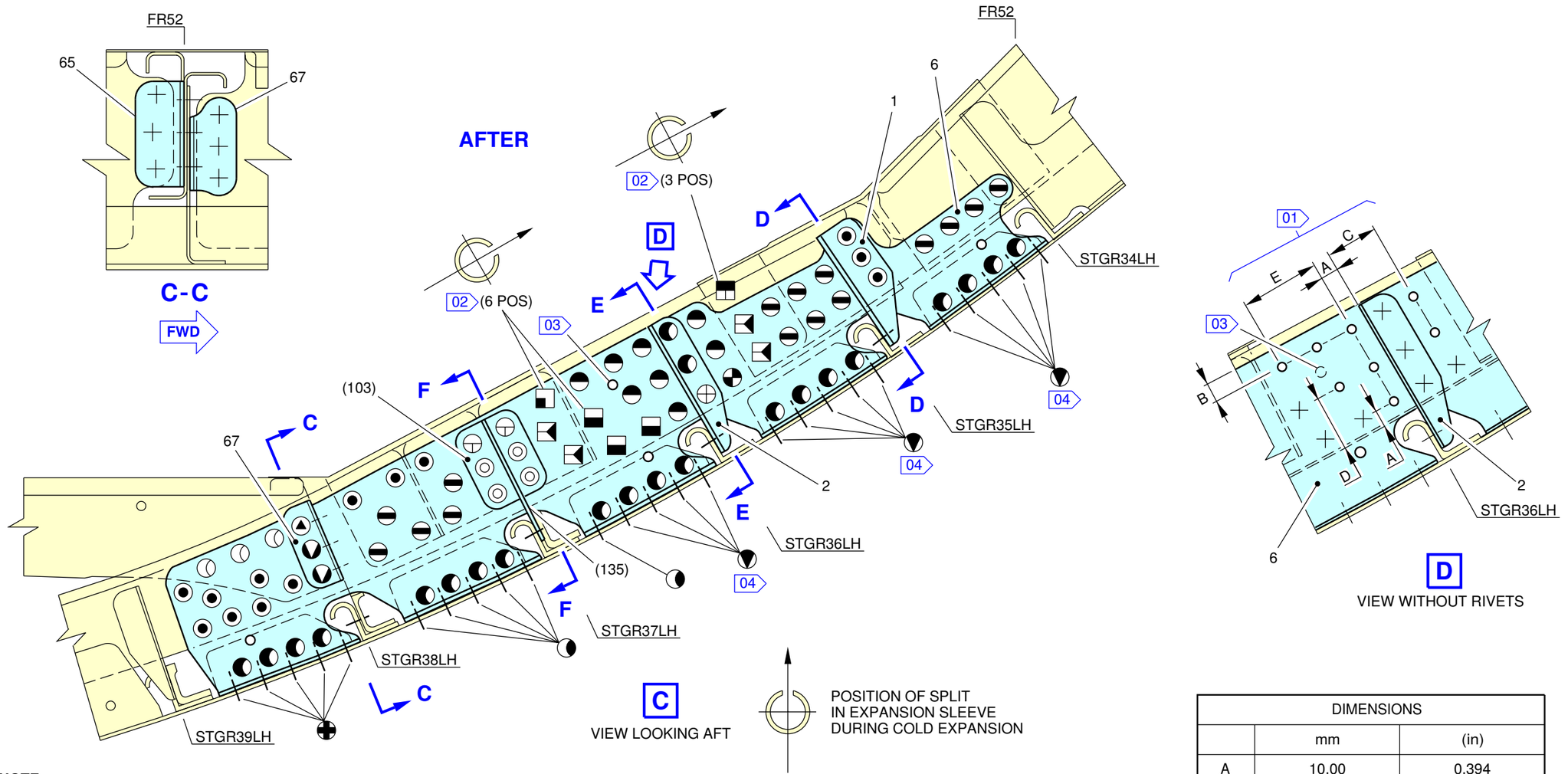
**CONF 006



NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

04 RIVETED WITH BELLY FAIRING ANGLE.

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BCAF_02_01

Figure A-GBCAF - Sheet 02
Replacement of Webs and Angles at Frame 52

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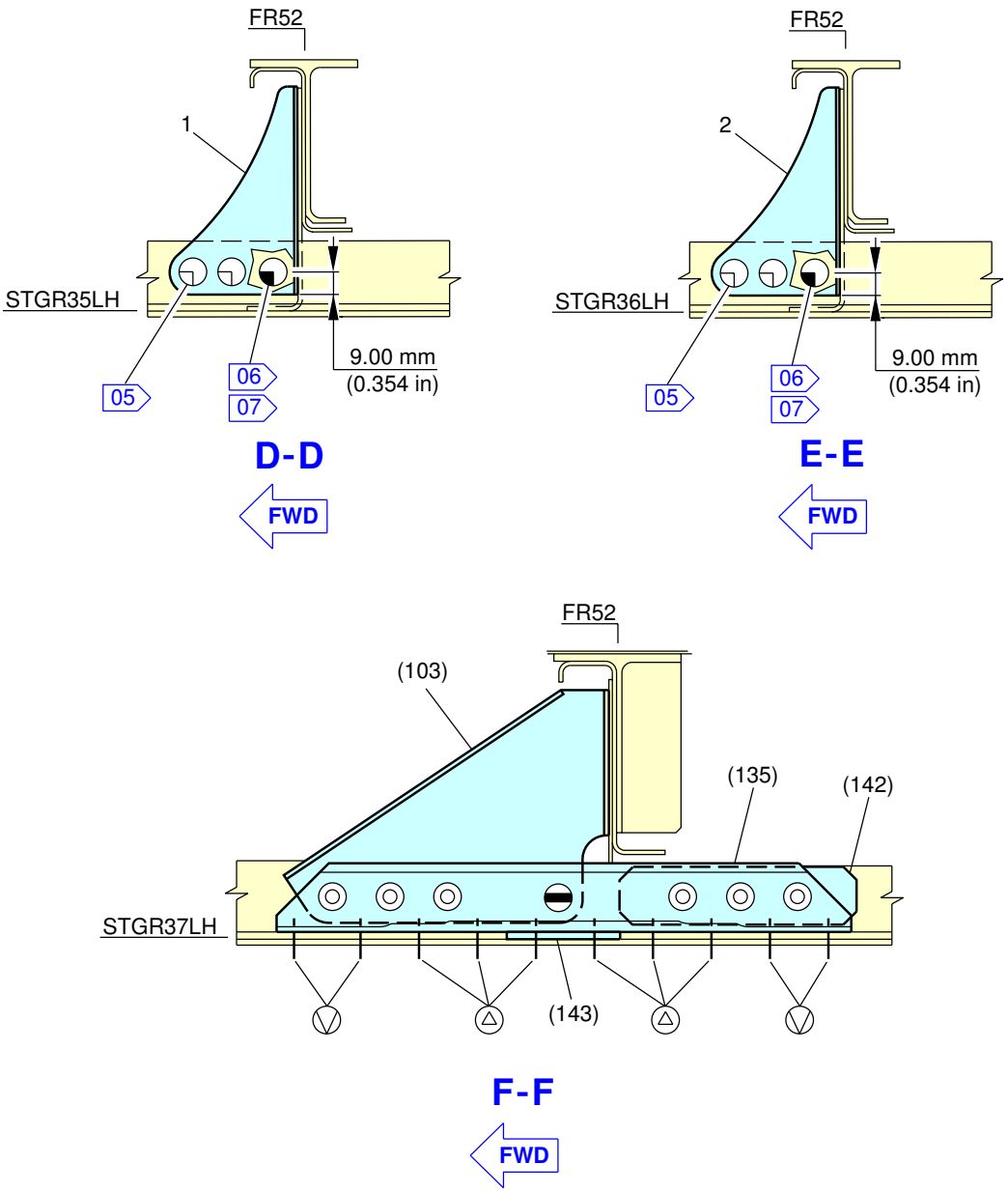
****CONF 006**



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BCAF_03_01

Figure A-GBCAF - Sheet 03
Replacement of Webs and Angles at Frame 52

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**CONF 006

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	768	DAN5–6–8X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	786	DAN5–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	865	DAN6–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	866	DAN6–6–6	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	873	DAN6–6–3X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BCAF_04_01

Figure A-GBCAF - Sheet 04
Replacement of Webs and Angles at Frame 52

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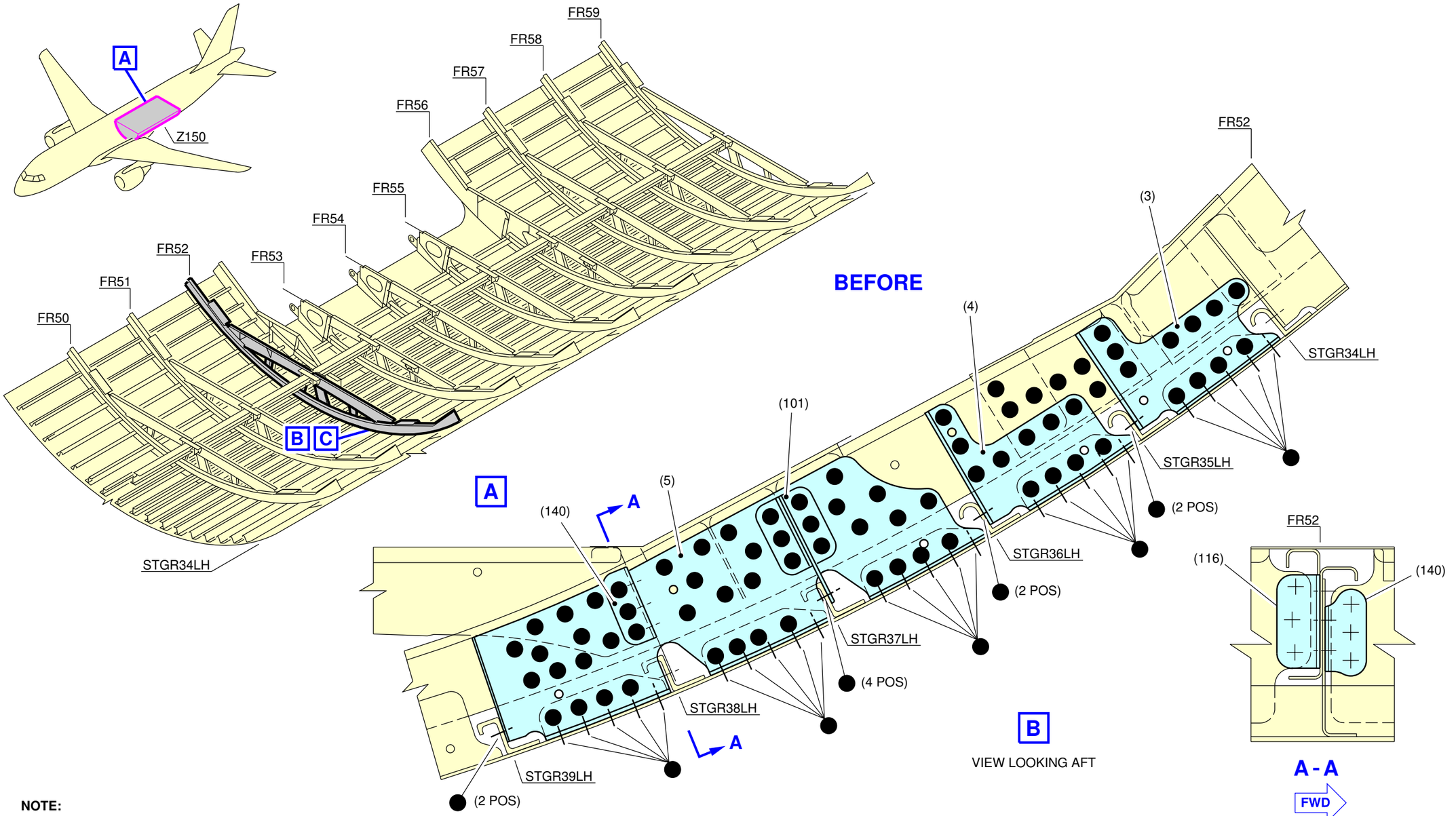
**CONF 007



N_SB_531364_6_BCAG_01_00

NOTE:

● REMOVE RIVETS, ITEM (100)

Figure A-GBCAG - Sheet 01
Replacement of Webs and Angles at Frame 52

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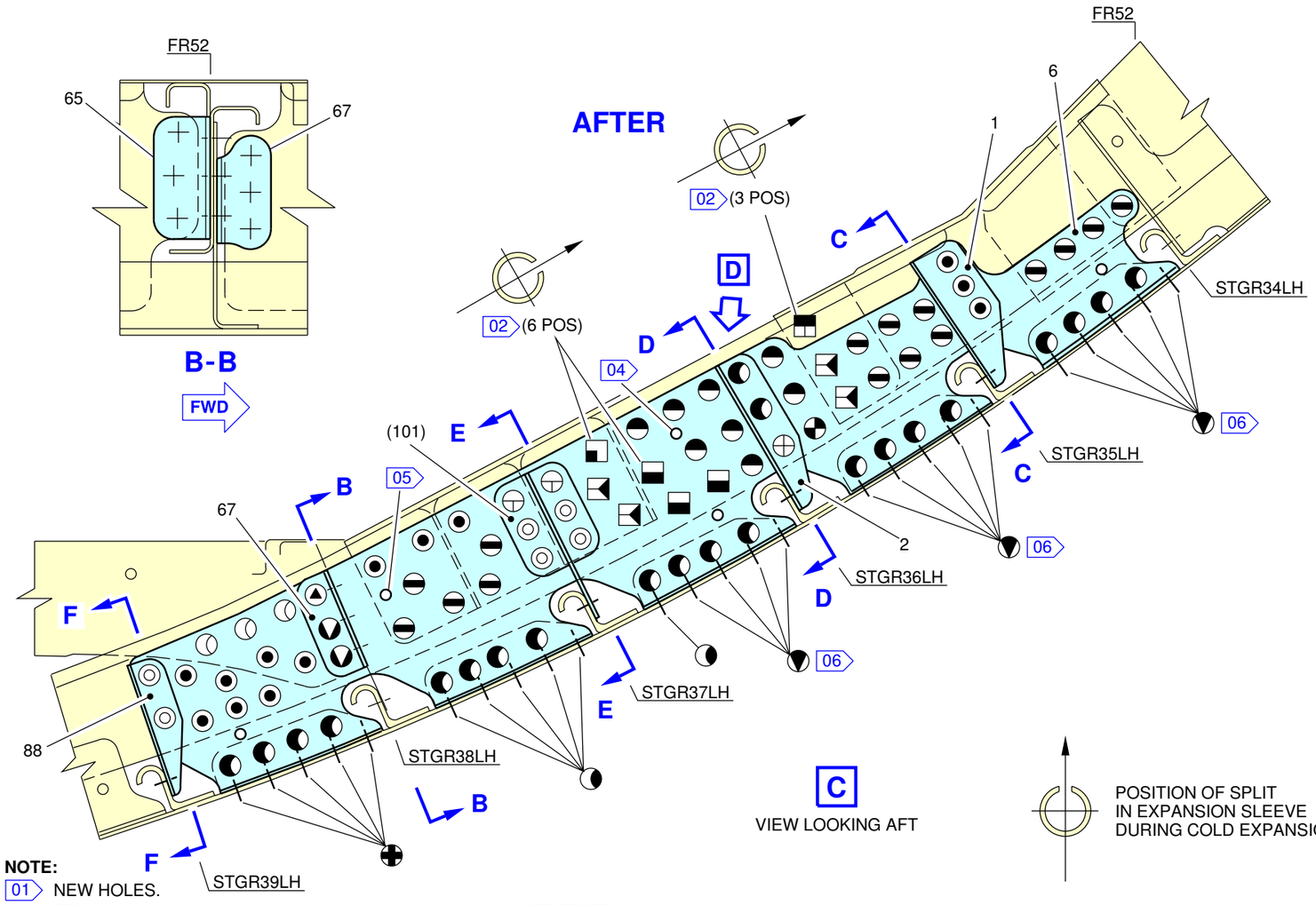
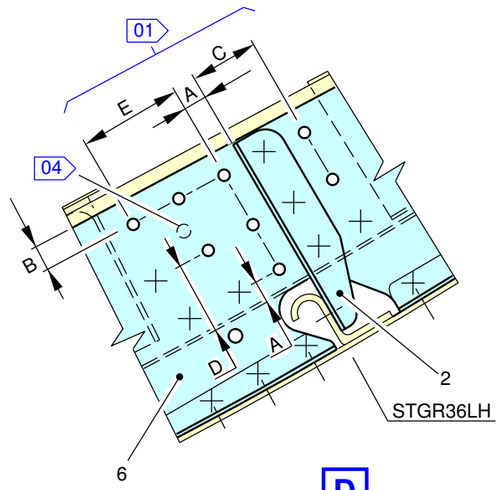
**CONF 007



C
VIEW LOOKING AFT

POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION



D
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

05 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in), FOR MSN 3999 AND SUBSEQUENT. + EXISTING HOLE POSITION MUST BE USED.

06 RIVETED WITH BELLY FAIRING ANGLE. FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BCAG_02_01

Figure A-GBCAG - Sheet 02
Replacement of Webs and Angles at Frame 52

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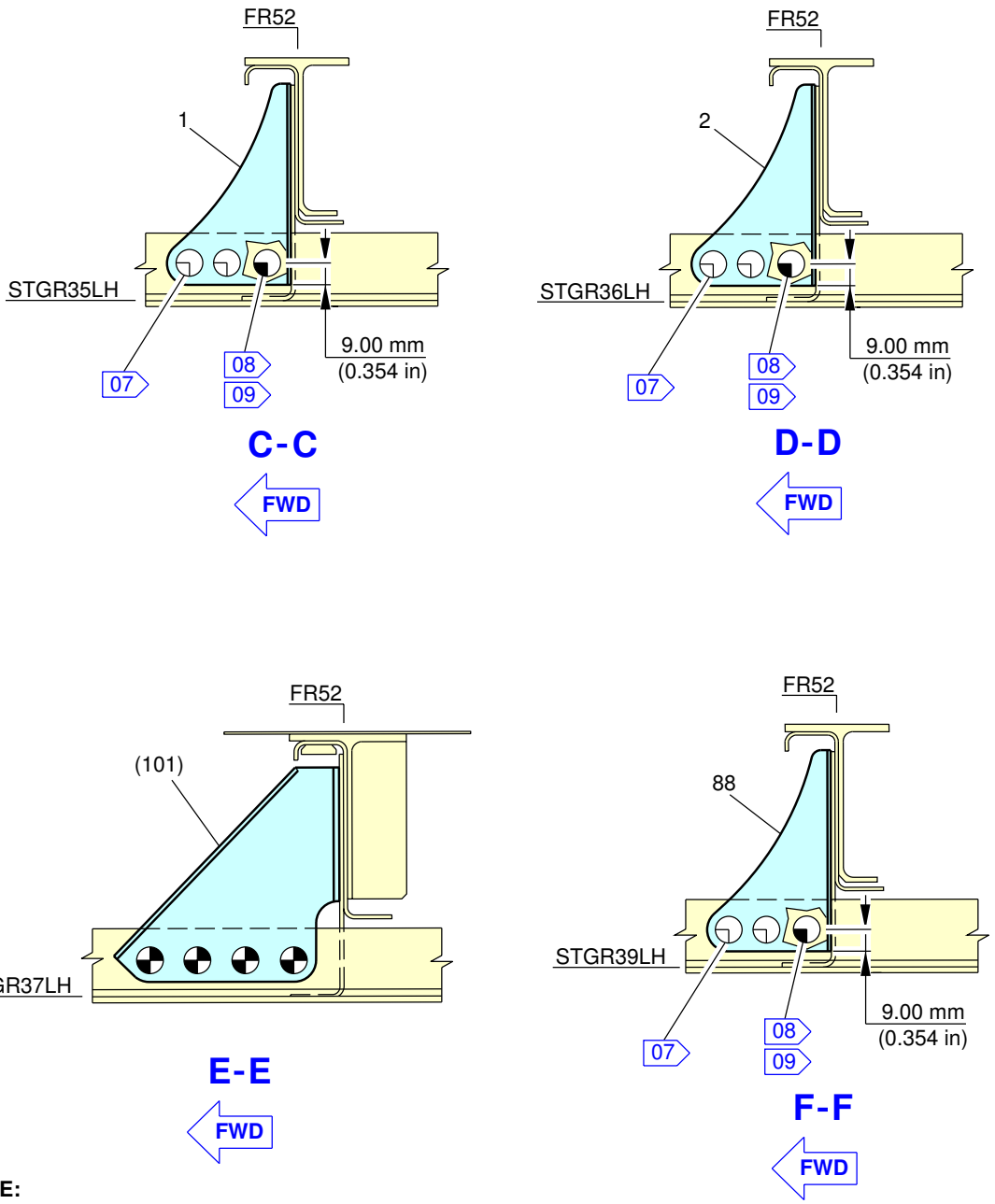
**CONF 007



NOTE:

07 EXISTING PILOT HOLES.

08 COUNTERSINK EXISTING HOLE IN THE STRINGER.

09 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BCAG_03_01

Figure A-GBCAG - Sheet 03
Replacement of Webs and Angles at Frame 52

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**CONF 007

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	768	DAN5–6–8	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	786	DAN5–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	873	DAN6–6–3X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BCAG_04_01

Figure A-GBCAG - Sheet 04
Replacement of Webs and Angles at Frame 52

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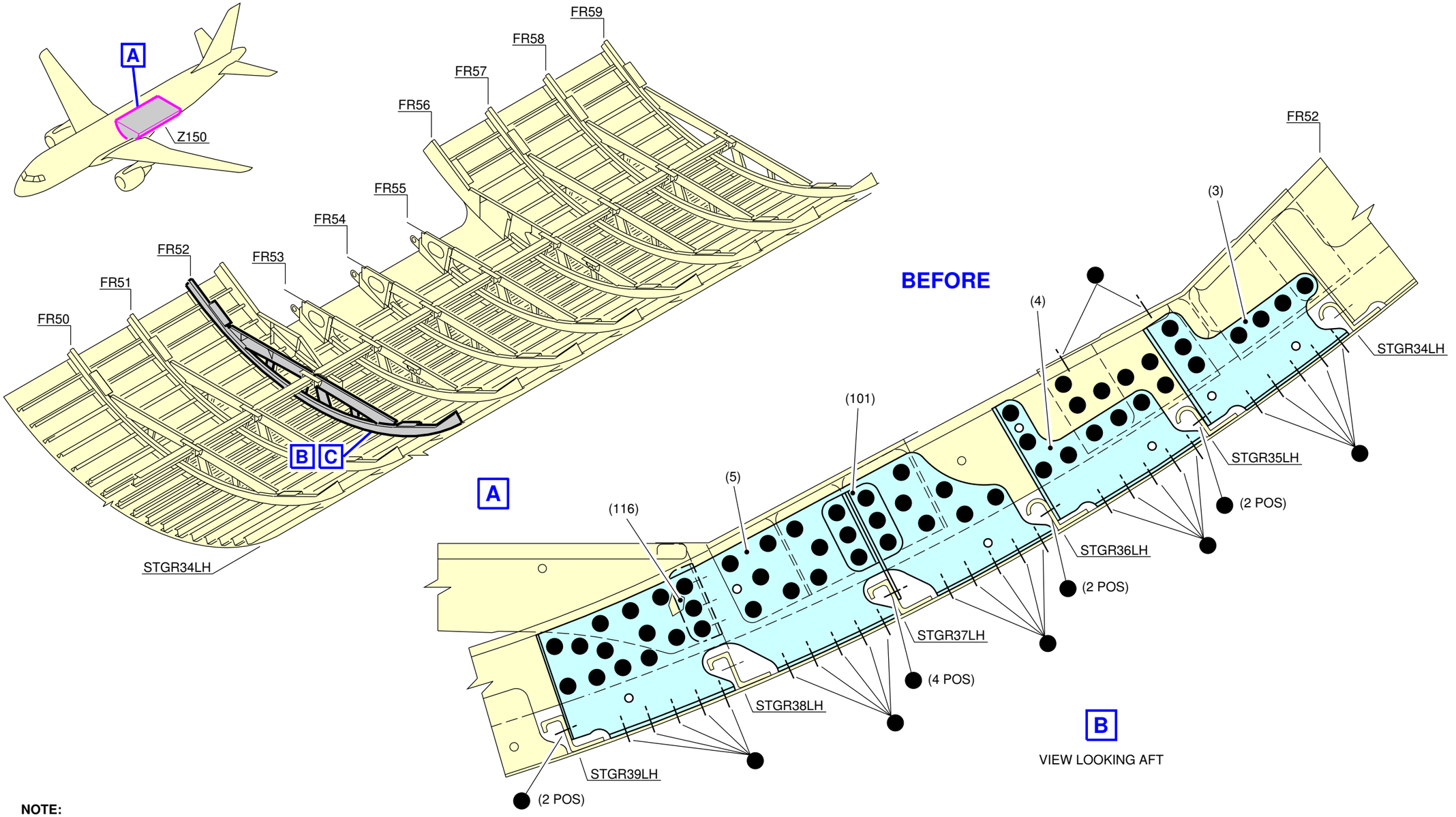
**CONF 009



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BCAJ_01_00

Figure A-GBCAJ - Sheet 01
Replacement of Webs and Angles at Frame 52

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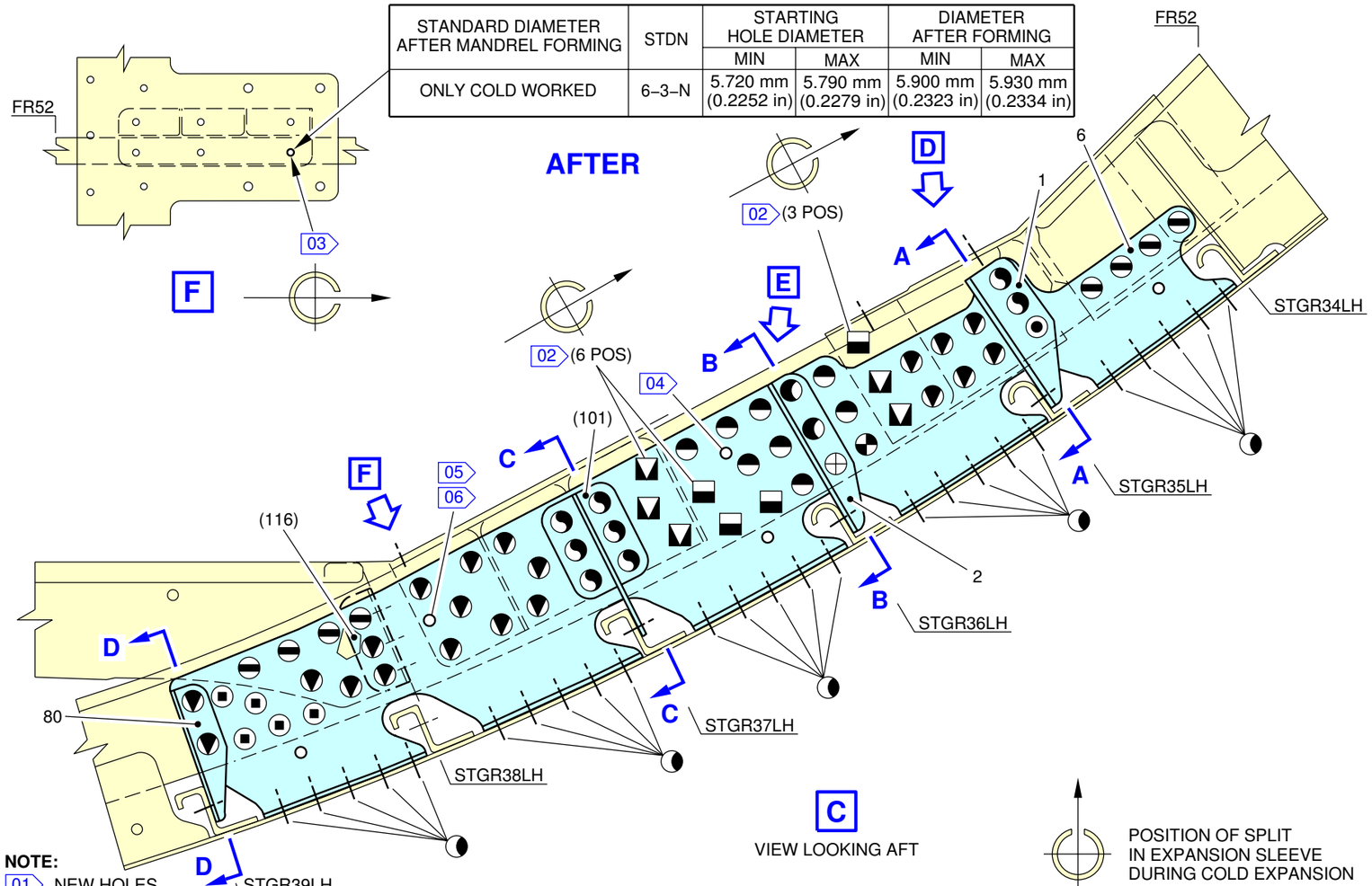
**CONF 009

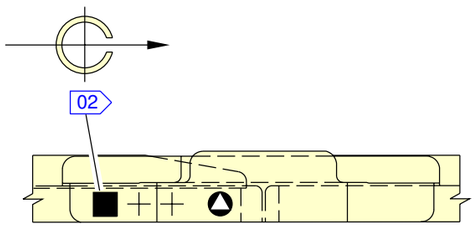
STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)

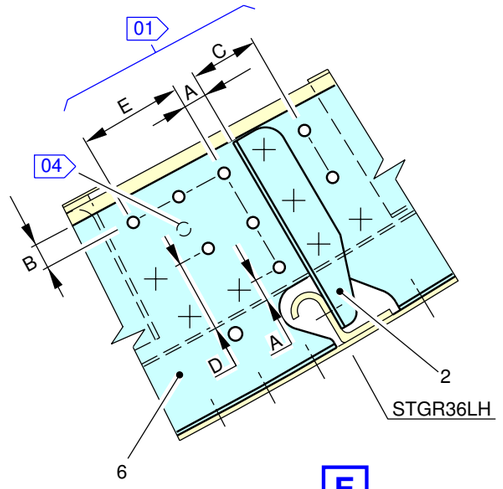


C

VIEW LOOKING AFT

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION





E

VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

05 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in).

06 VALID FOR MSN 4005 AND SUBSEQUENT.

EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BCAJ_02_01

Figure A-GBCAJ - Sheet 02
Replacement of Webs and Angles at Frame 52

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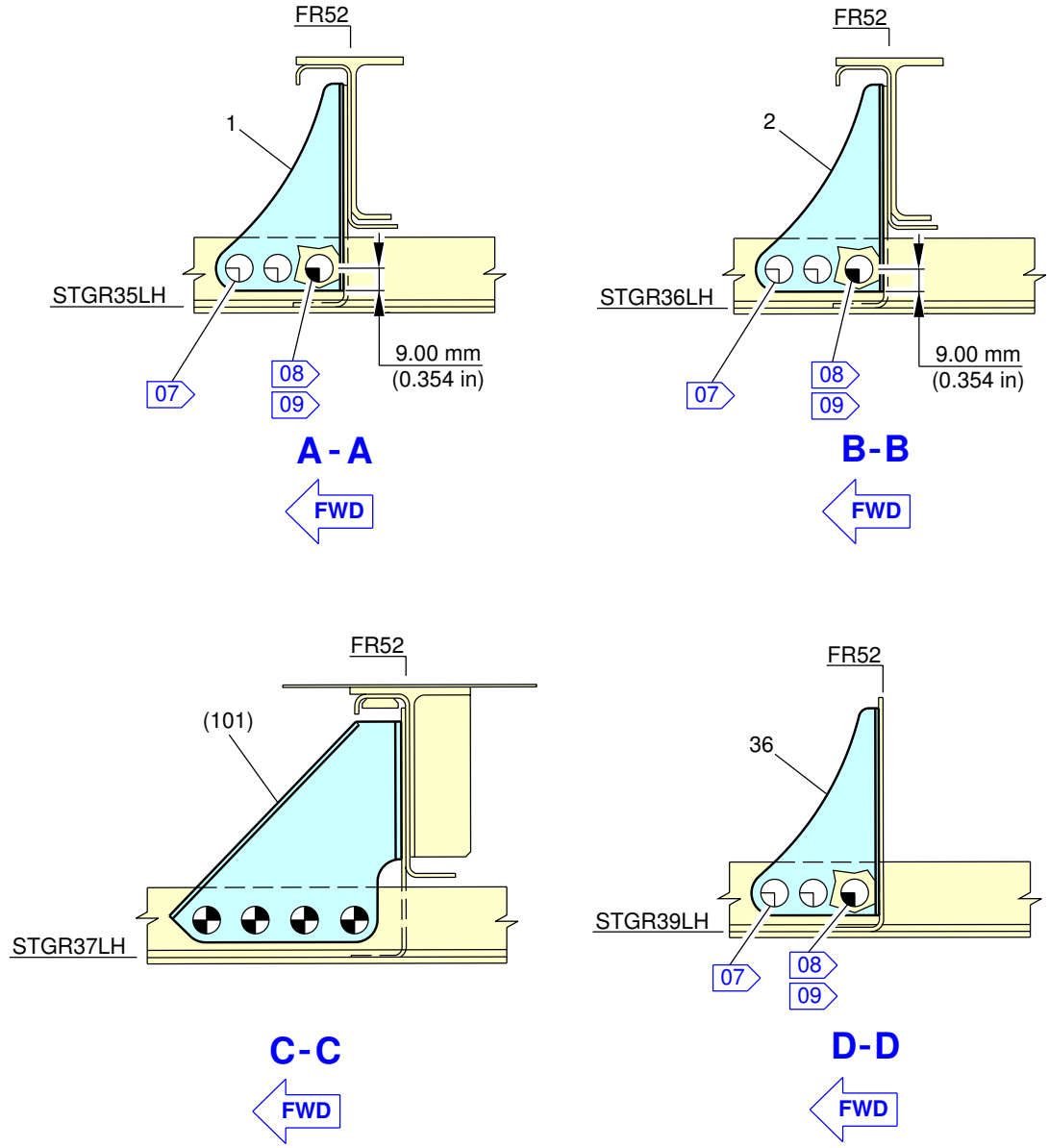
**CONF 009



NOTE:

07 EXISTING PILOT HOLES.

08 COUNTERSINK EXISTING HOLE IN THE STRINGER.

09 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BCAJ_03_01

Figure A-GBCAJ - Sheet 03
Replacement of Webs and Angles at Frame 52

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**CONF 009

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
◒	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
▼	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
■	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
◒	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◑	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◓	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◵	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◙	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◐	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
▽	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◔	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
◓	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
◉	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
▲	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
◕	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
⊕	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BCAJ_04_01

Figure A-GBCAJ - Sheet 04
Replacement of Webs and Angles at Frame 52

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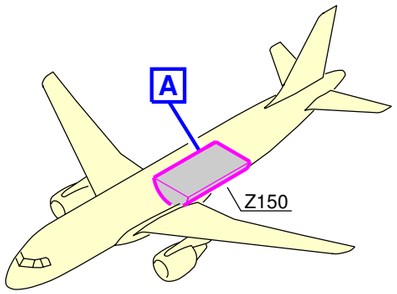
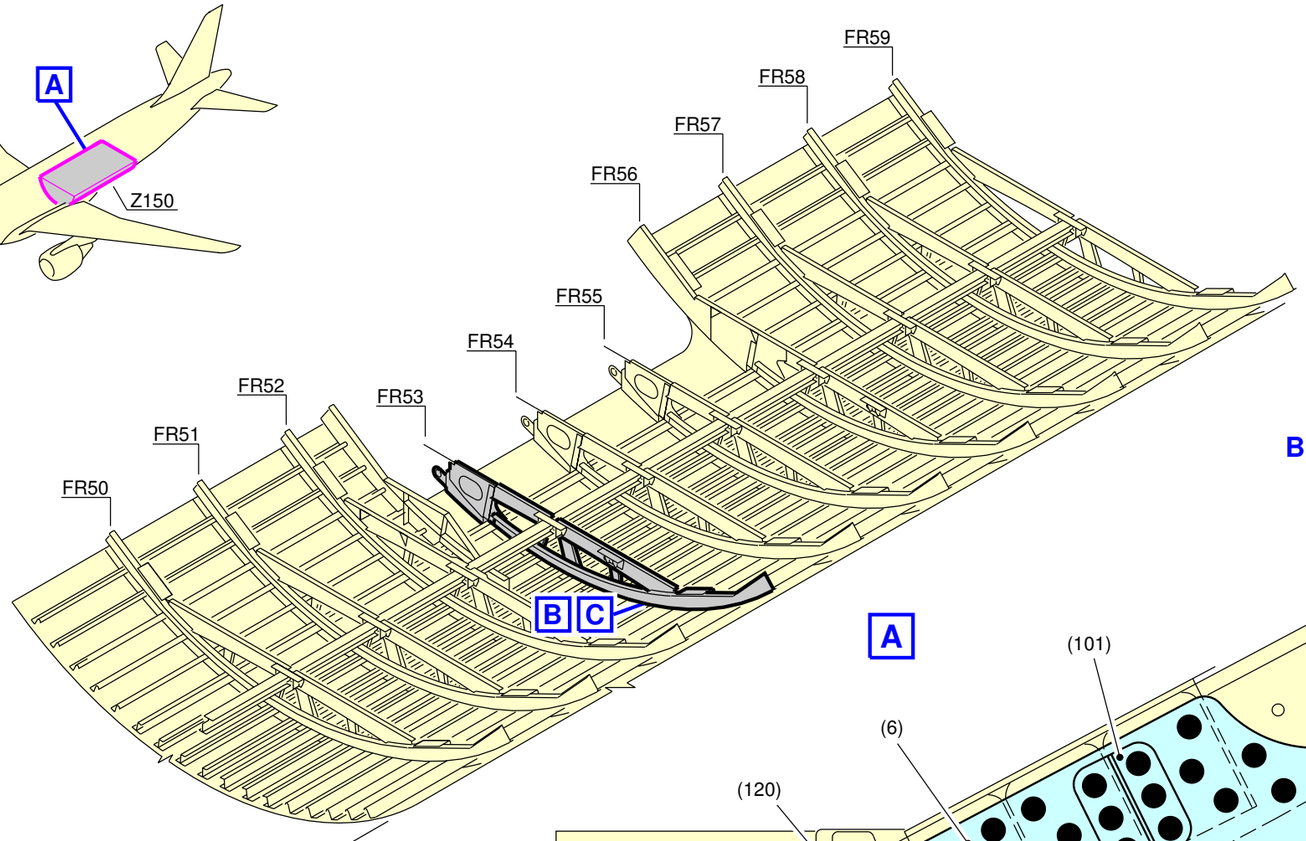
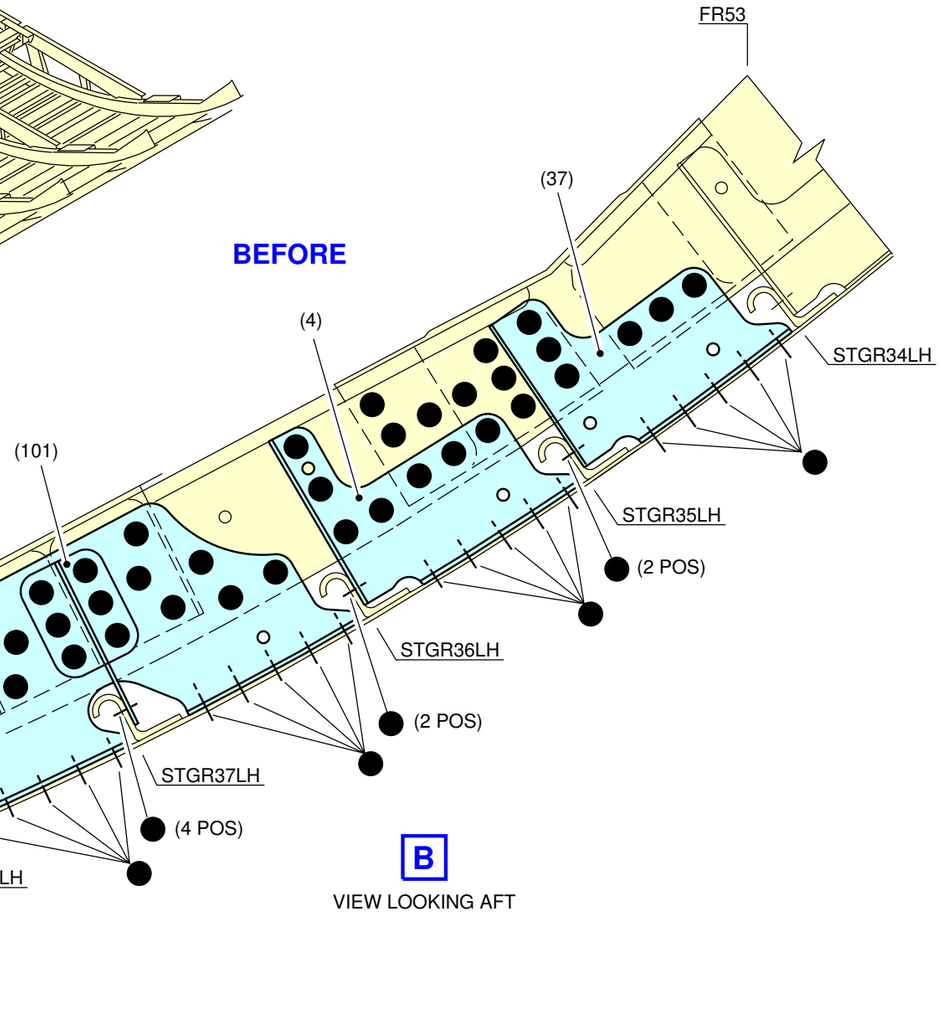
**CONF 001





A

BEFORE



B

VIEW LOOKING AFT

NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BDAA_01_00

Figure A-GBDAA - Sheet 01
Replacement of Webs and Angles at Frame 53

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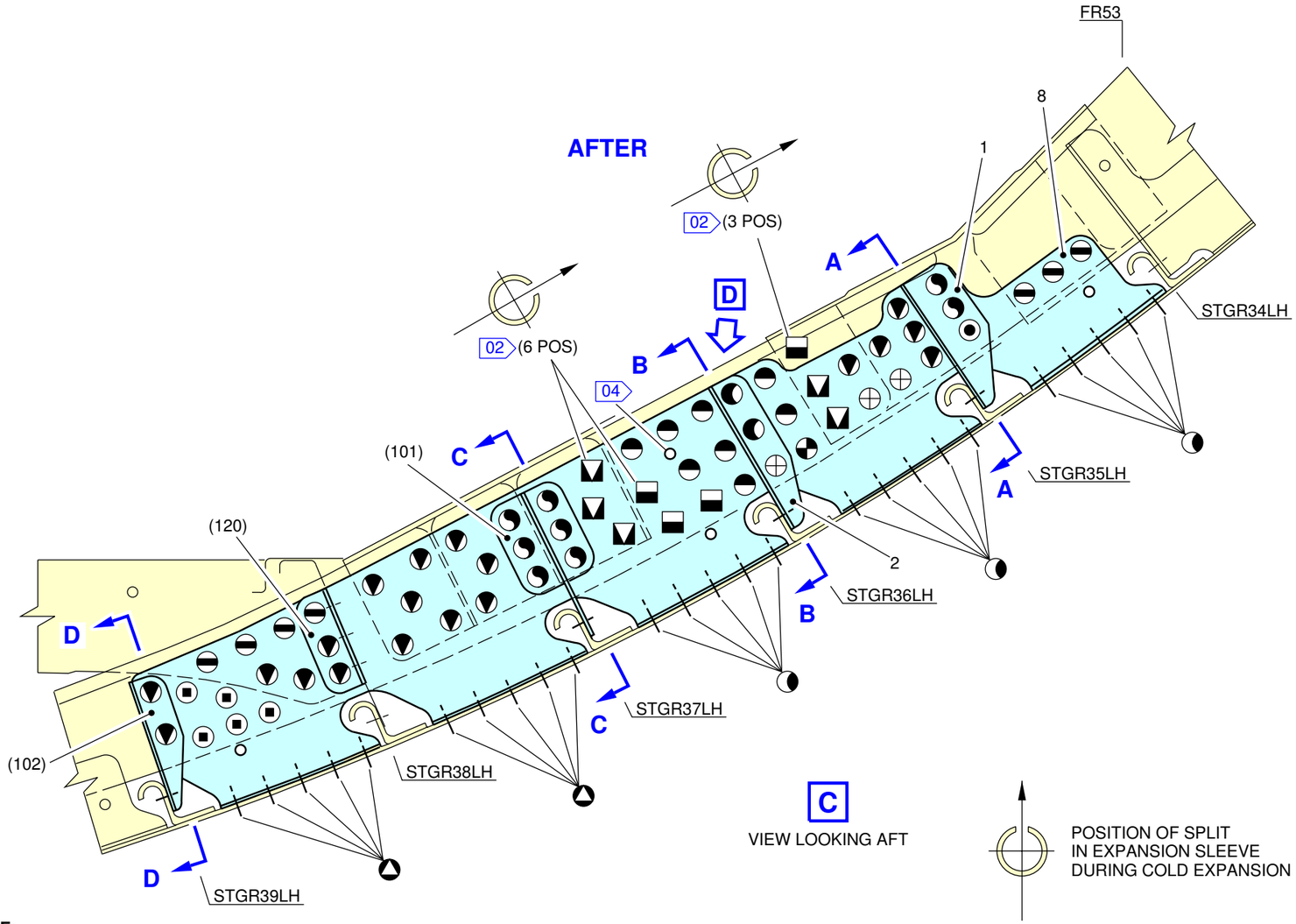
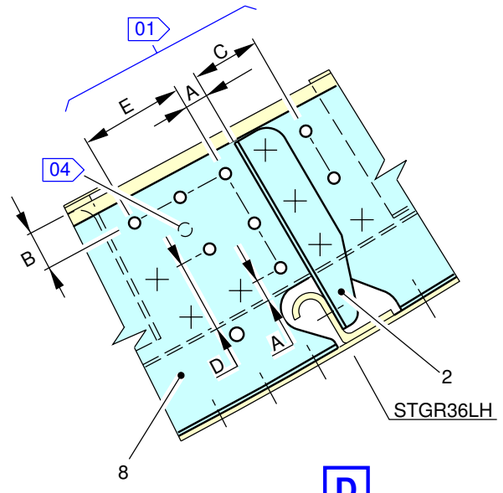
**CONF 001



C
VIEW LOOKING AFT

POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION



D
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BDAA_02_01

NOTE:

01 NEW HOLES

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4

Figure A-GBDAA - Sheet 02
Replacement of Webs and Angles at Frame 53

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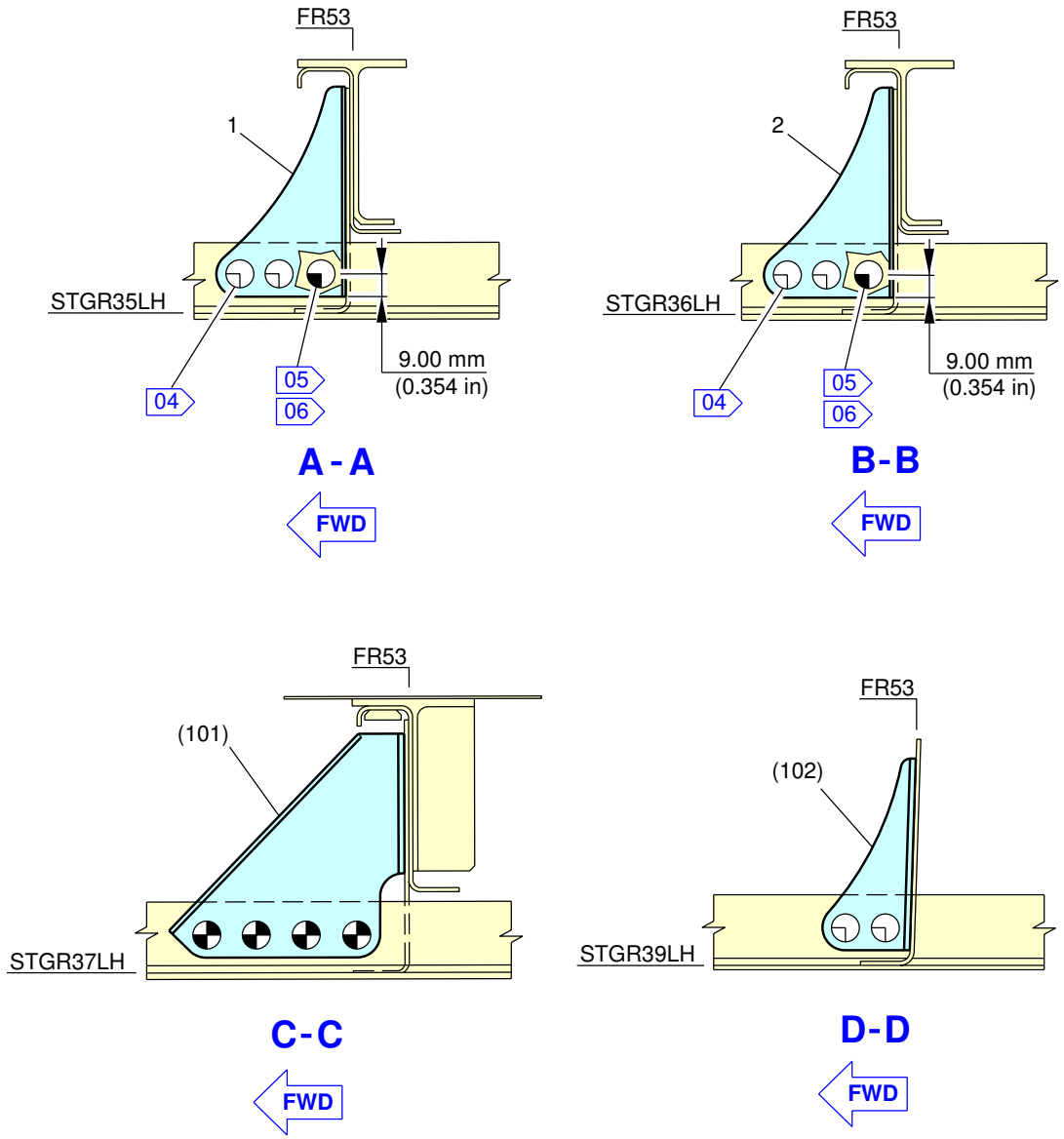
**CONF 001



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BDAA_03_01

Figure A-GBDAA - Sheet 03
Replacement of Webs and Angles at Frame 53

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**CONF 001

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BDAA_04_01

Figure A-GBDAA - Sheet 04
Replacement of Webs and Angles at Frame 53

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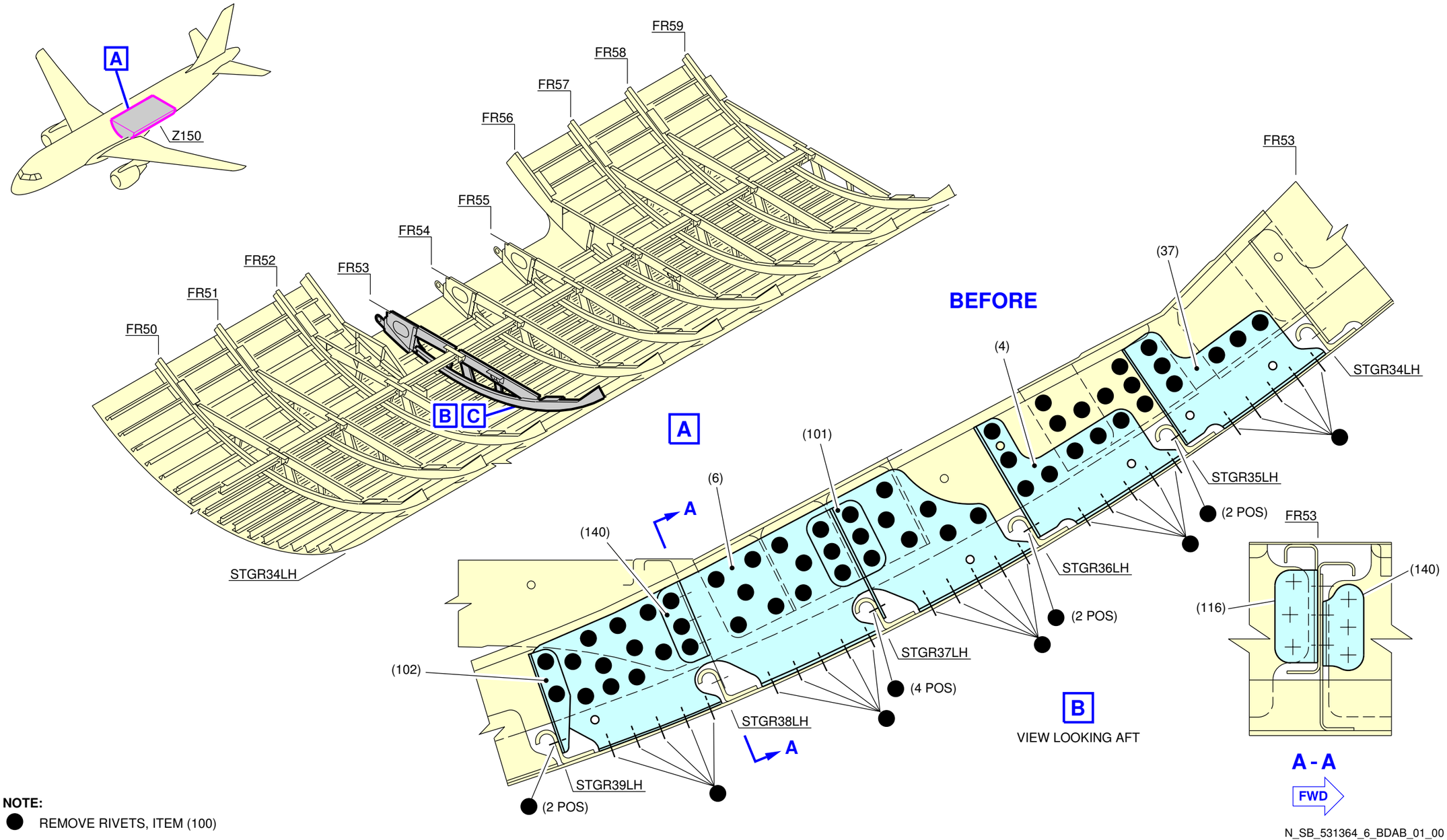
**CONF 002



NOTE:

● REMOVE RIVETS, ITEM (100)

Figure A-GBDAB - Sheet 01
Replacement of Webs and Angles at Frame 53

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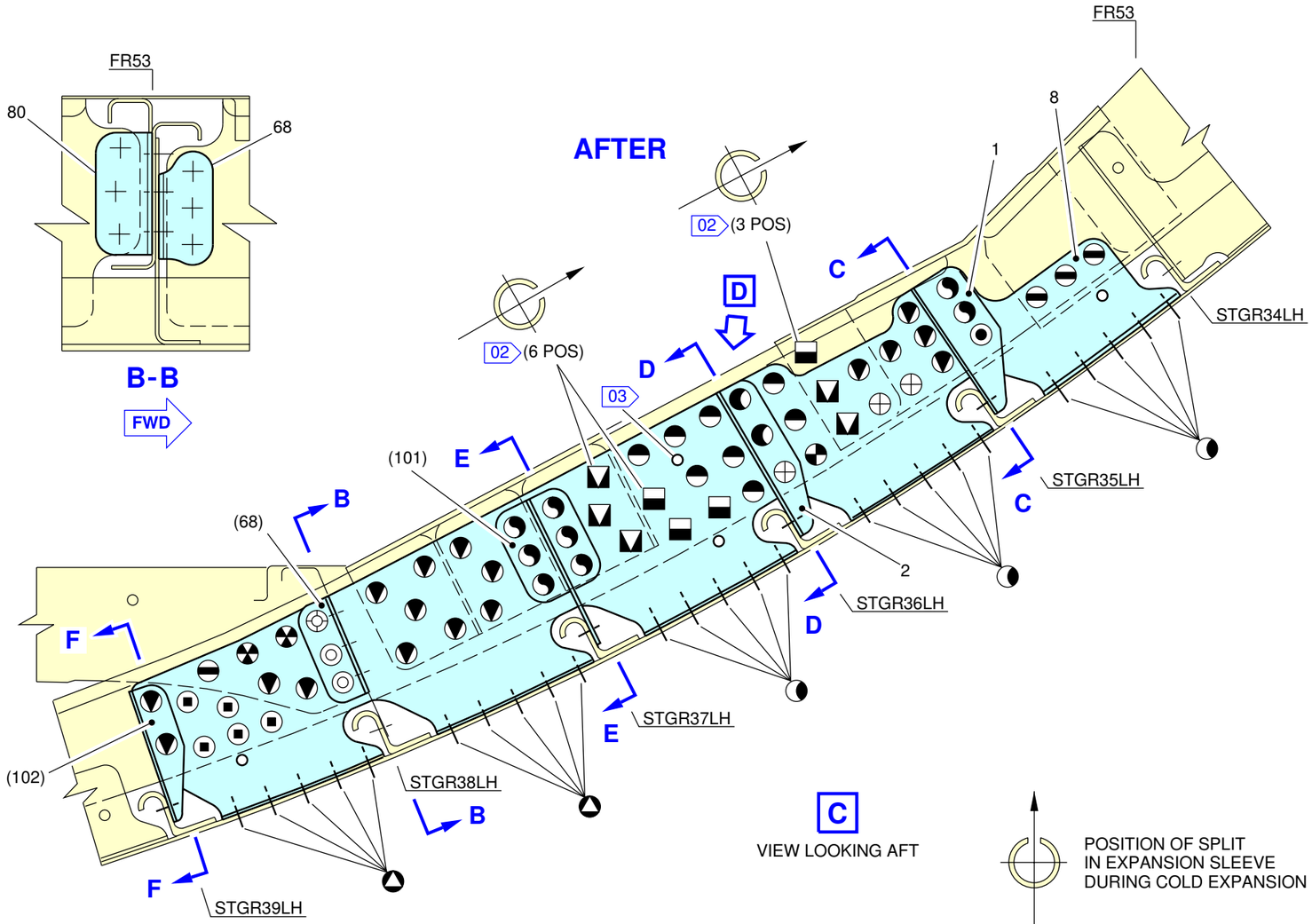
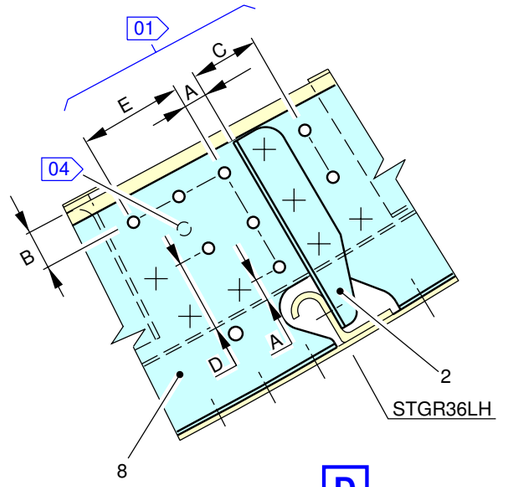
**CONF 002



C
VIEW LOOKING AFT

POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION



D
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BDAB_02_01

NOTE:

01 NEW HOLES

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00,

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4

Figure A-GBDAB - Sheet 02
Replacement of Webs and Angles at Frame 53

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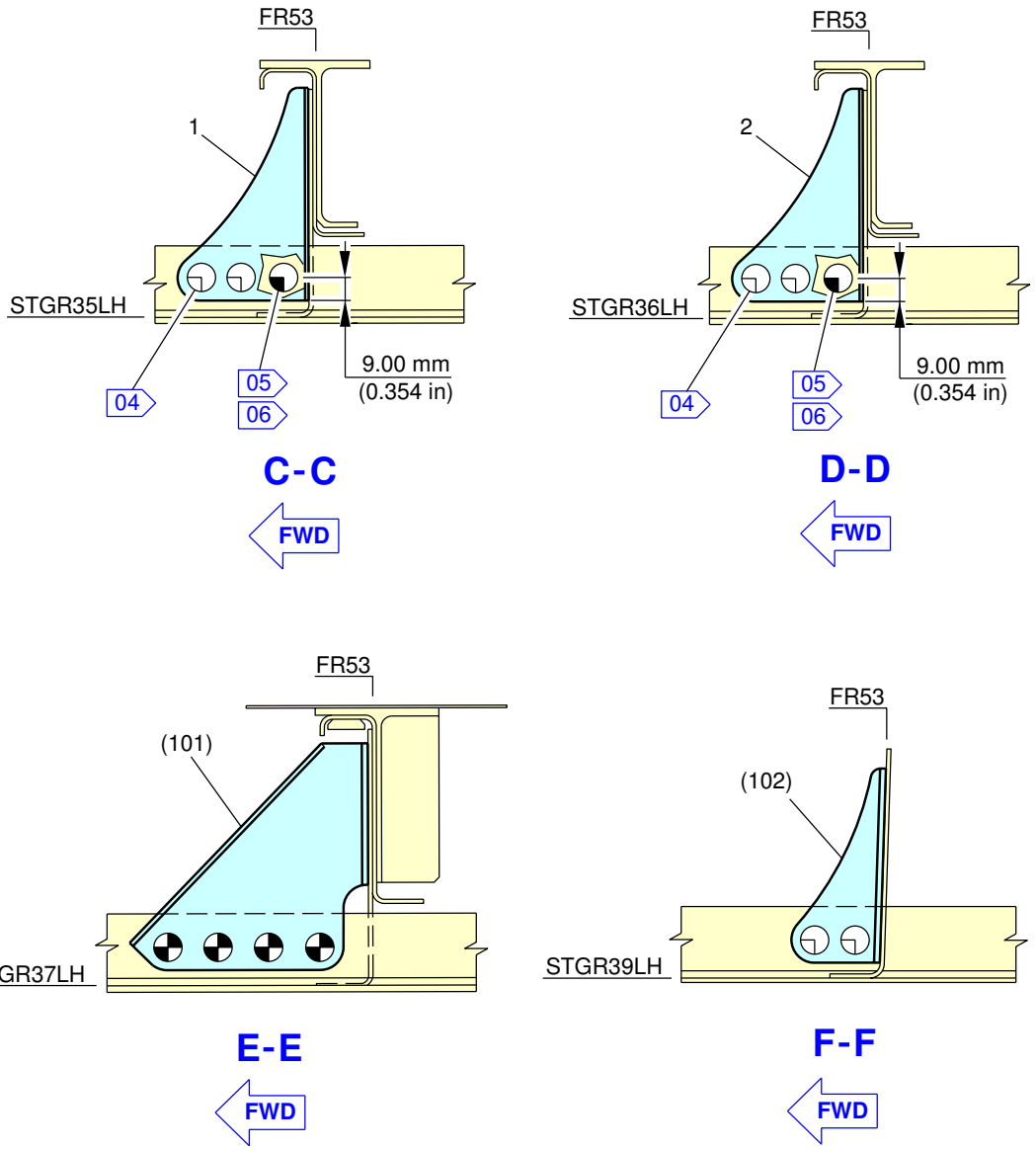
**CONF 002



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BDAB_03_01

Figure A-GBDAB - Sheet 03
Replacement of Webs and Angles at Frame 53

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**CONF 002

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	784	DAN5–6–4Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	875	DAN6–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BDAB_04_01

Figure A-GBDAB - Sheet 04
Replacement of Webs and Angles at Frame 53

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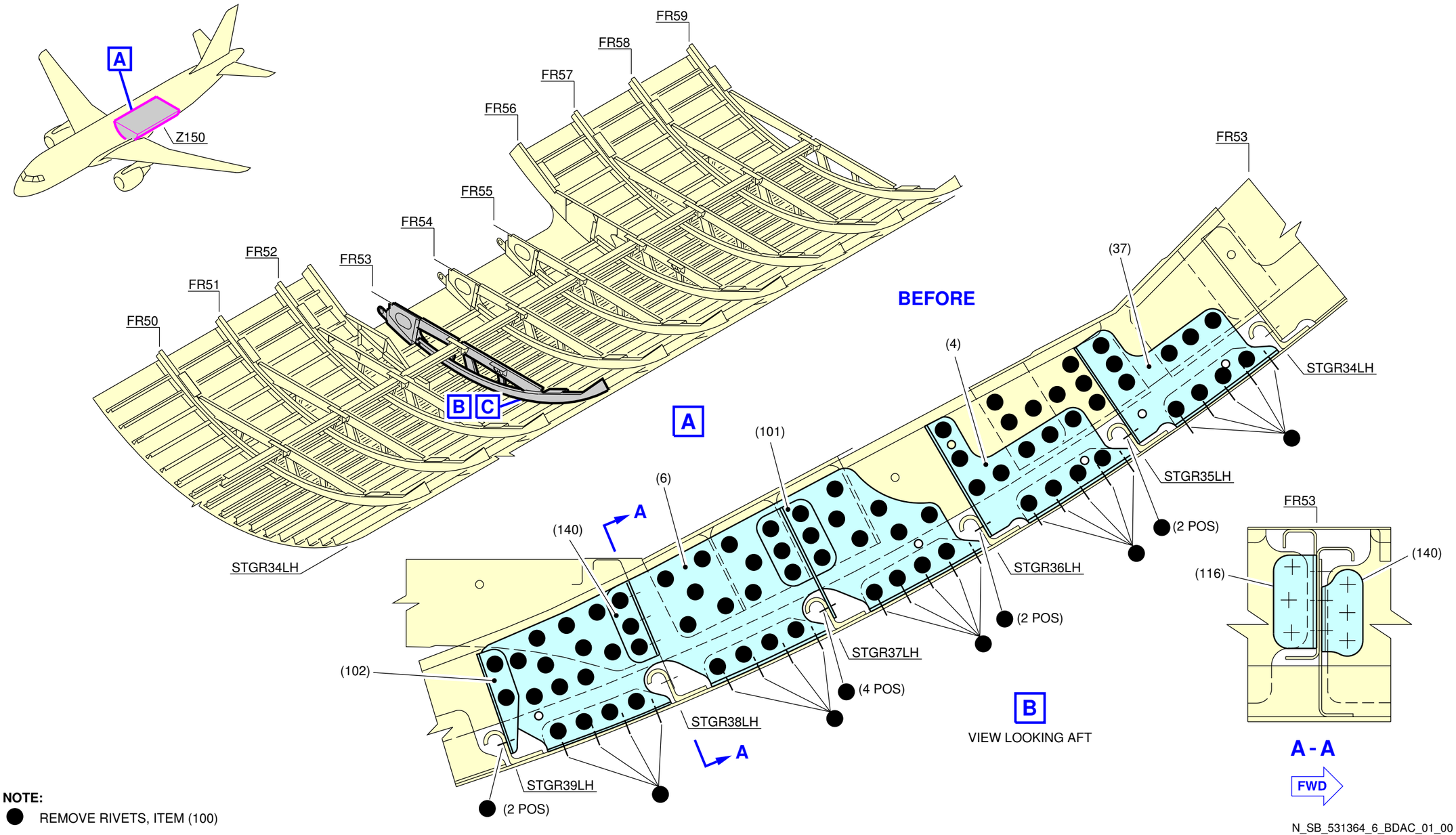
**CONF 003



NOTE:

● REMOVE RIVETS, ITEM (100)

Figure A-GBDAC - Sheet 01
Replacement of Webs and Angles at Frame 53

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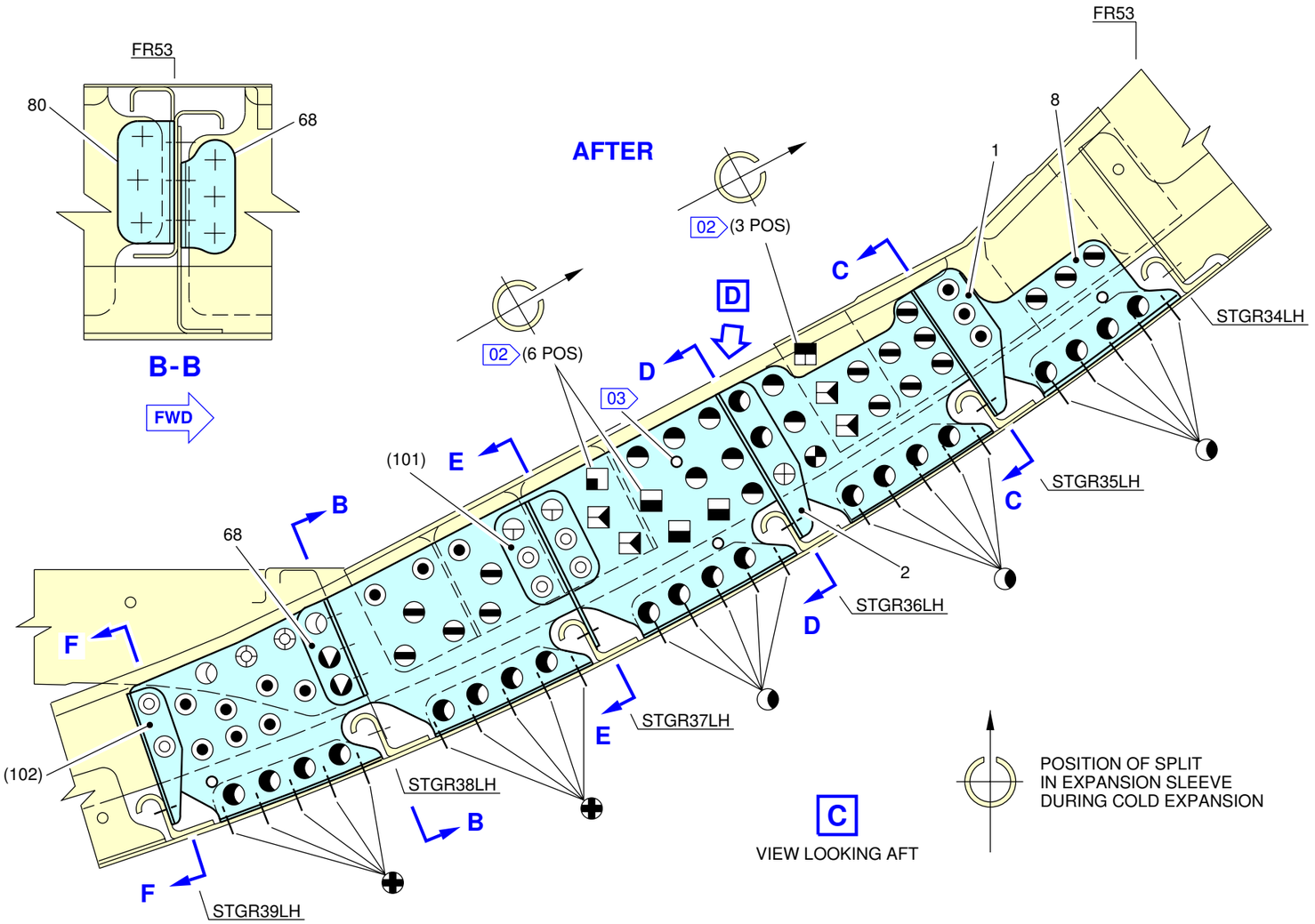
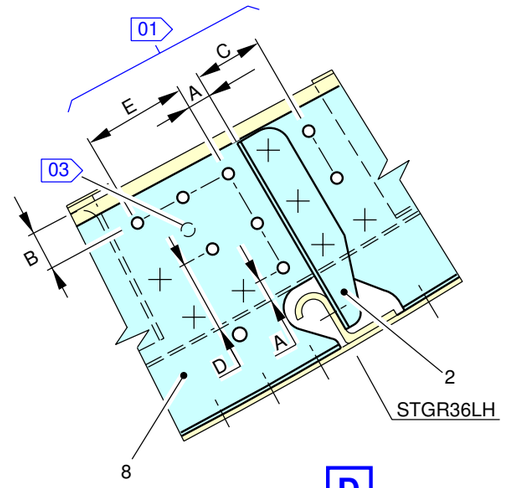
**CONF 003





NOTE:

01 NEW HOLES

02 ▬ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, ◧◧◧ COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

┼ EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BDAC_02_01

Figure A-GBDAC - Sheet 02
Replacement of Webs and Angles at Frame 53

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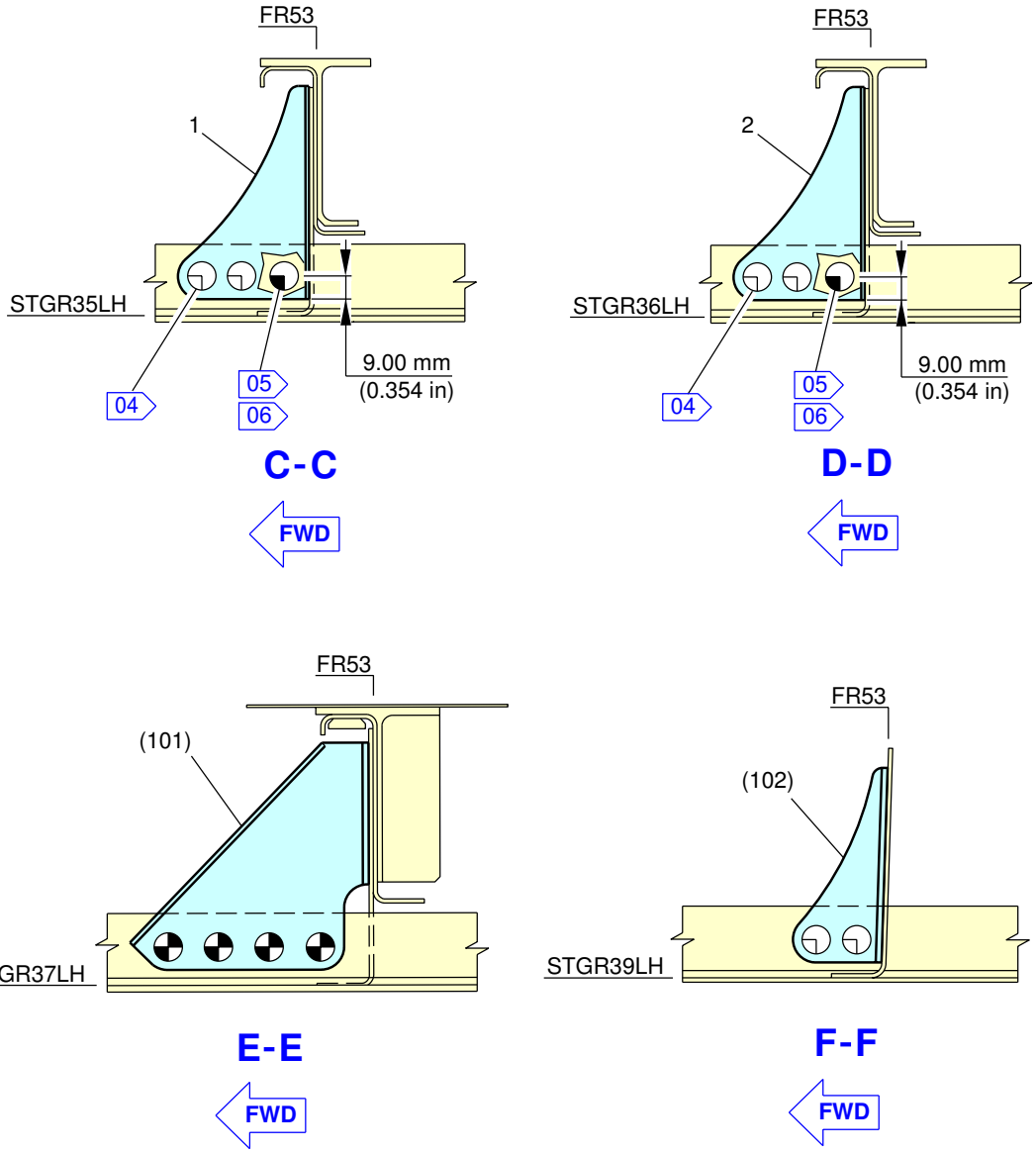
**CONF 003



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BDAC_03_01

Figure A-GBDAC - Sheet 03
Replacement of Webs and Angles at Frame 53

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**CONF 003

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	873	DAN6–6–3X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	768	DAN5–6–8X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	784	DAN5–6–4Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			

N_SB_531364_6_BDAC_04_01

Figure A-GBDAC - Sheet 04
Replacement of Webs and Angles at Frame 53

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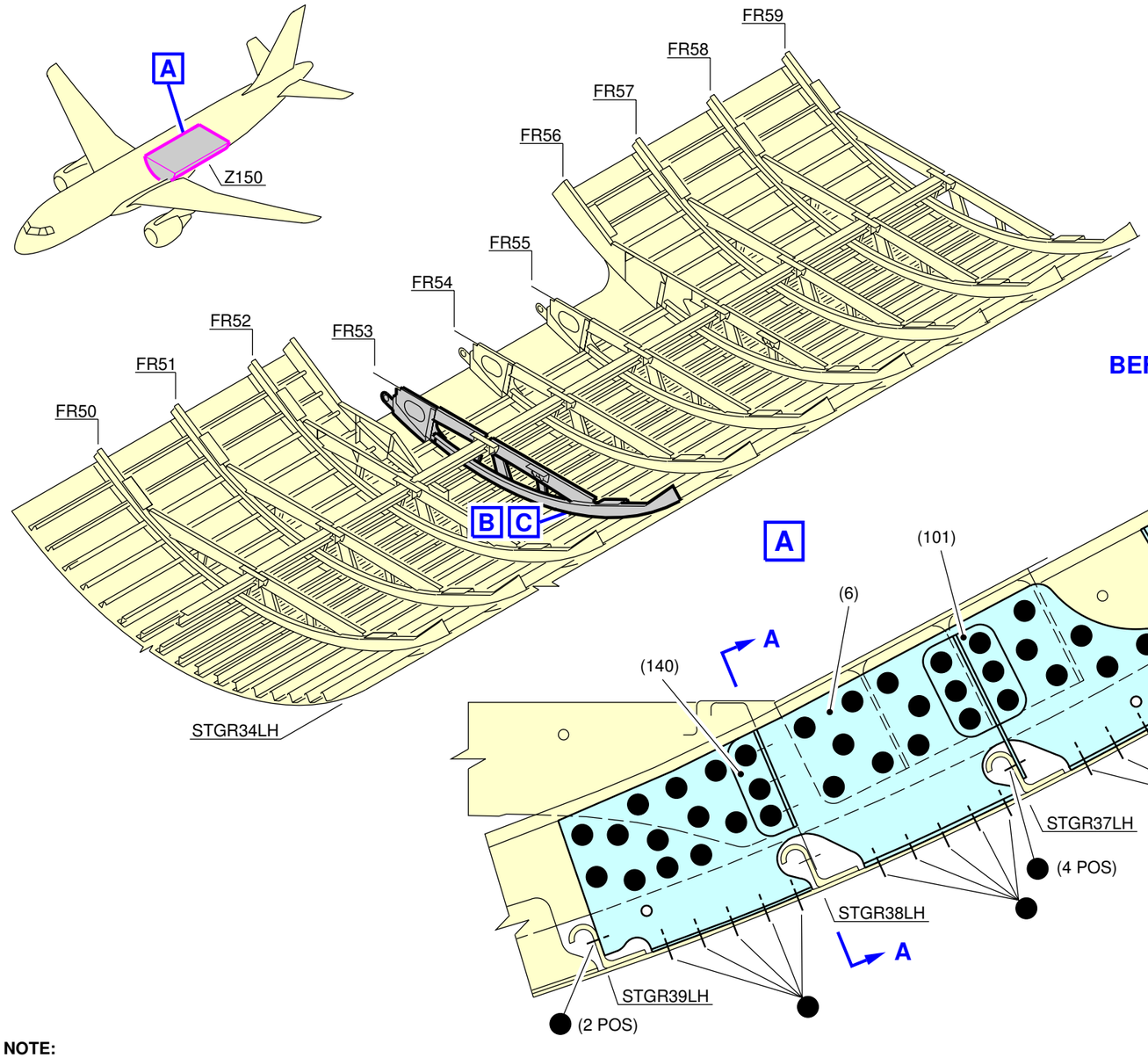
**CONF 004



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BDAD_01_00

Figure A-GBDAD - Sheet 01
Replacement of Webs and Angles at Frame 53

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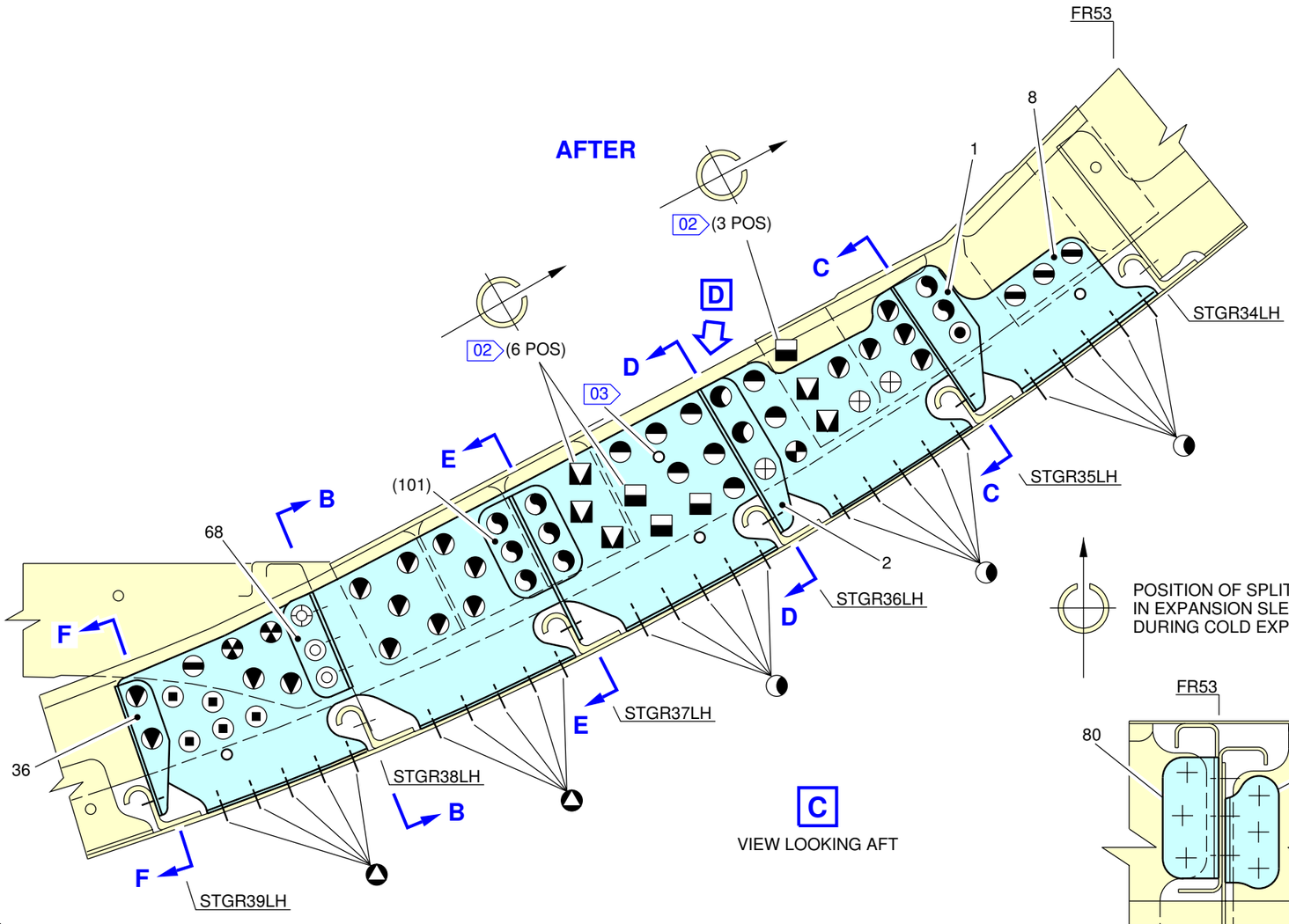
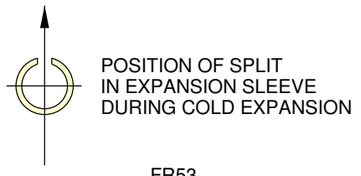
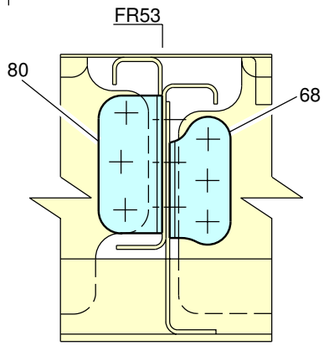
**CONF 004



C
VIEW LOOKING AFT

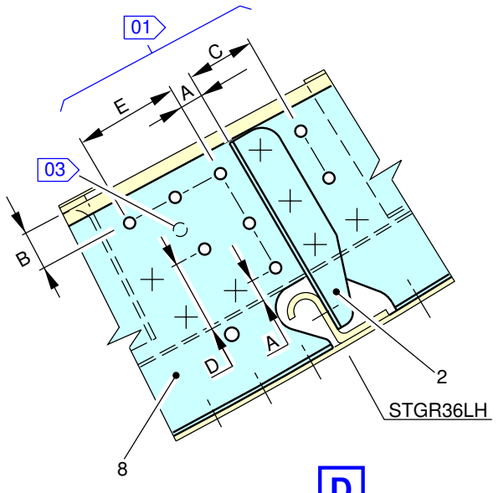


POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION



B-B

FWD



D
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BDAD_02_01

NOTE:

01 NEW HOLES

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4

Figure A-GBDAD - Sheet 02
Replacement of Webs and Angles at Frame 53

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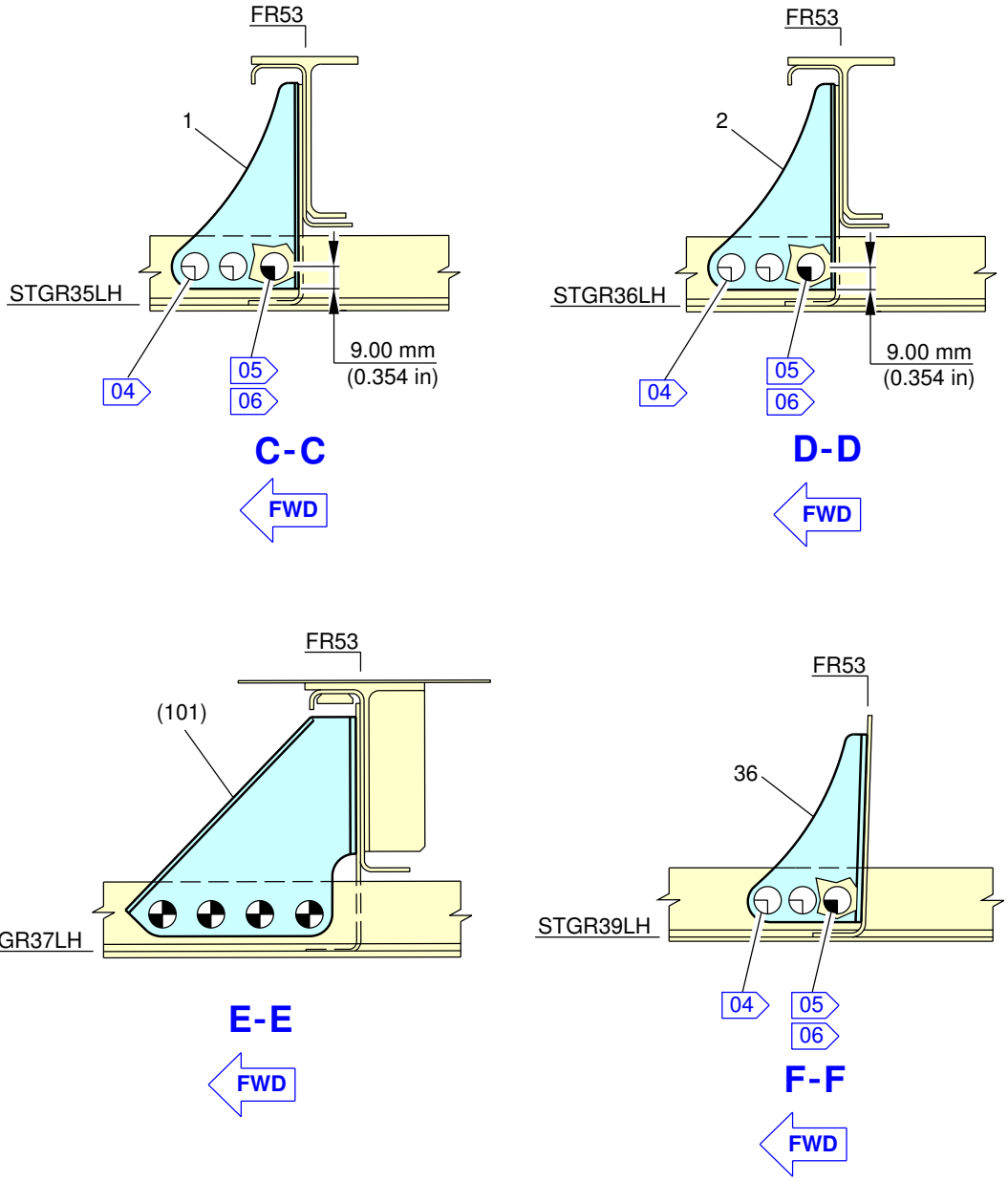
**CONF 004



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BDAD_03_01

Figure A-GBDAD - Sheet 03
Replacement of Webs and Angles at Frame 53

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**CONF 004

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	784	DAN5–6–4Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	875	DAN6–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BDAD_04_01

Figure A-GBDAD - Sheet 04
Replacement of Webs and Angles at Frame 53

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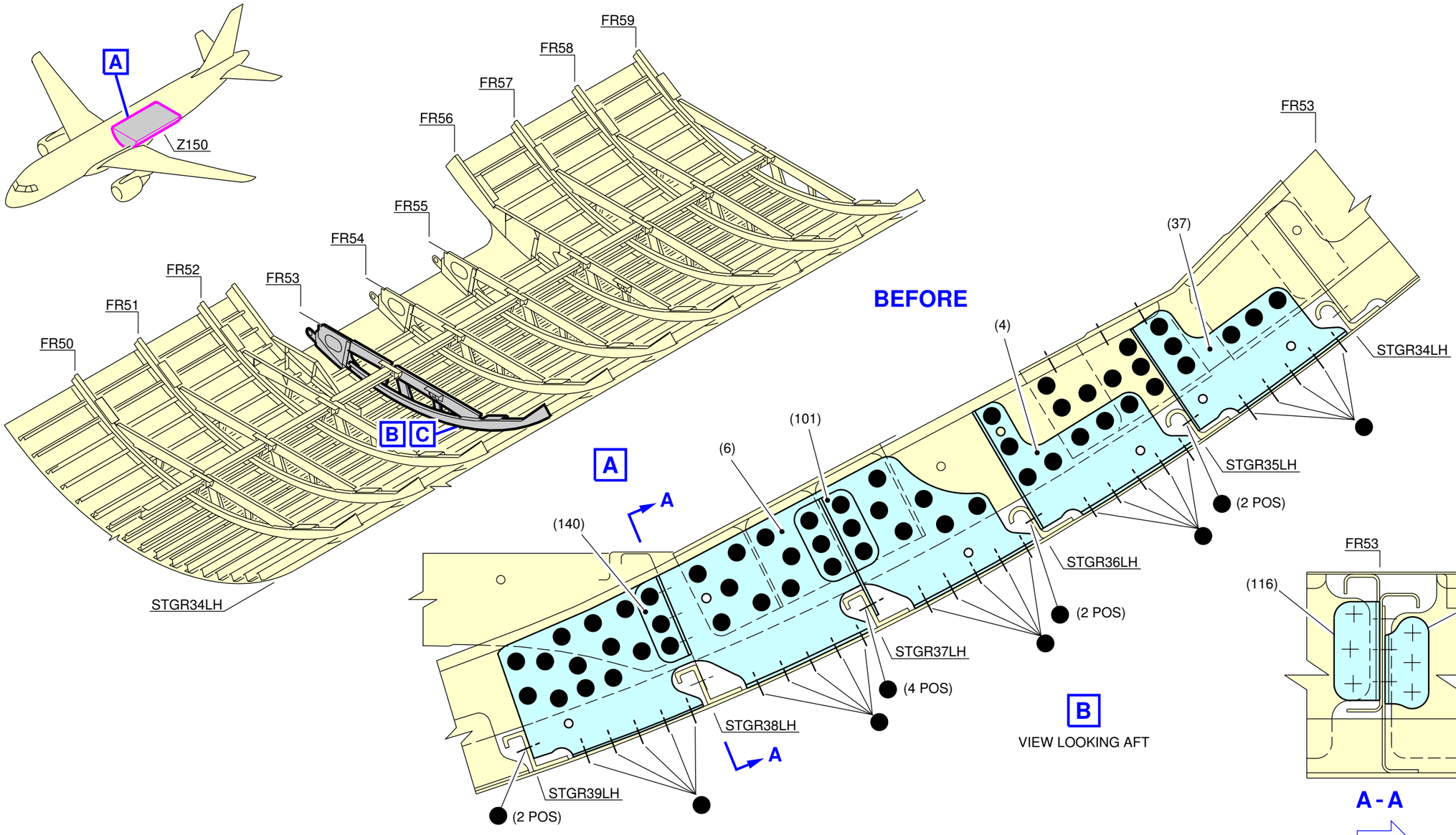
**CONF 005



N_SB_531364_6_BDAE_01_00

NOTE:

● REMOVE RIVETS, ITEM (100)

Figure A-GBDAE - Sheet 01
Replacement of Webs and Angles at Frame 53

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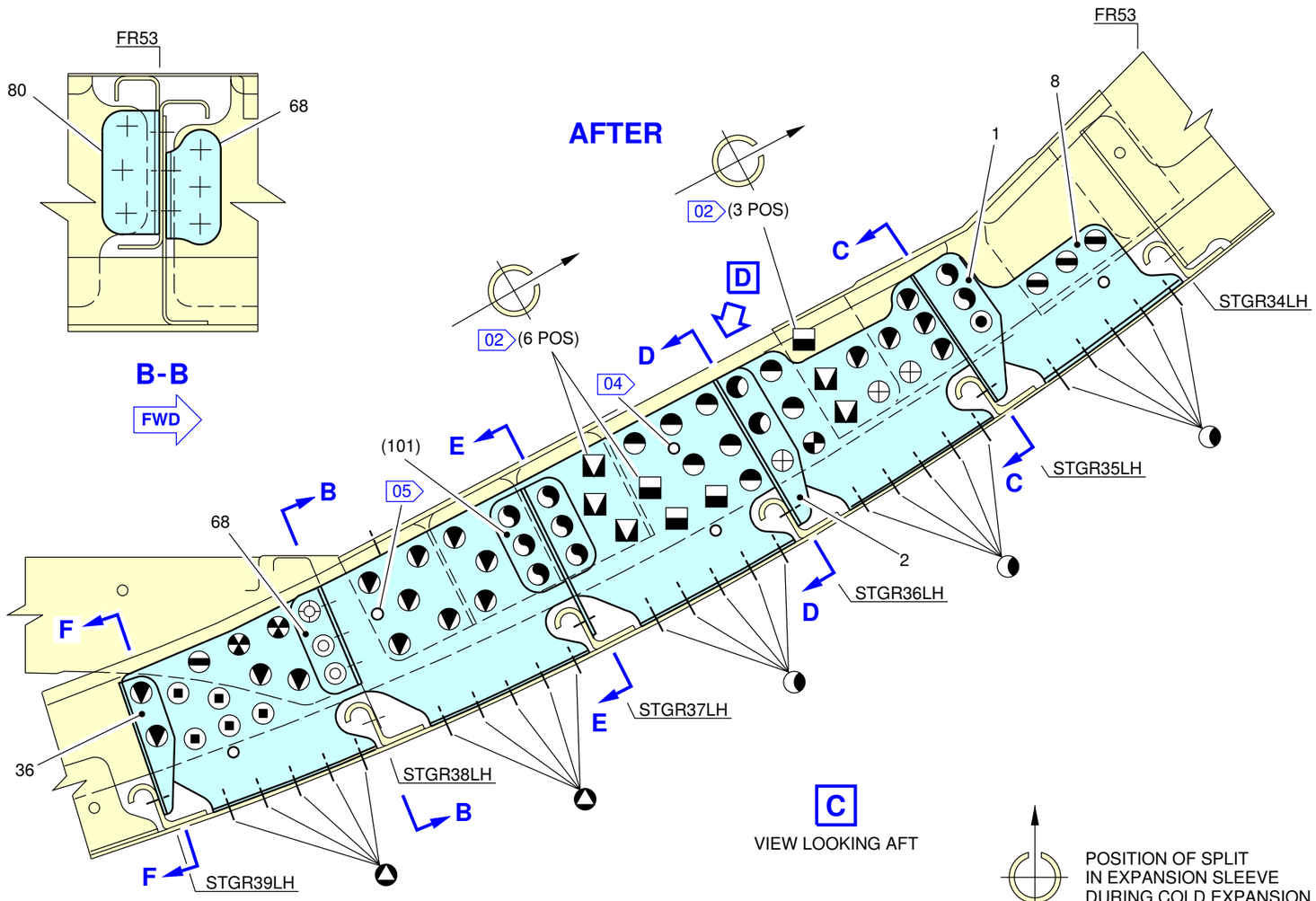
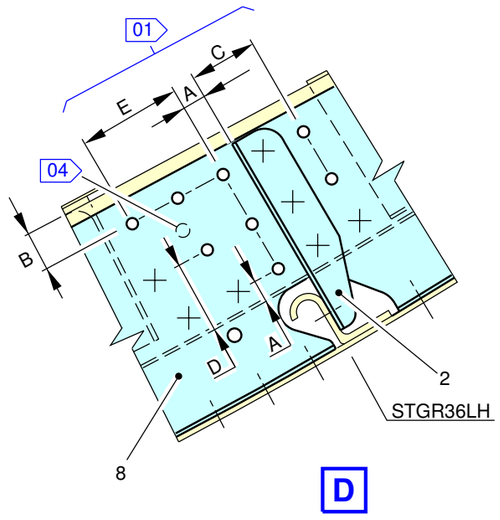
**CONF 005





DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

05 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in). FOR MSN 3999 AND SUBSEQUENT.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BDAE_02_02

Figure A-GBDAE - Sheet 02
Replacement of Webs and Angles at Frame 53

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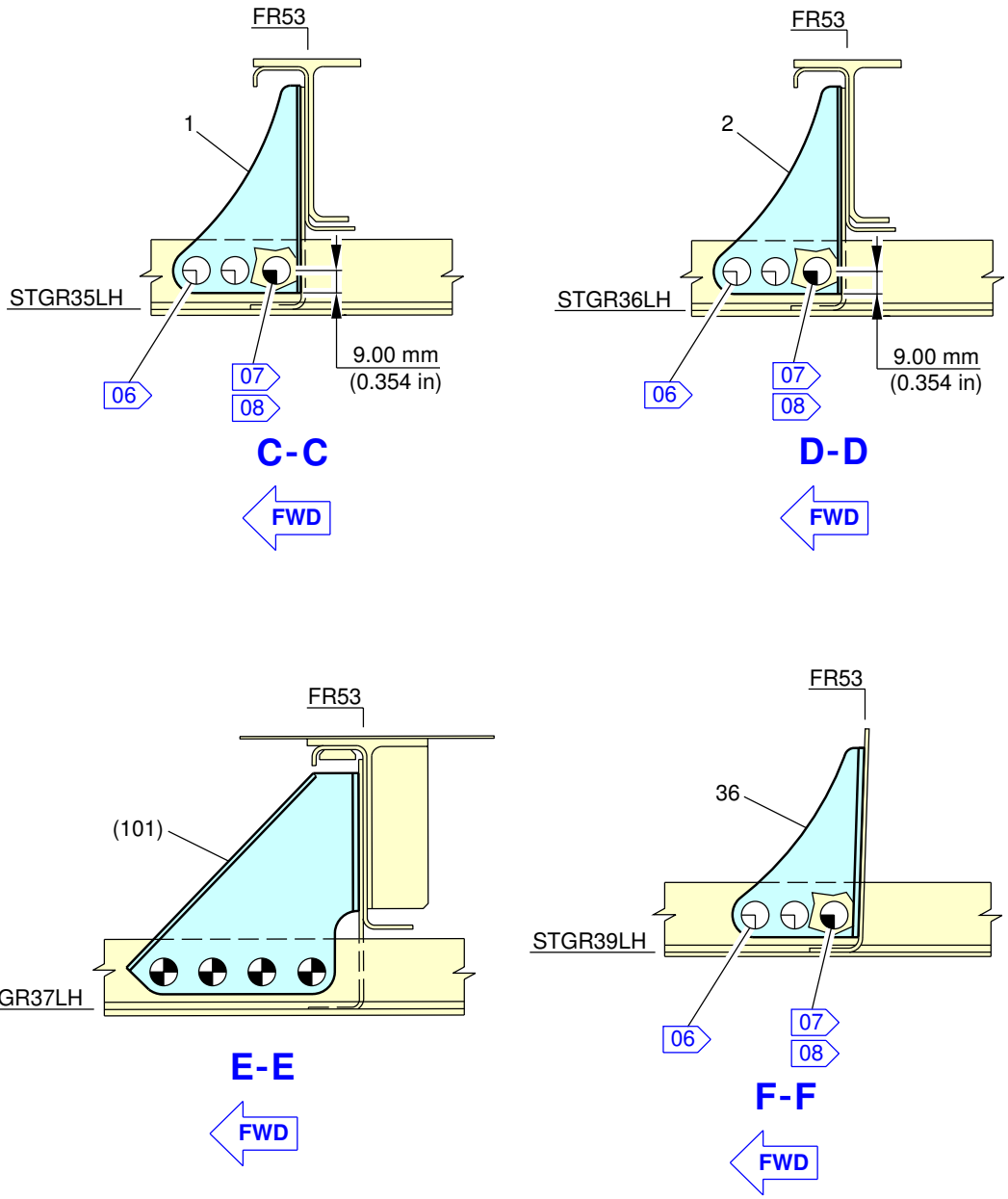
**CONF 005



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BDAE_03_01

Figure A-GBDAE - Sheet 03
Replacement of Webs and Angles at Frame 53

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**CONF 005

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	784	DAN5–6–4Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	875	DAN6–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BDAE_04_01

Figure A-GBDAE - Sheet 04
Replacement of Webs and Angles at Frame 53

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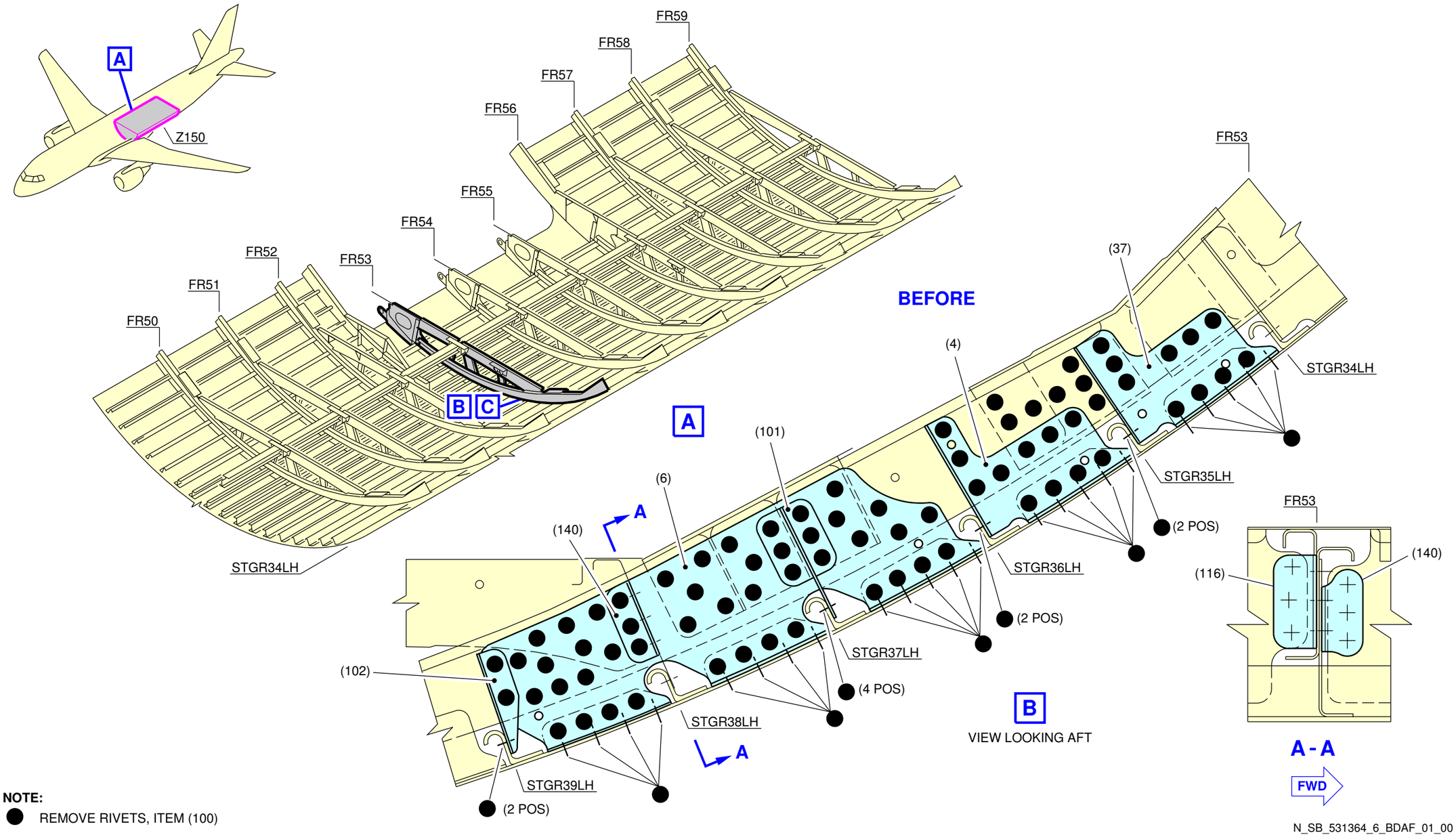
**CONF 006



NOTE:

● REMOVE RIVETS, ITEM (100)

Figure A-GBDAF - Sheet 01
Replacement of Webs and Angles at Frame 53

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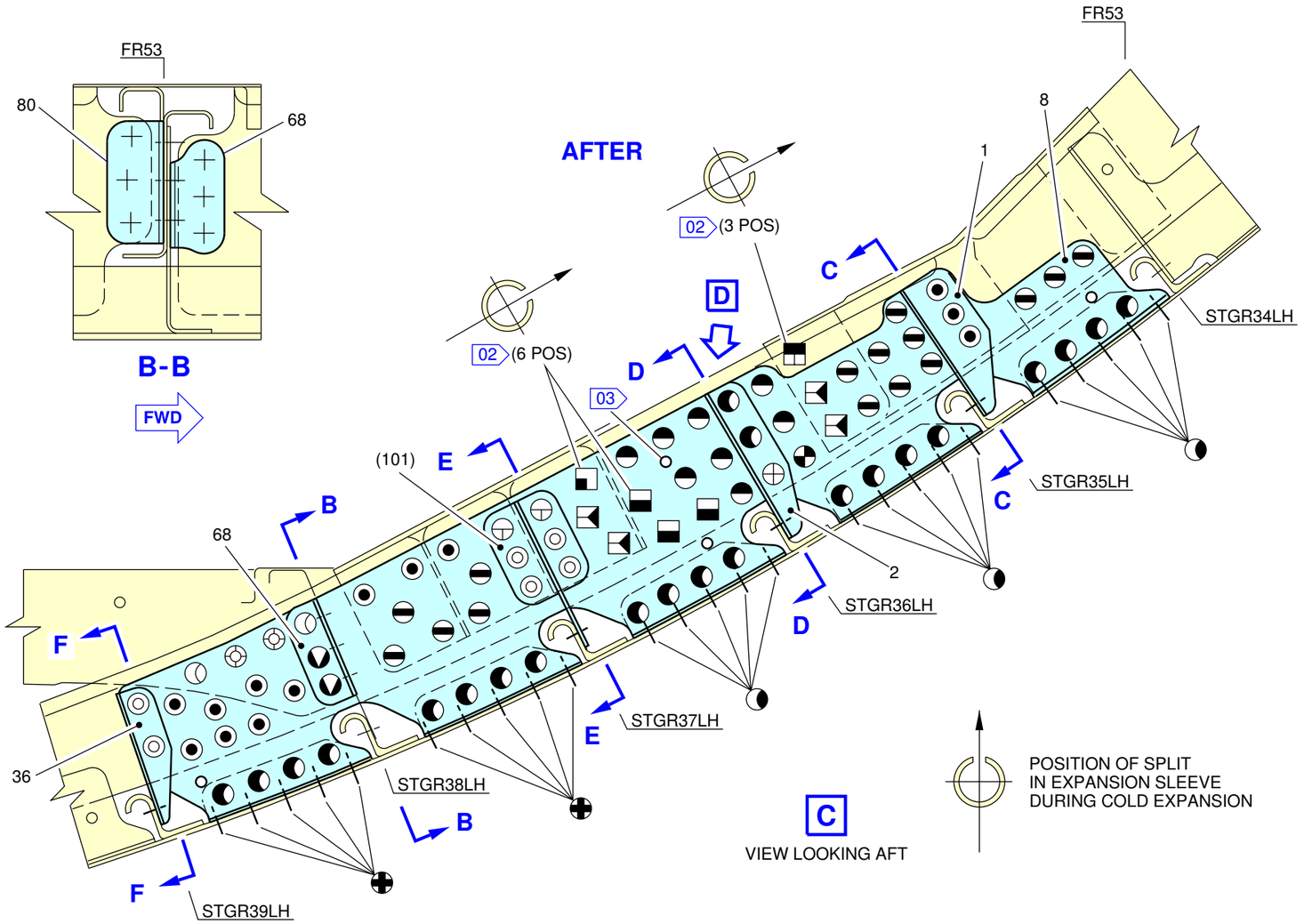
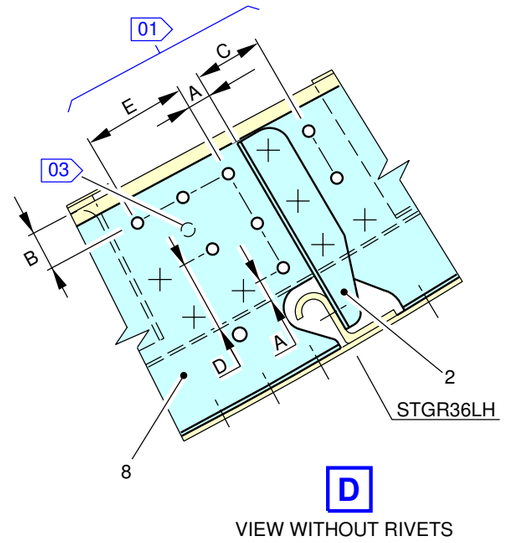
**CONF 006





NOTE:

01 NEW HOLES

02 ▬ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, ◧ ◧ ◧ COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

┼ EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BDAF_02_01

Figure A-GBDAF - Sheet 02
Replacement of Webs and Angles at Frame 53

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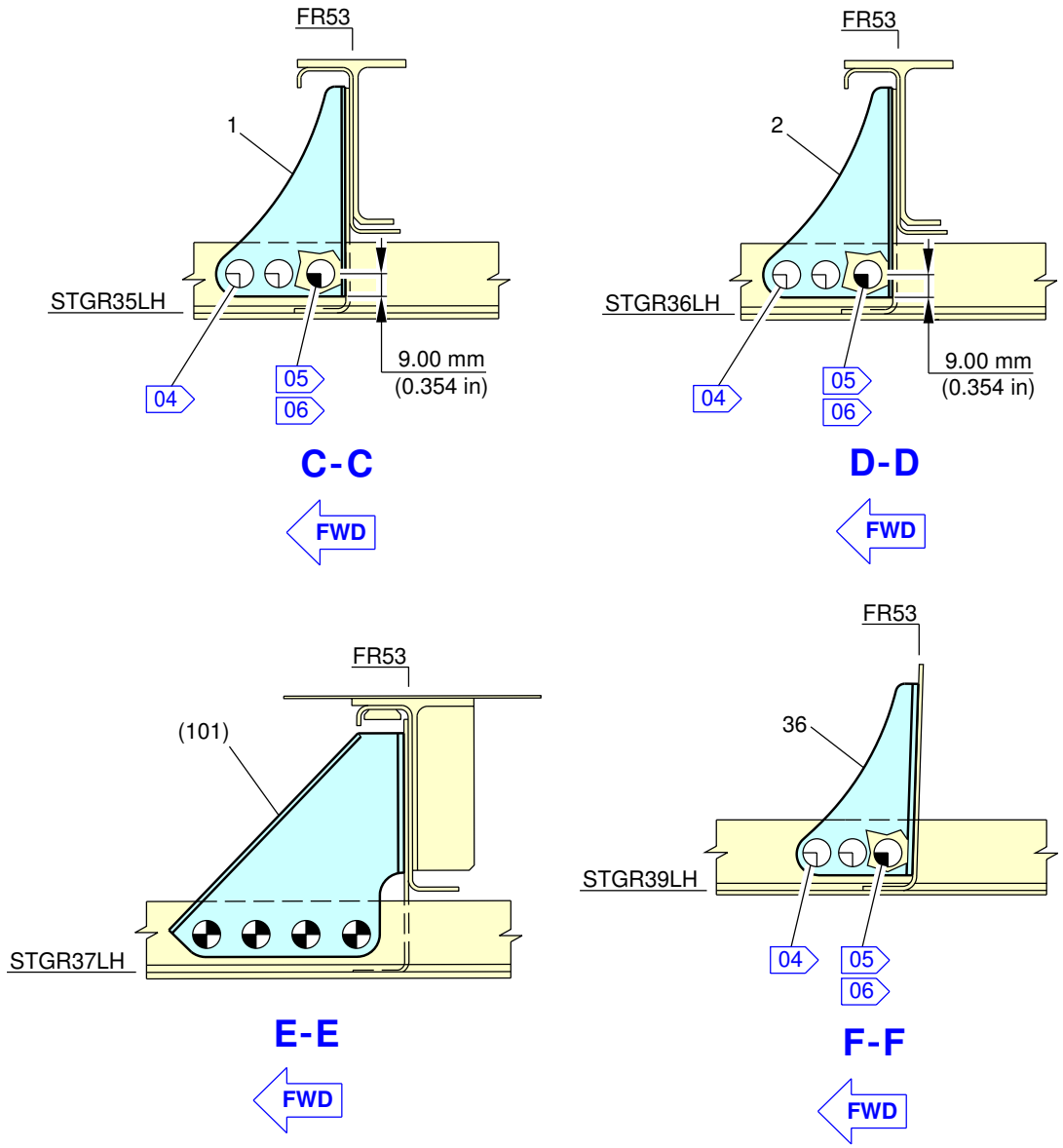
****CONF 006**



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BDAF_03_01

Figure A-GBDAF - Sheet 03
Replacement of Webs and Angles at Frame 53

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**CONF 006

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	873	DAN6–6–3X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	875	DAN6–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	768	DAN5–6–8X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	784	DAN5–6–4Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			

N_SB_531364_6_BDAF_04_01

Figure A-GBDAF - Sheet 04
Replacement of Webs and Angles at Frame 53

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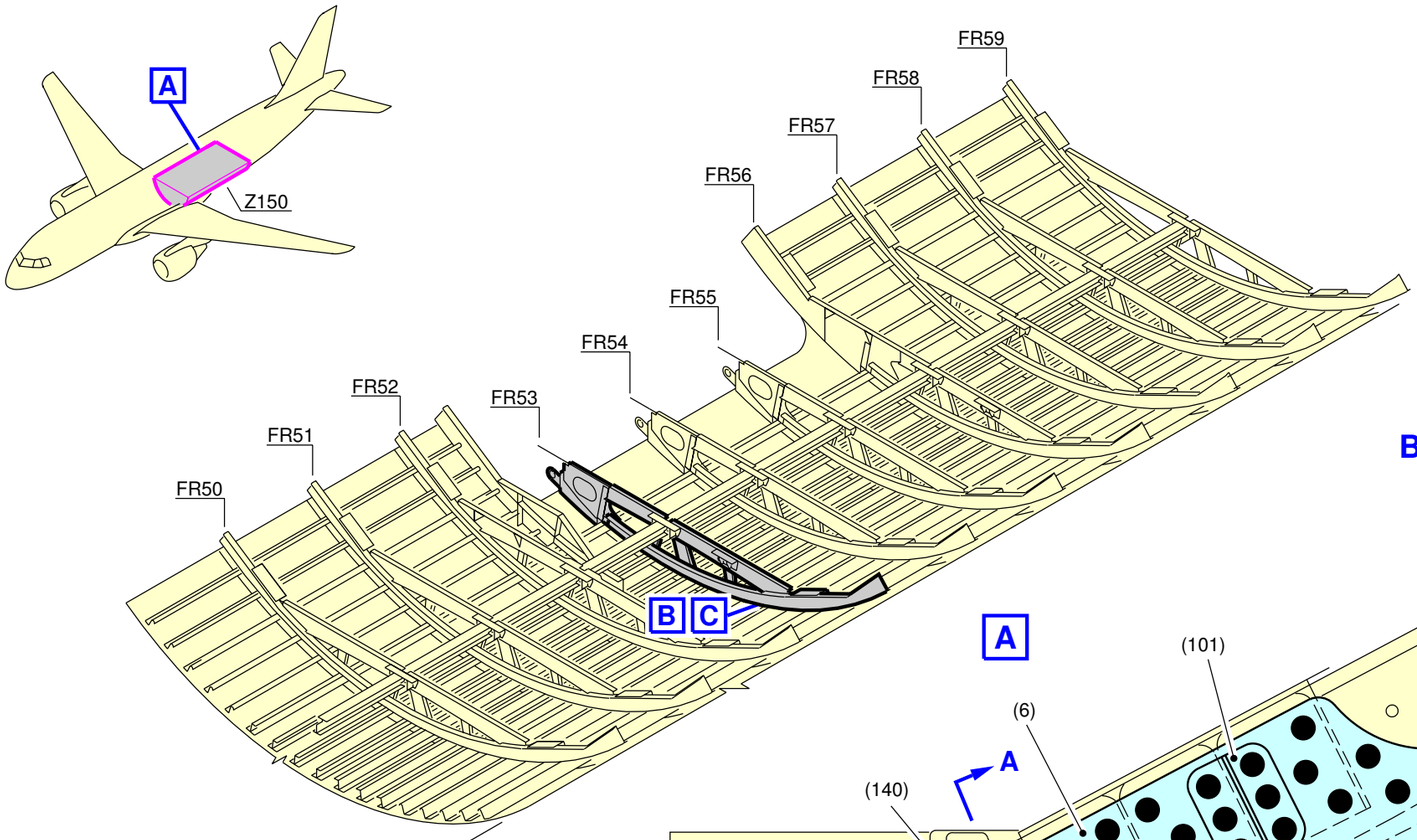
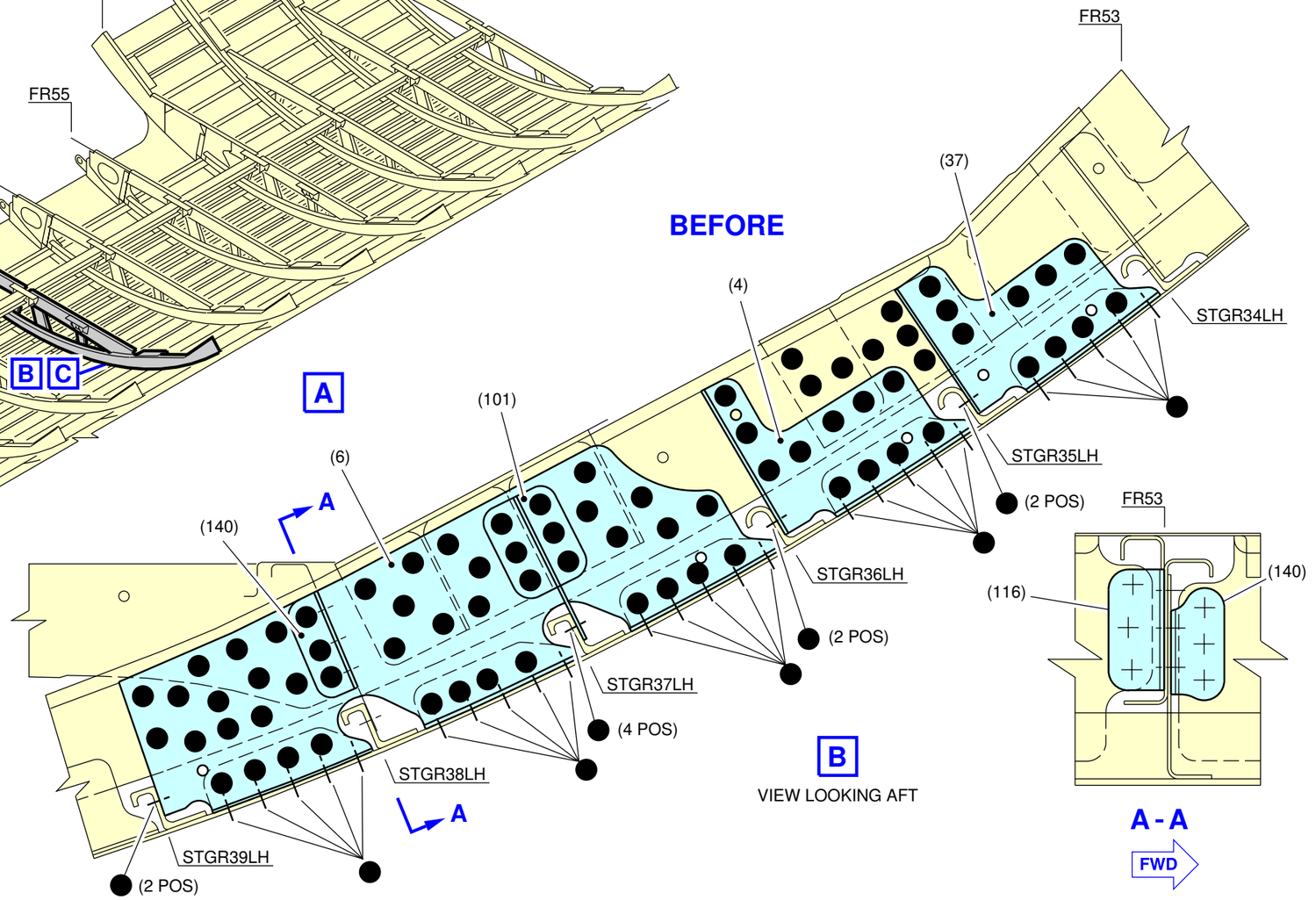
**CONF 007





N_SB_531364_6_BDAG_01_00

NOTE:

● REMOVE RIVETS, ITEM (100)

Figure A-GBDAG - Sheet 01
Replacement of Webs and Angles at Frame 53

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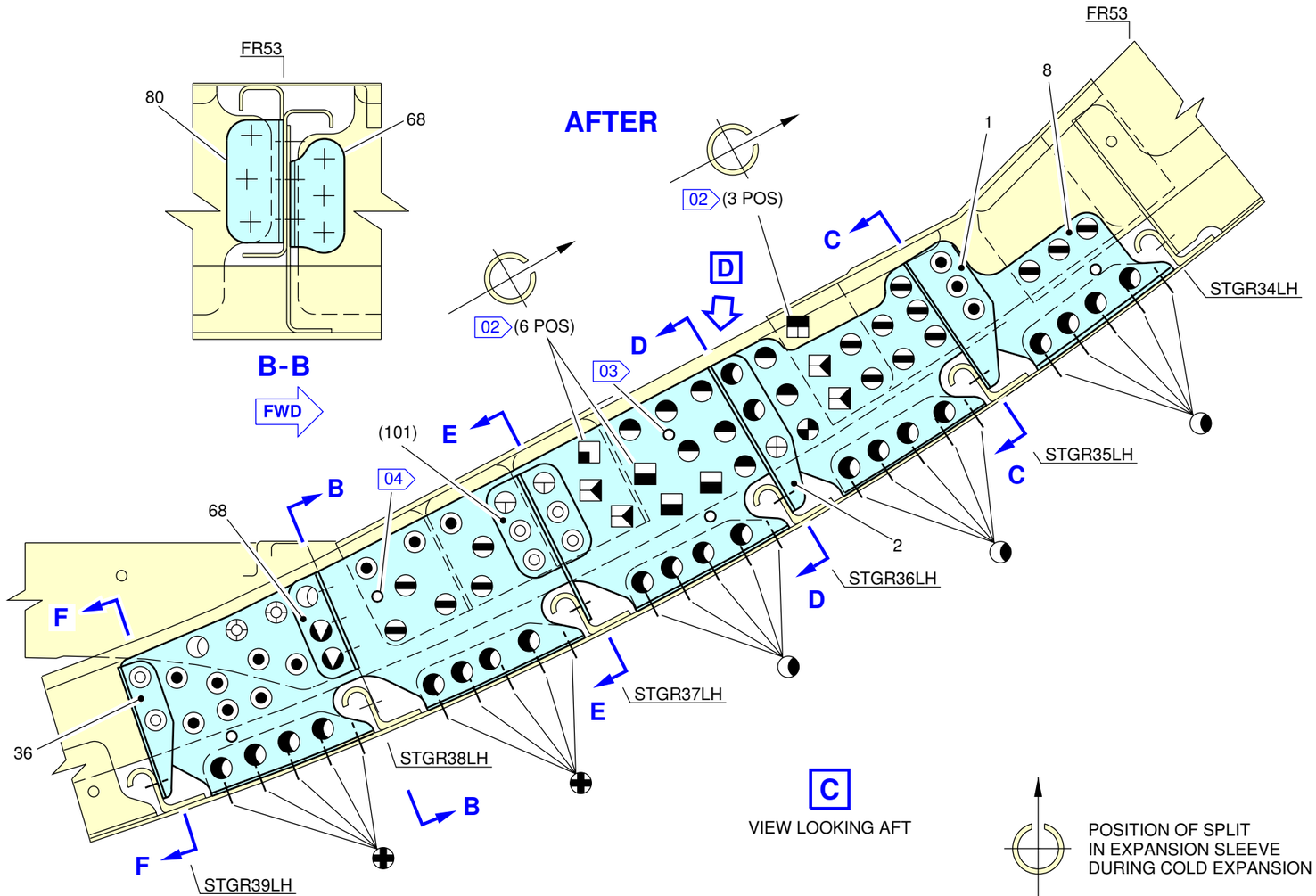
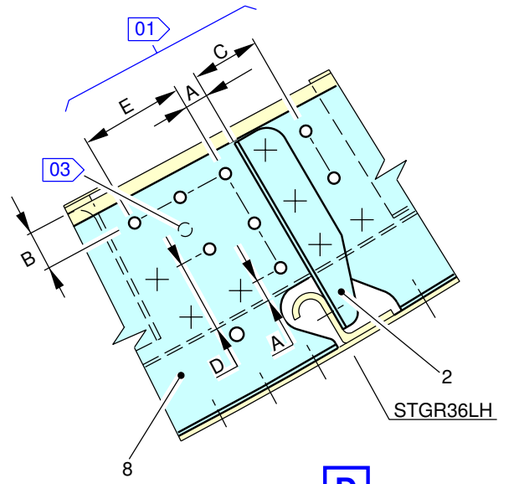
**CONF 007



C
VIEW LOOKING AFT

POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION



D
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	18.00	0.709
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BDAG_02_01

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in), FOR MSN 3999 AND SUBSEQUENT.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

Figure A-GBDAG - Sheet 02
Replacement of Webs and Angles at Frame 53

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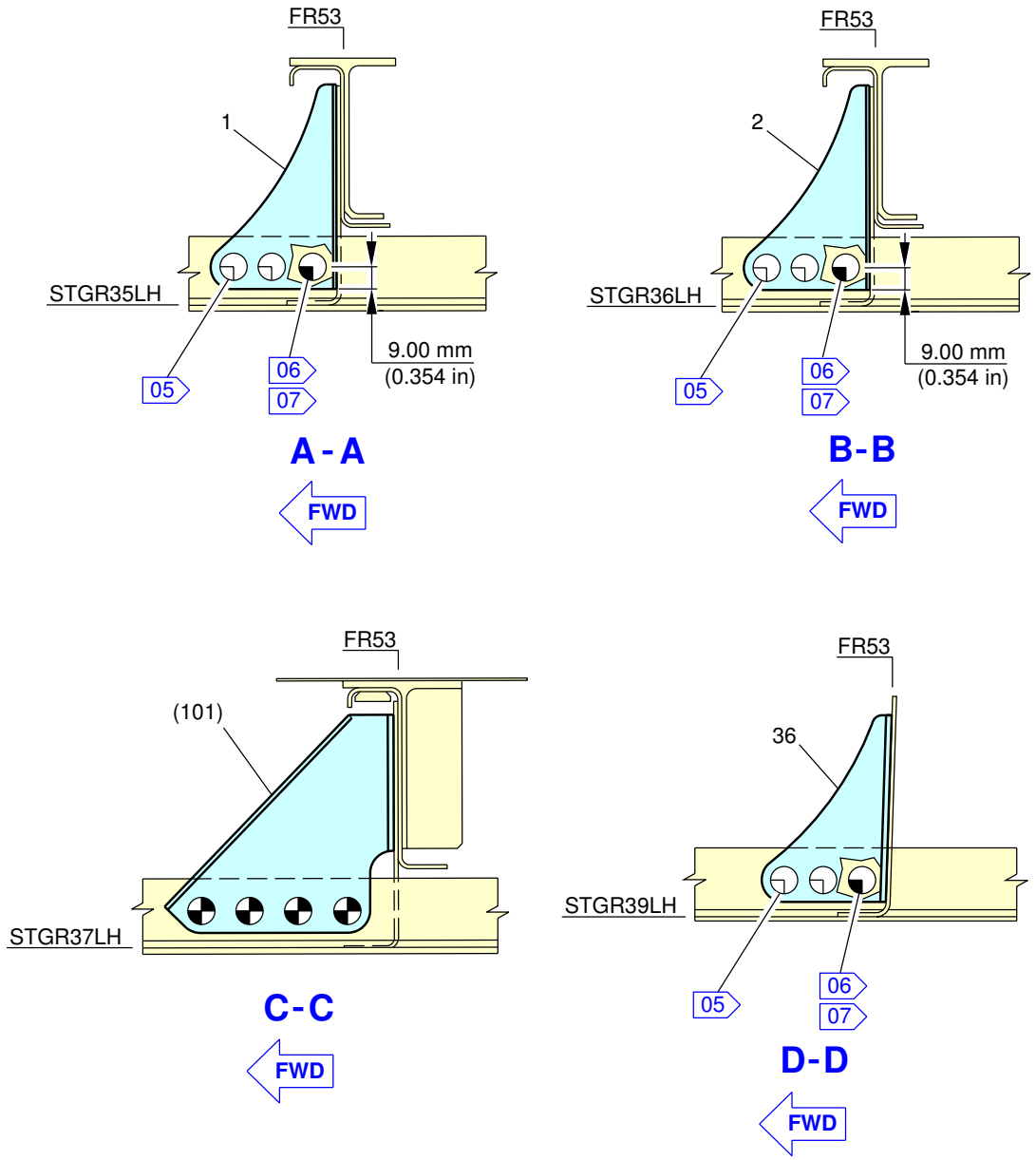
**CONF 007



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BDAG_03_01

Figure A-GBDAG - Sheet 03
Replacement of Webs and Angles at Frame 53

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**CONF 007

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	768	DAN5–6–8	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	784	DAN5–6–4Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	873	DAN6–6–3X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BDAG_04_01

Figure A-GBDAG - Sheet 04
Replacement of Webs and Angles at Frame 53

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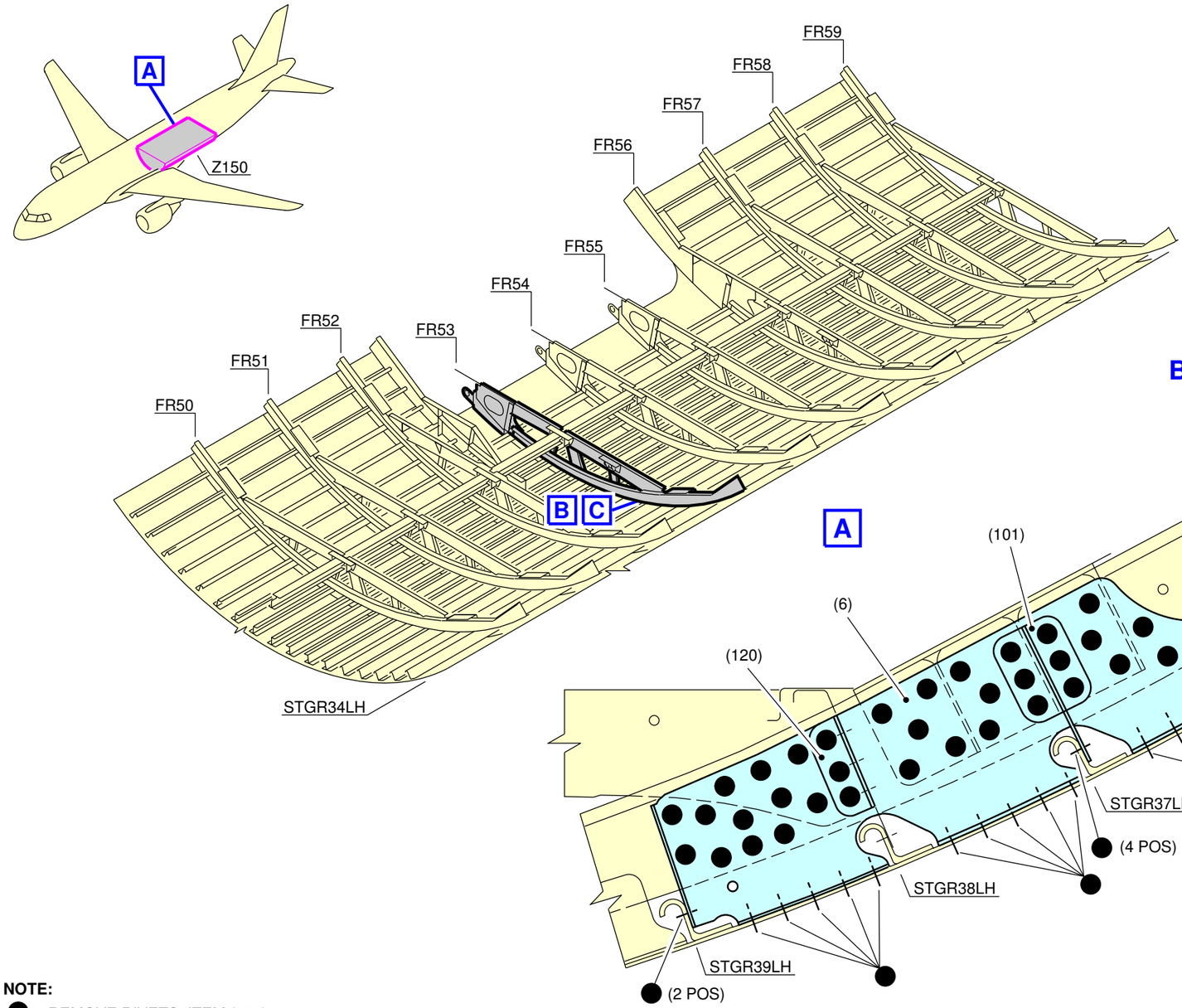
**CONF 008



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BDAH_01_00

Figure A-GBDAH - Sheet 01
Replacement of Webs and Angles at Frame 53

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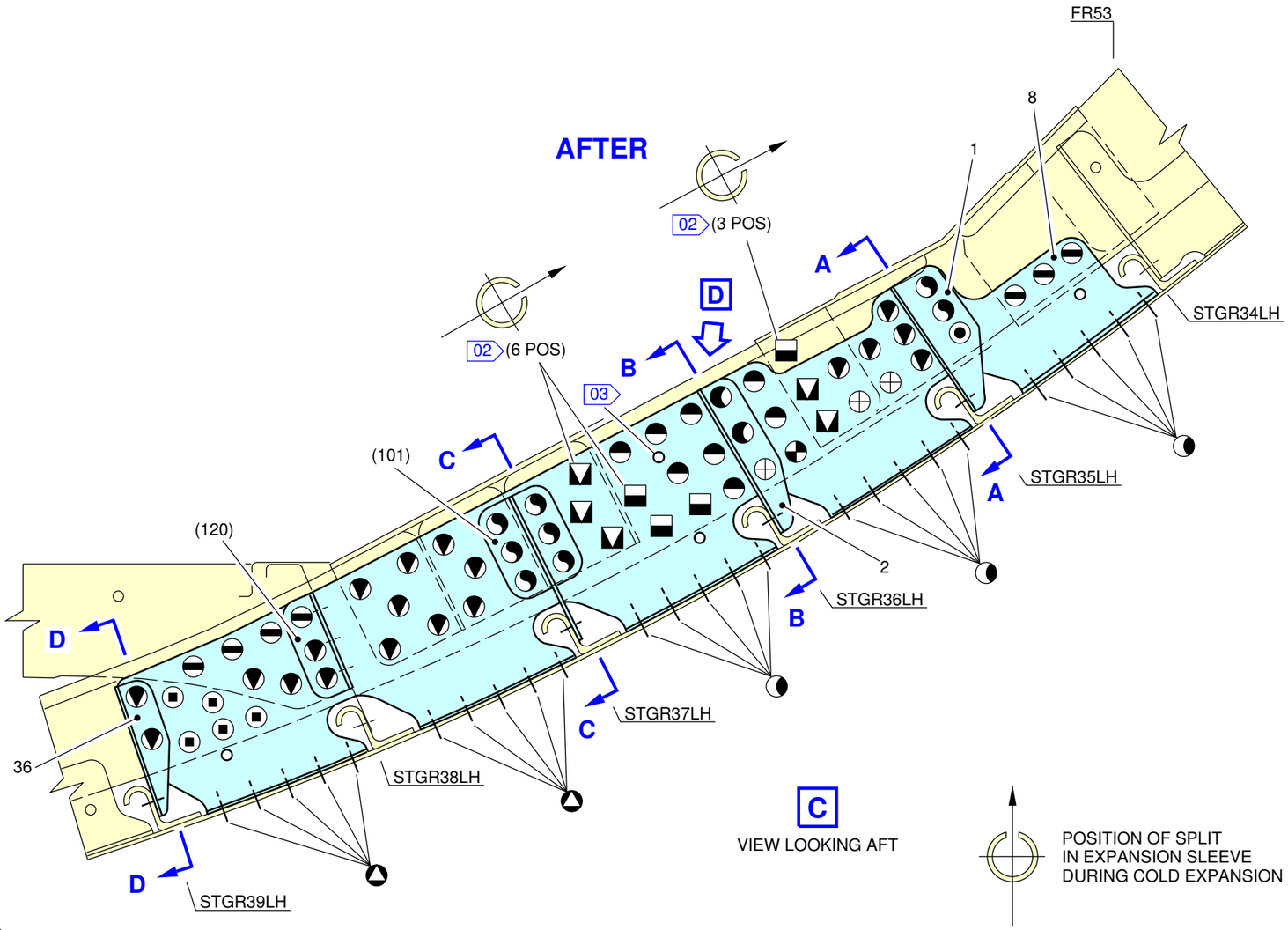
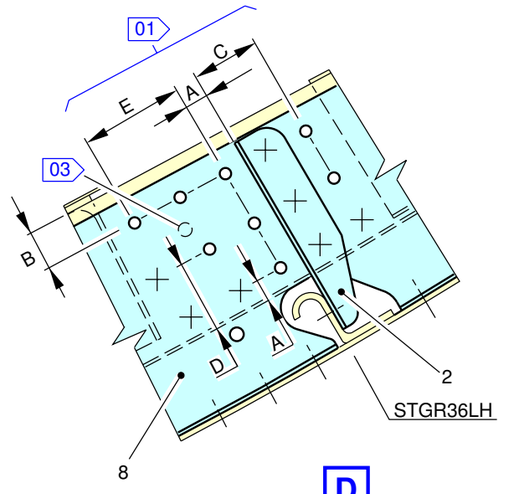
**CONF 008



C
VIEW LOOKING AFT

POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION



D
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BDAH_02_01

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

Figure A-GBDAH - Sheet 02
Replacement of Webs and Angles at Frame 53

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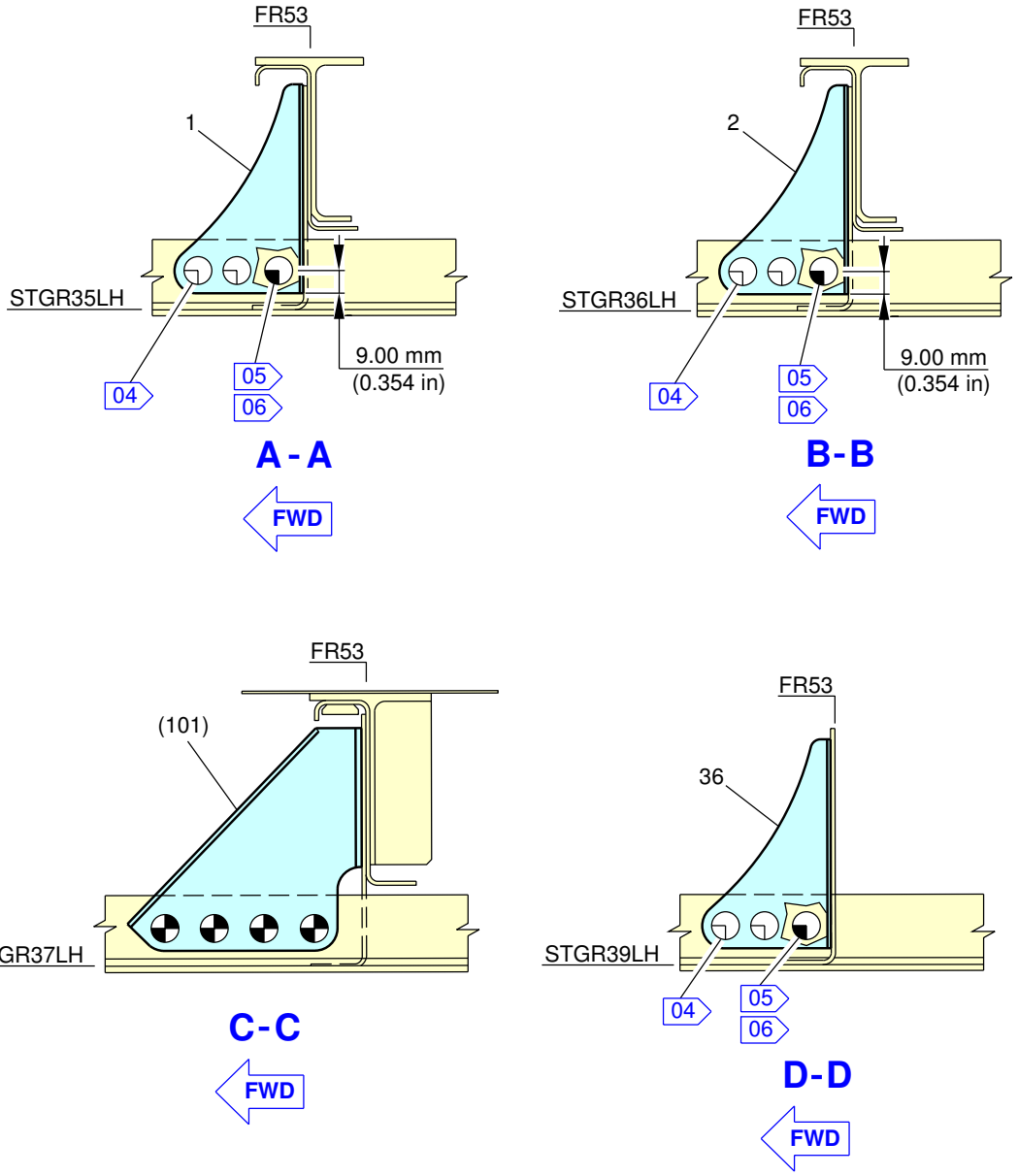
**CONF 008



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BDAH_03_01

Figure A-GBDAH - Sheet 03
Replacement of Webs and Angles at Frame 53

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**CONF 008

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BDAH_04_01

Figure A-GBDAH - Sheet 04
Replacement of Webs and Angles at Frame 53

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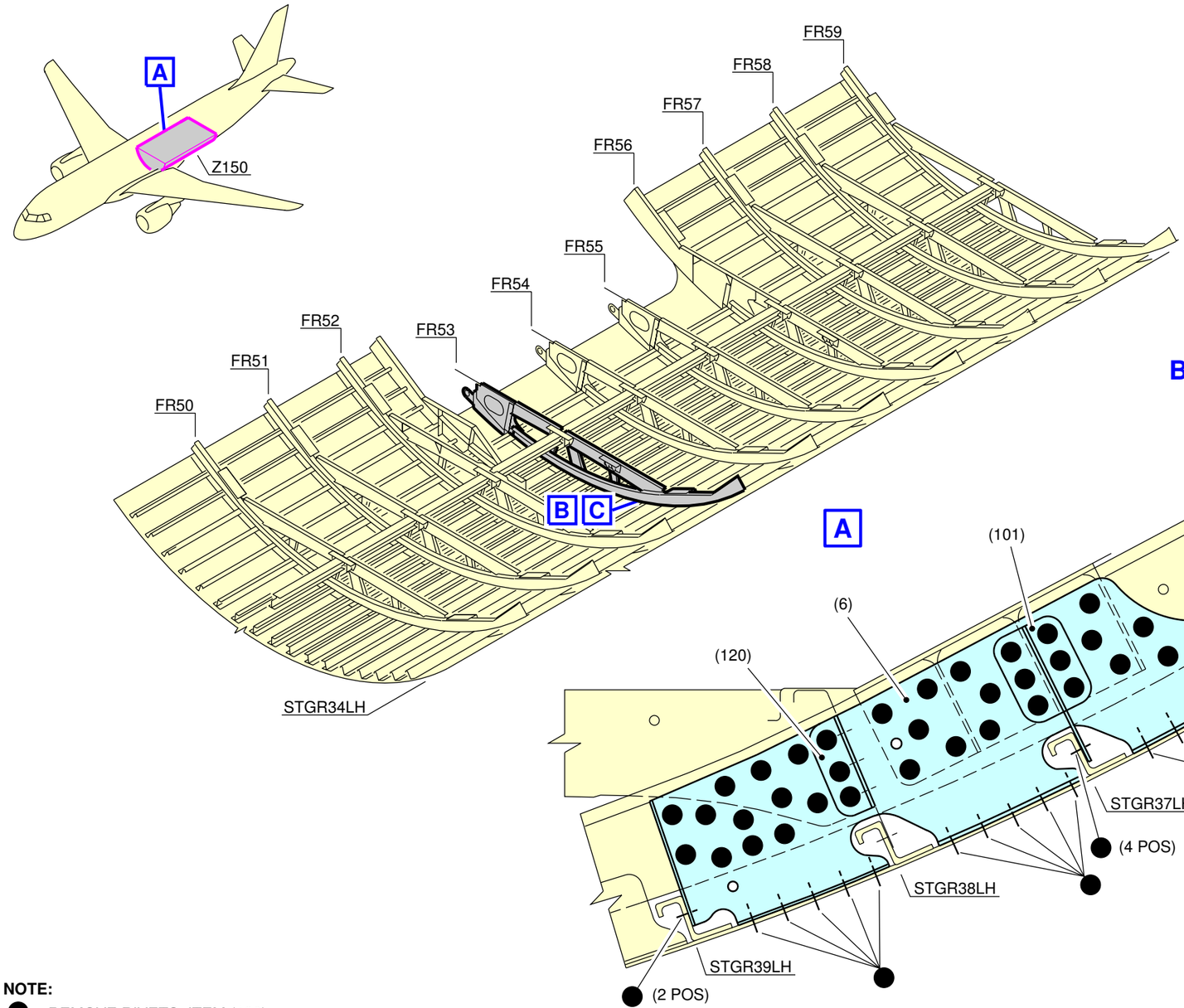
**CONF 009



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BDAJ_01_00

Figure A-GBDAJ - Sheet 01
Replacement of Webs and Angles at Frame 53

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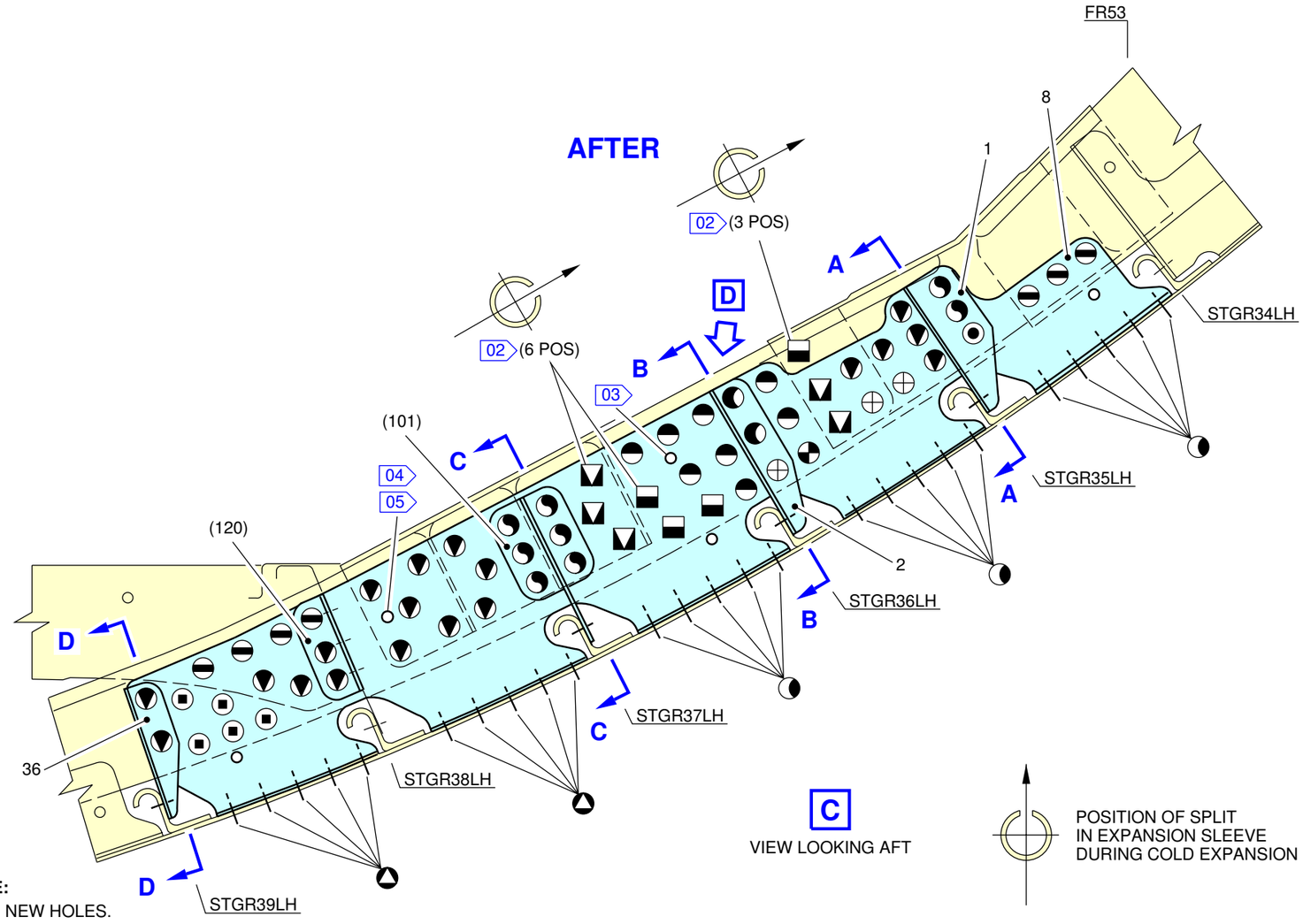
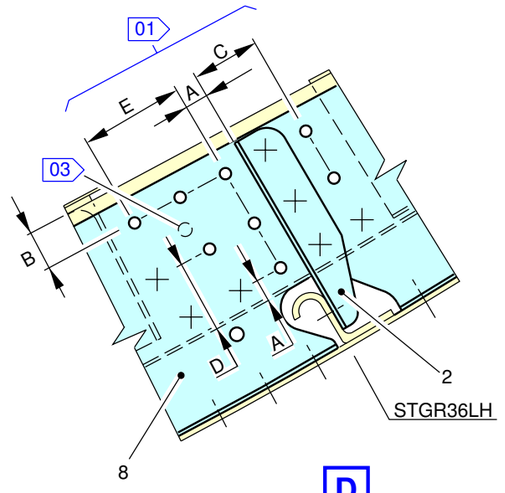
**CONF 009



C
VIEW LOOKING AFT

POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION



D
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BDAJ_02_01

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in).

05 VALID FOR MSN 4005 AND SUBSEQUENT.

+ EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

Figure A-GBDAJ - Sheet 02
Replacement of Webs and Angles at Frame 53

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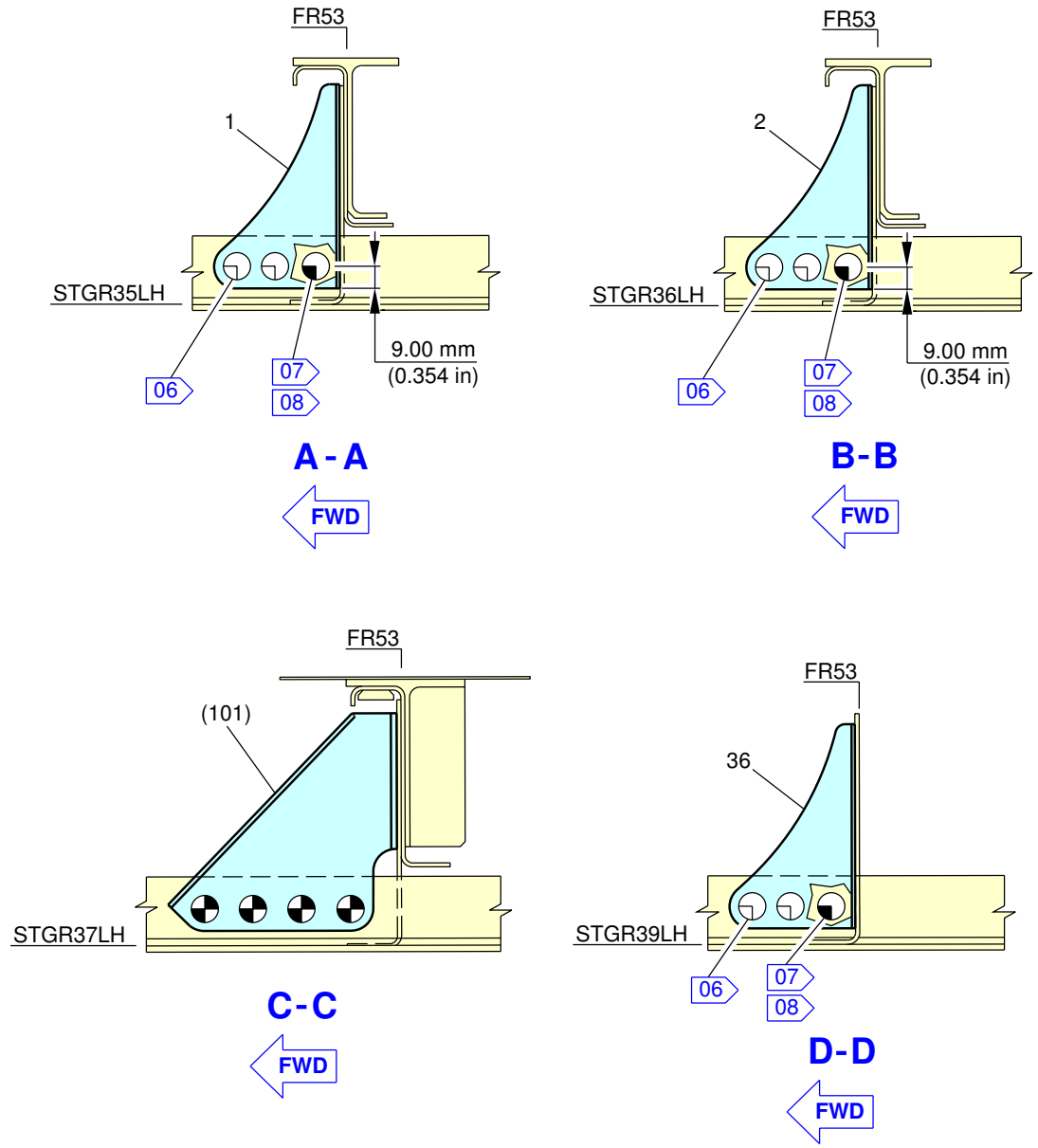
**CONF 009



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BDAJ_03_01

Figure A-GBDAJ - Sheet 03
Replacement of Webs and Angles at Frame 53

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**CONF 009

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BDAJ_04_01

Figure A-GBDAJ - Sheet 04
Replacement of Webs and Angles at Frame 53

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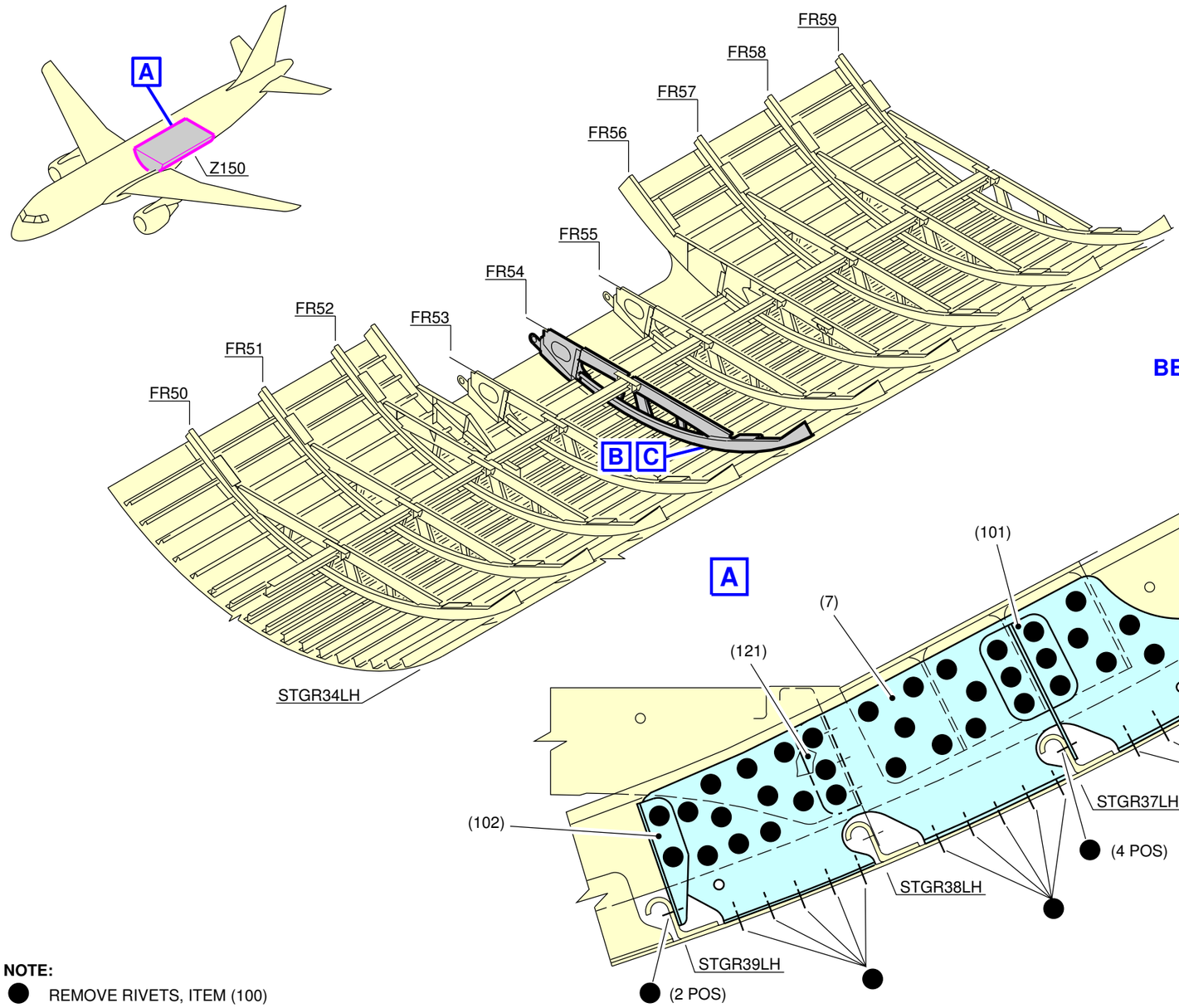
**CONF 001



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BEAA_01_00

Figure A-GBEAA - Sheet 01
Replacement of Webs and Angles at Frame 54

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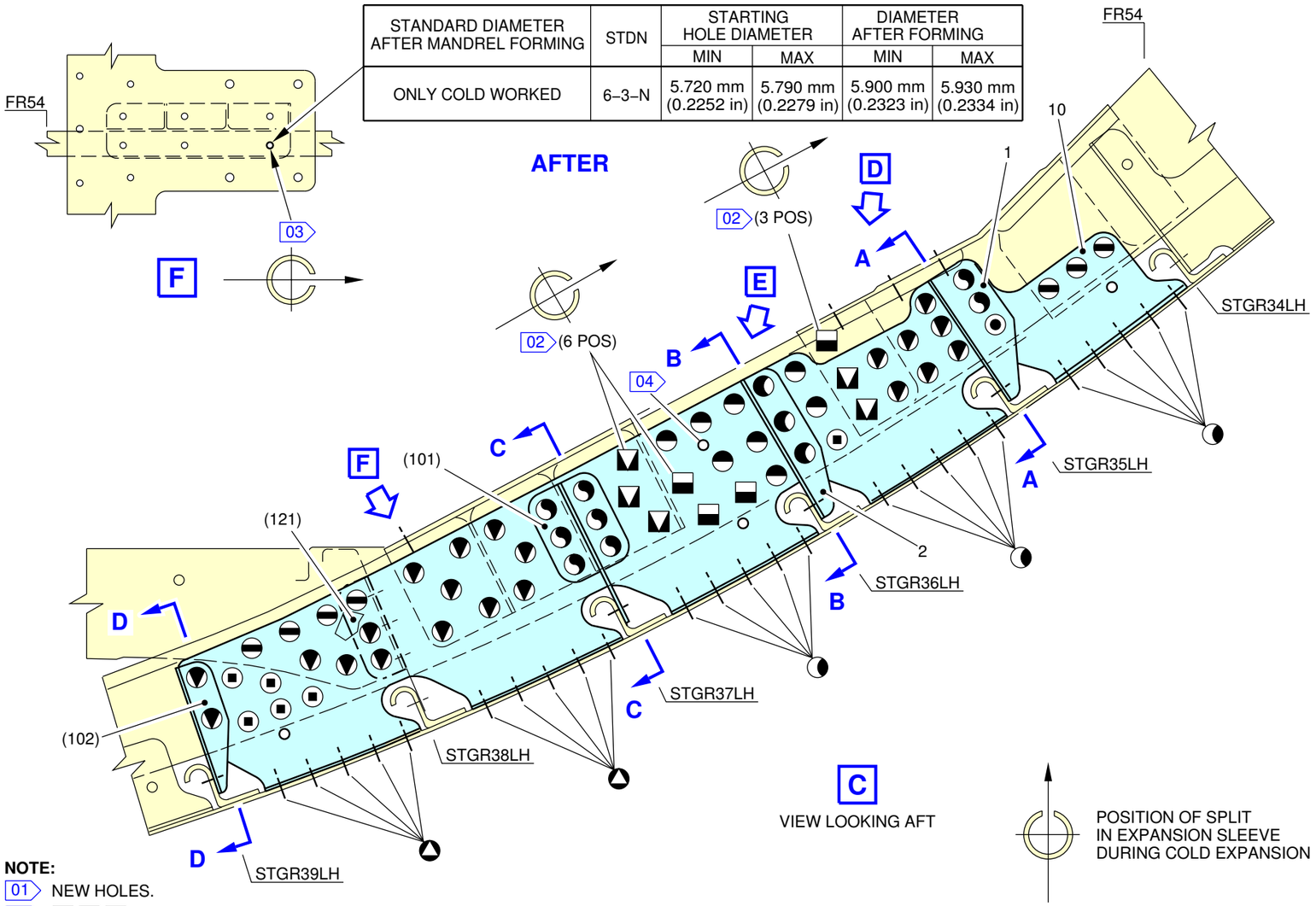
**CONF 001

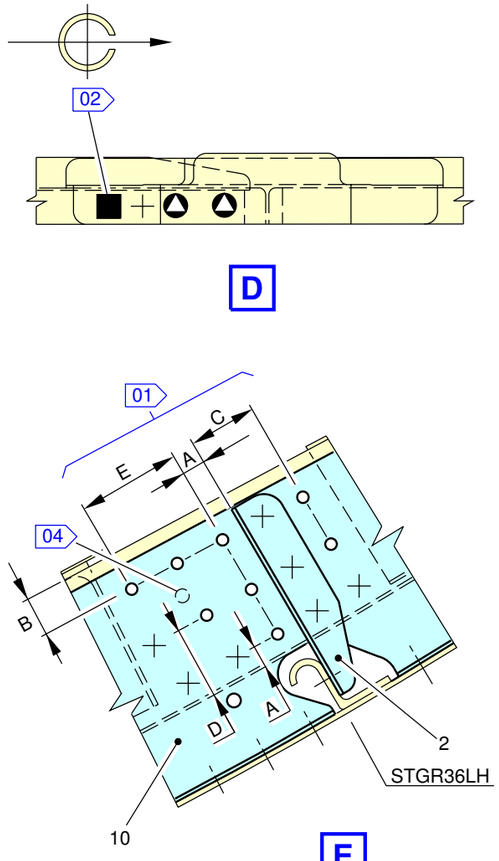
STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



C

VIEW LOOKING AFT

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION



E

VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BEAA_02_01

Figure A-GBEAA - Sheet 02
Replacement of Webs and Angles at Frame 54

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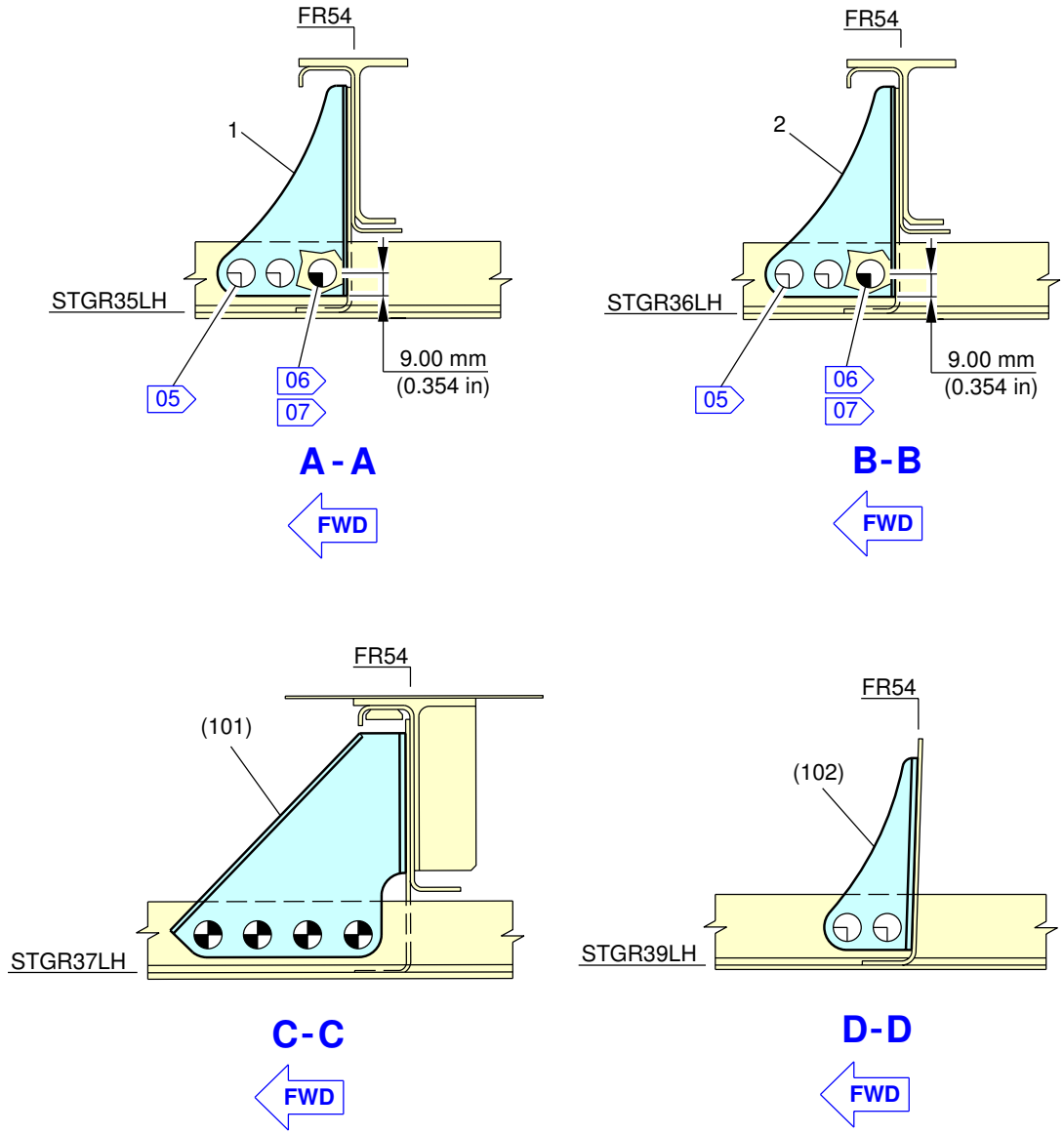
**CONF 001



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BEAA_03_01

Figure A-GBEAA - Sheet 03
Replacement of Webs and Angles at Frame 54

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**CONF 001

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
◒	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
▽	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
■	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
◕	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◑	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◓	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◵	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◙	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◐	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
▼	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◔	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
⊖	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
◉	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
▲	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
◕	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BEAA_04_01

Figure A-GBEAA - Sheet 04
Replacement of Webs and Angles at Frame 54

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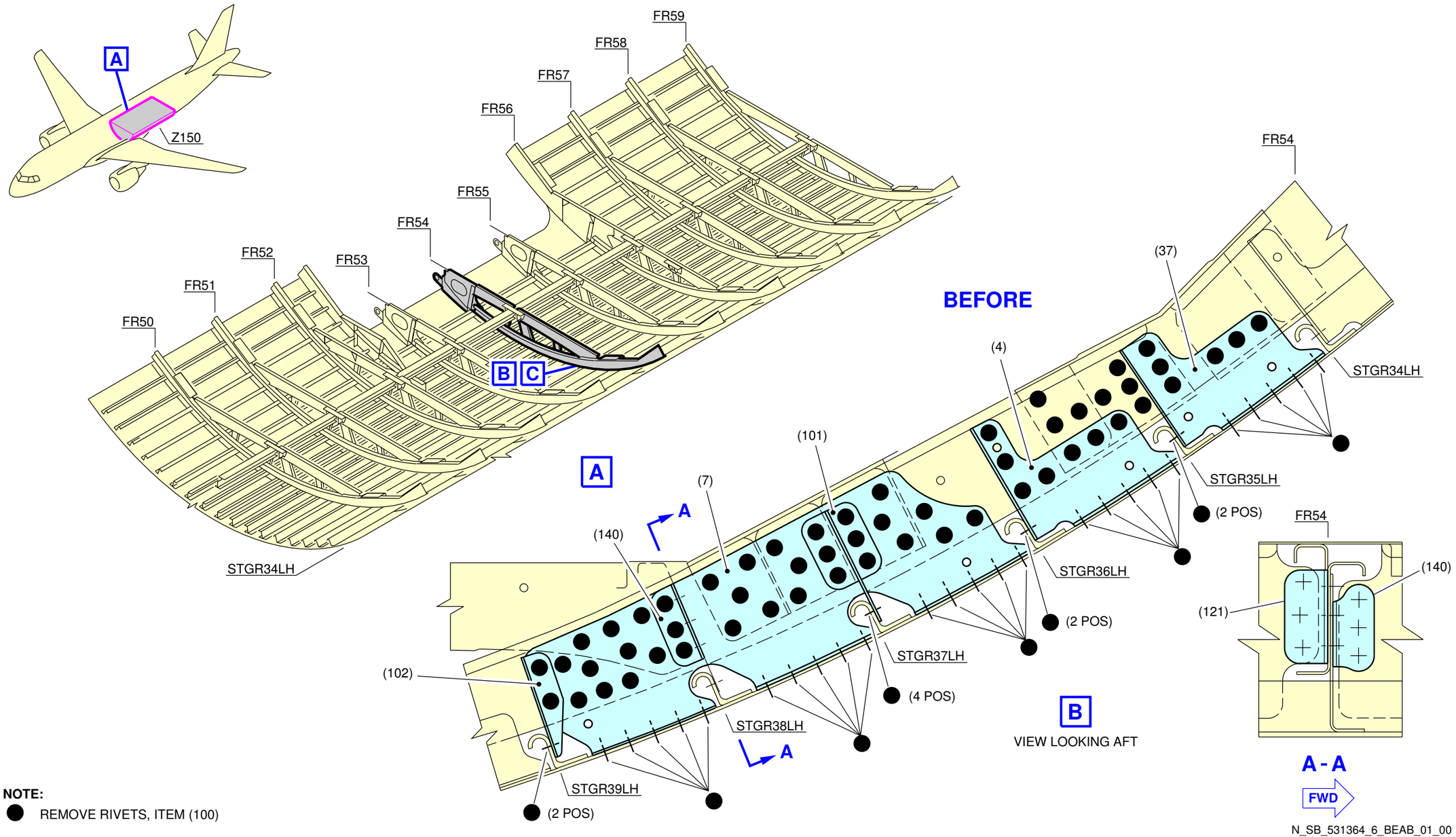
**CONF 002



NOTE:

● REMOVE RIVETS, ITEM (100)

Figure A-GBEAB - Sheet 01
Replacement of Webs and Angles at Frame 54

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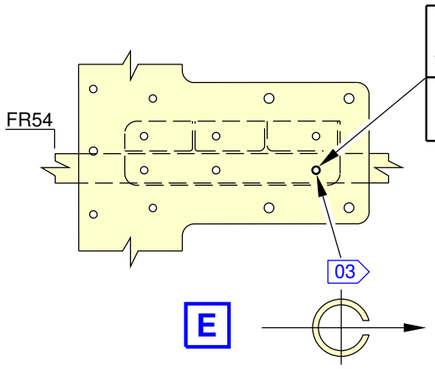
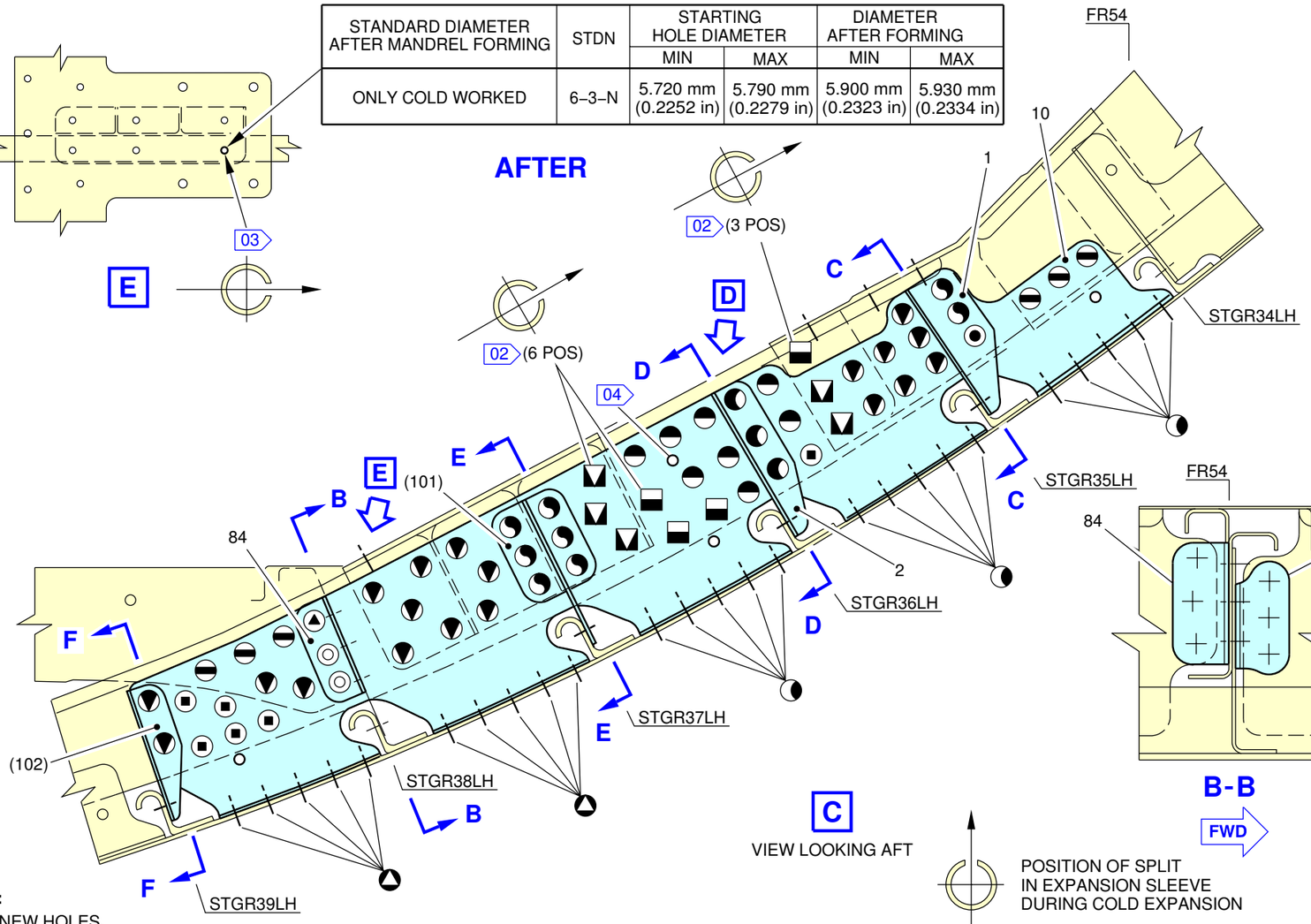
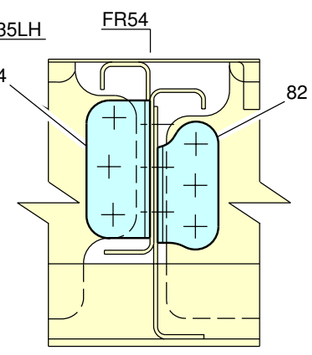
**CONF 002

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



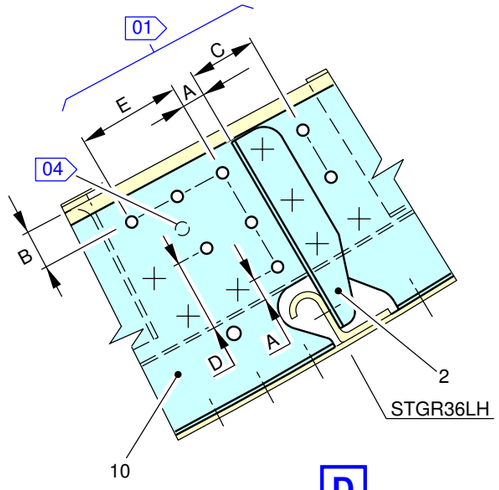
AFTER





B-B

FWD

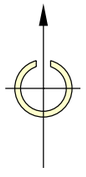


D

VIEW WITHOUT RIVETS

C

VIEW LOOKING AFT



POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES.

02 ◥◤ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

┼ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BEAB_02_01

Figure A-GBEAB - Sheet 02
Replacement of Webs and Angles at Frame 54

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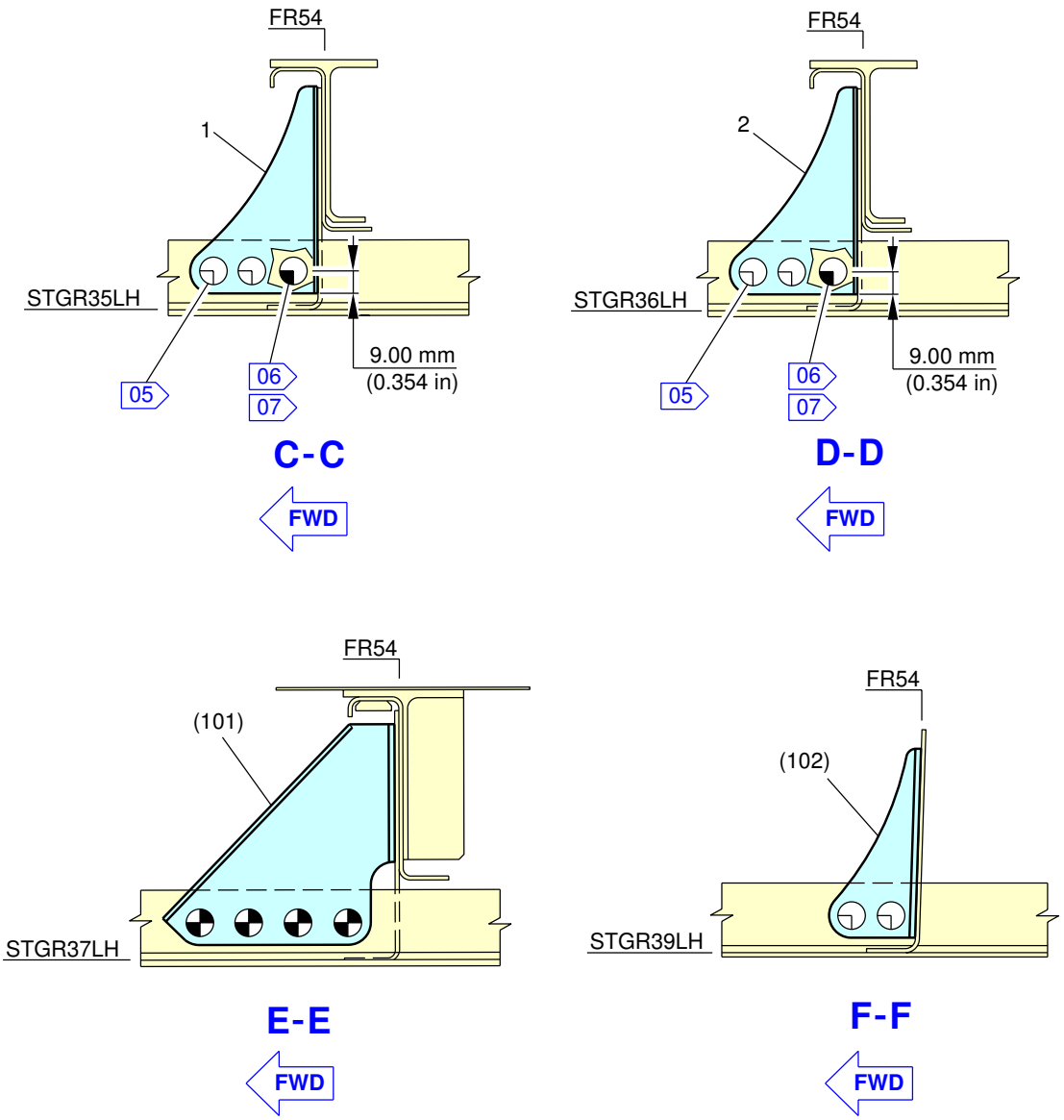
**CONF 002



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BEAB_03_01

Figure A-GBEAB - Sheet 03
Replacement of Webs and Angles at Frame 54

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**CONF 002

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
⬓	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
⬙	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
◒	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◑	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◓	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◱	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◉	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◐	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
⬙	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◔	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
⊖	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
◉	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
◎	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
▲	786	DAN5–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
◬	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
◕	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BEAB_04_01

Figure A-GBEAB - Sheet 04
Replacement of Webs and Angles at Frame 54

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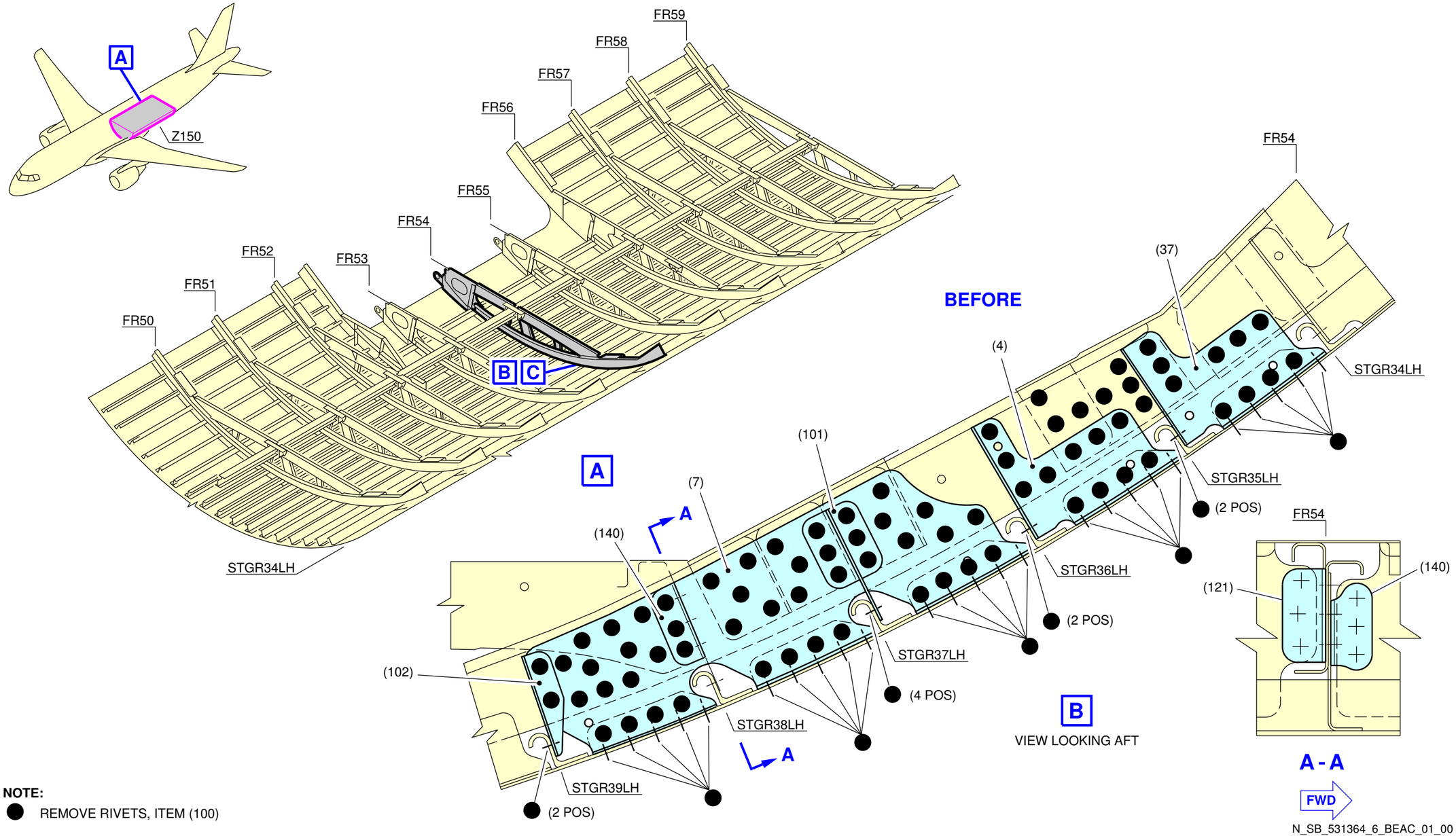
**CONF 003



N_SB_531364_6_BEAC_01_00

NOTE:

● REMOVE RIVETS, ITEM (100)

Figure A-GBEAC - Sheet 01
Replacement of Webs and Angles at Frame 54

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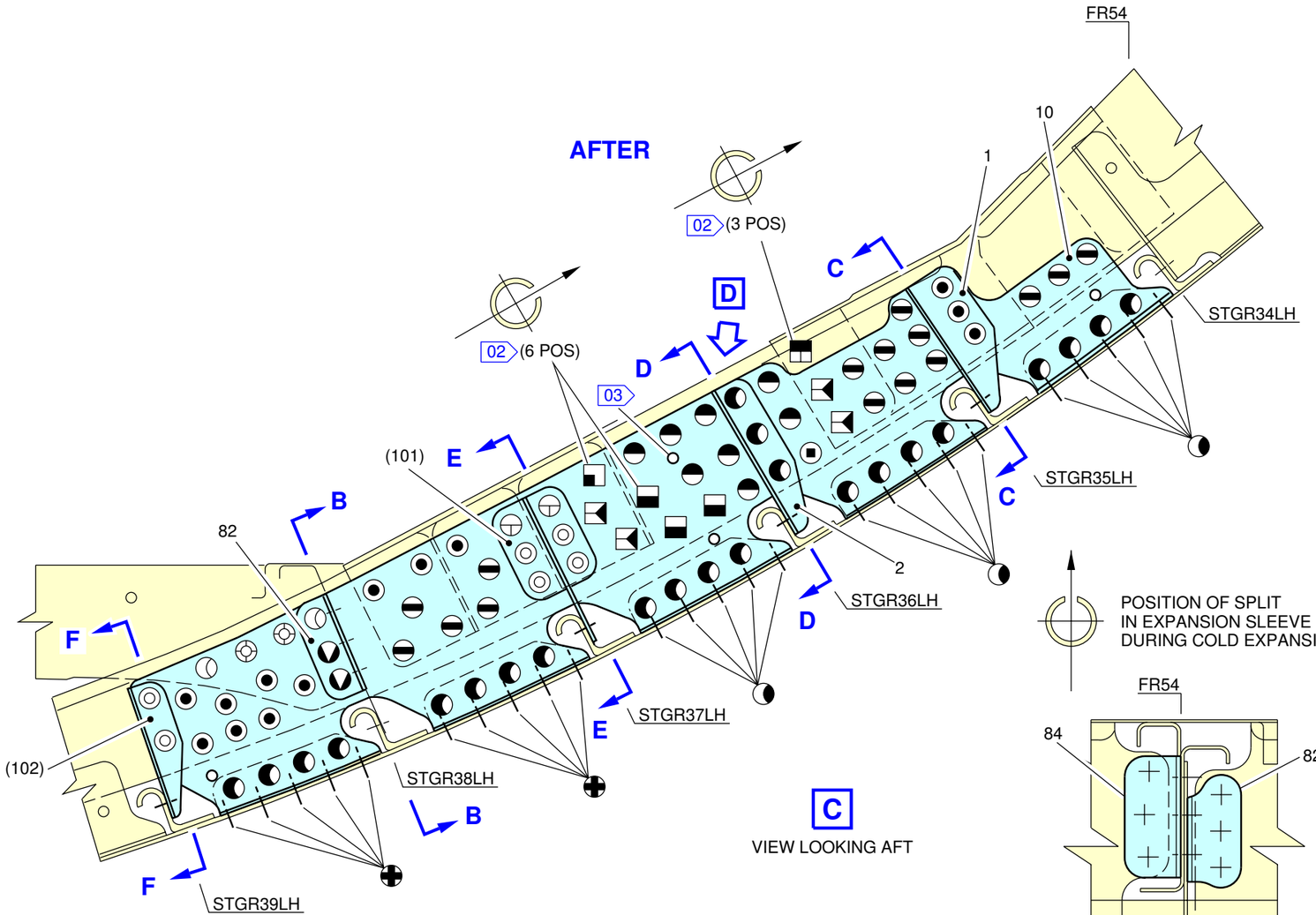
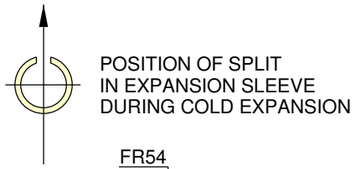
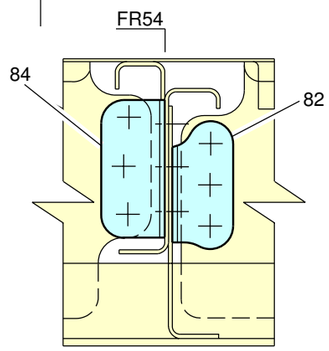
**CONF 003



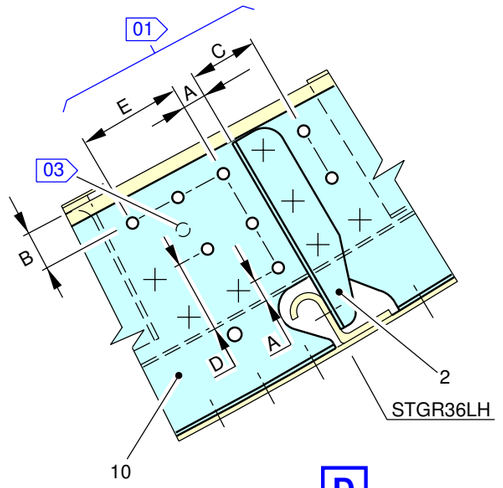
C
VIEW LOOKING AFT





B-B

FWD



D
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BEAC_02_01

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

Figure A-GBEAC - Sheet 02
Replacement of Webs and Angles at Frame 54

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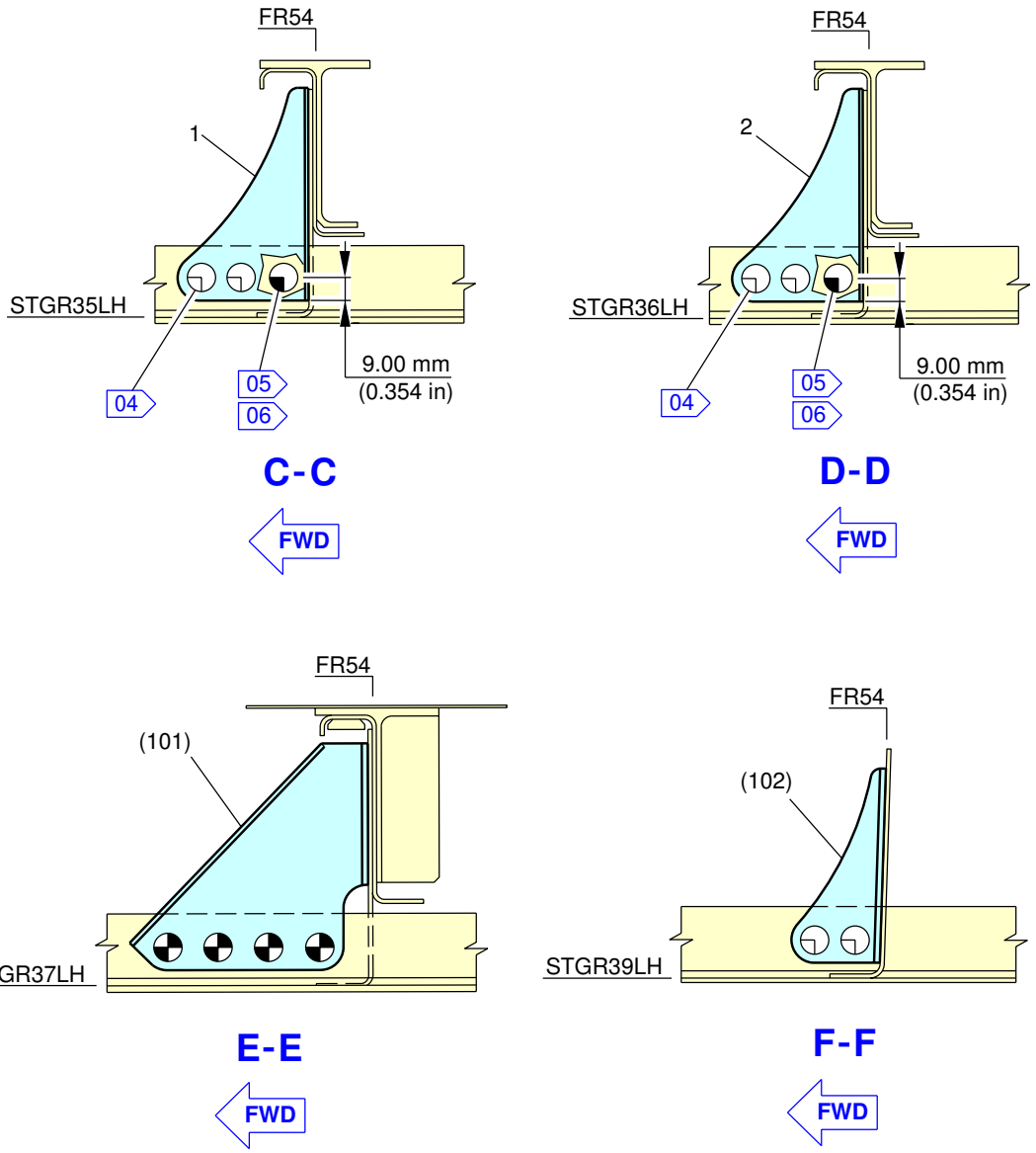
**CONF 003



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BEAC_03_01

Figure A-GBEAC - Sheet 03
Replacement of Webs and Angles at Frame 54

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**CONF 003

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	768	DAN5–6–8X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	784	DAN5–6–4Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	873	DAN6–6–3X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BEAC_04_01

Figure A-GBEAC - Sheet 04
Replacement of Webs and Angles at Frame 54

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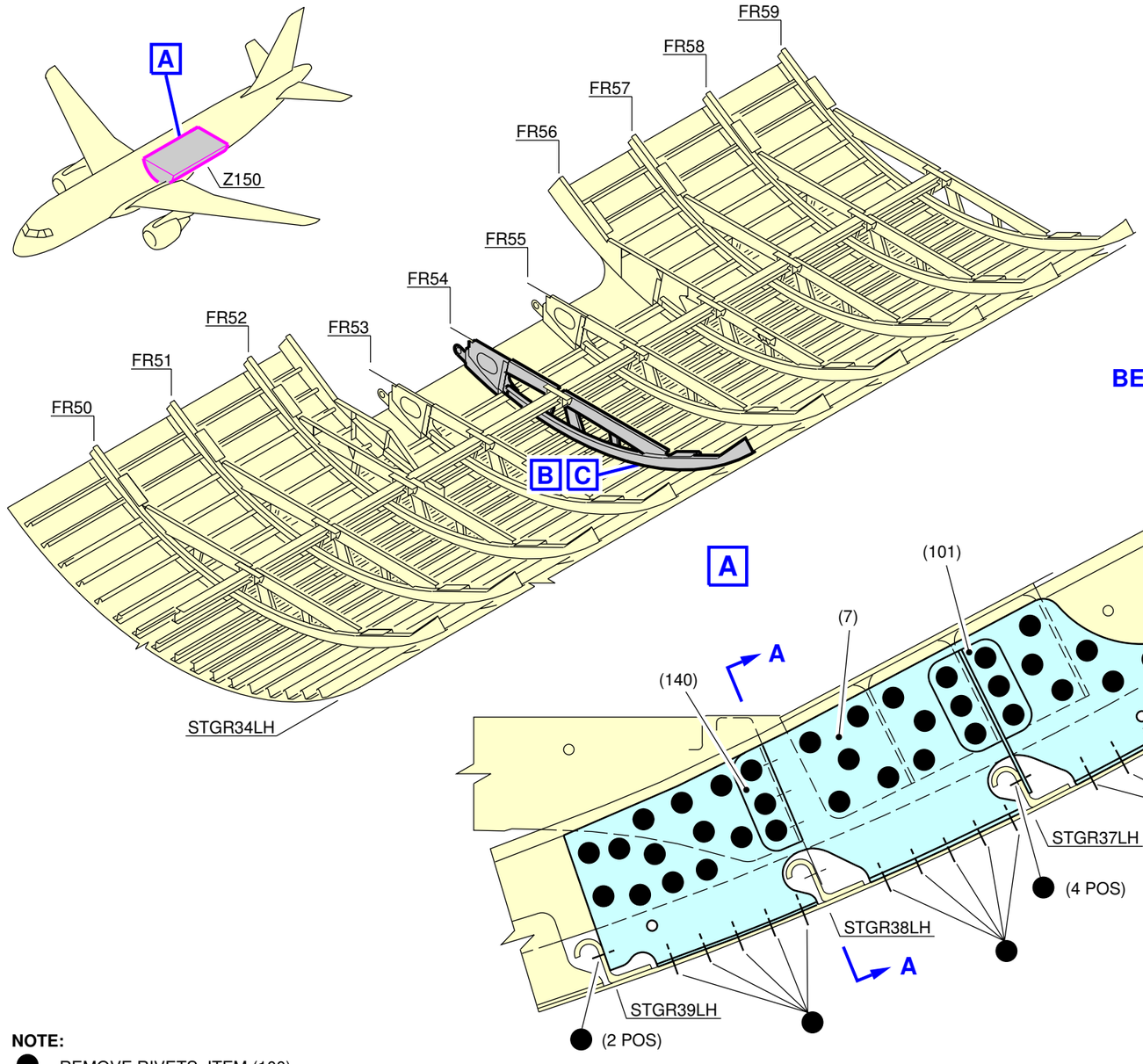
**CONF 004



N_SB_531364_6_BEAD_01_00

NOTE:

● REMOVE RIVETS, ITEM (100)

Figure A-GBEAD - Sheet 01
Replacement of Webs and Angles at Frame 54

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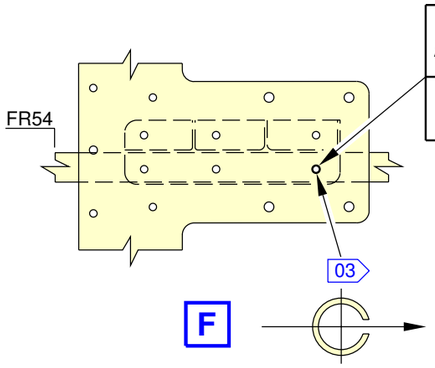
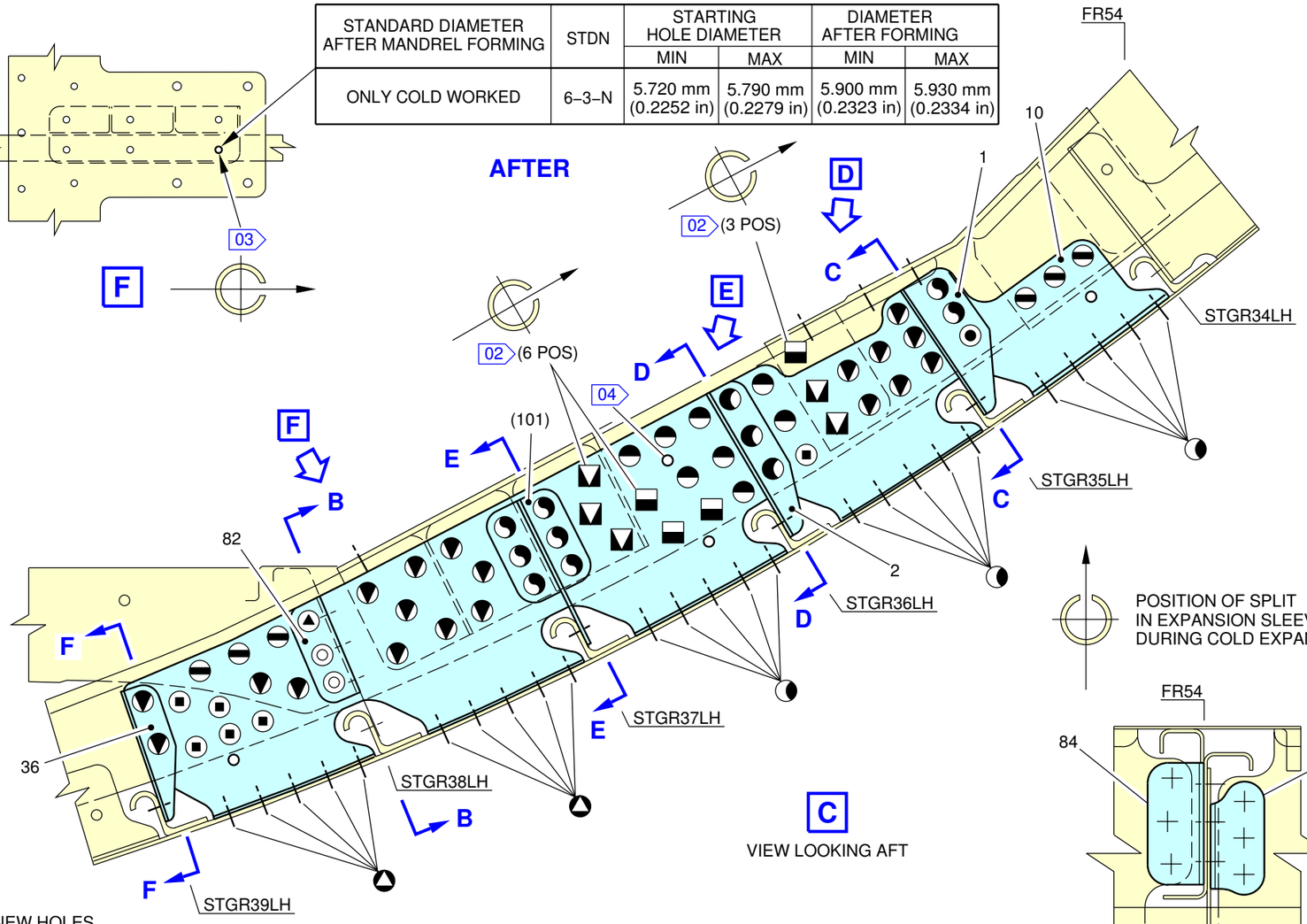
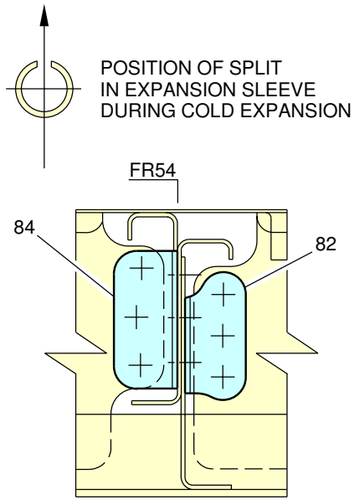
**CONF 004

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)

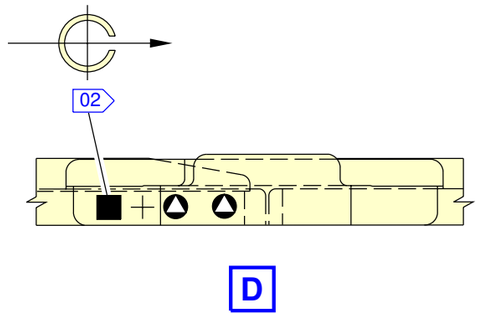


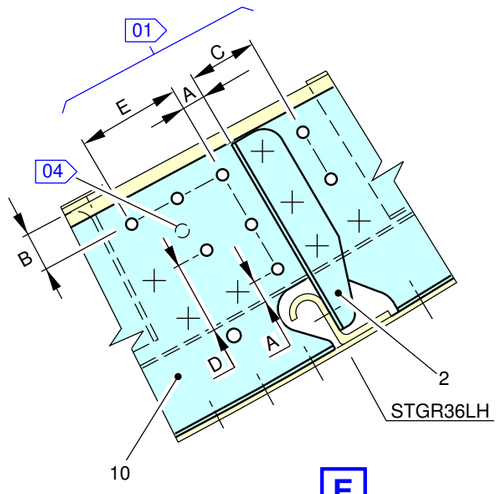


C
VIEW LOOKING AFT



B-B
FWD





E
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BEAD_02_01

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

Figure A-GBEAD - Sheet 02
Replacement of Webs and Angles at Frame 54

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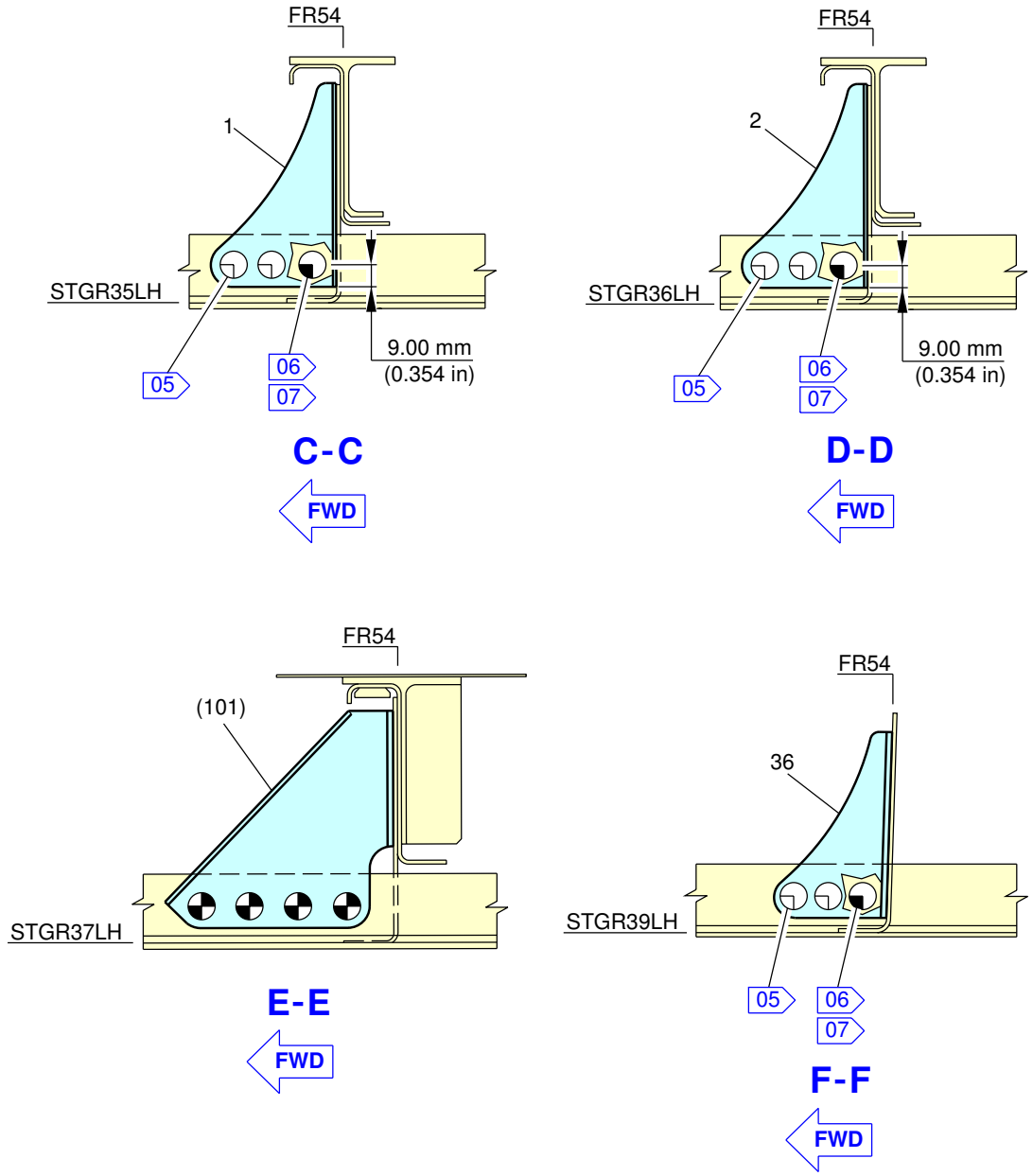
****CONF 004**



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BEAD_03_01

Figure A-GBEAD - Sheet 03
Replacement of Webs and Angles at Frame 54

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**CONF 004

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	786	DAN5–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BEAD_04_01

Figure A-GBEAD - Sheet 04
Replacement of Webs and Angles at Frame 54

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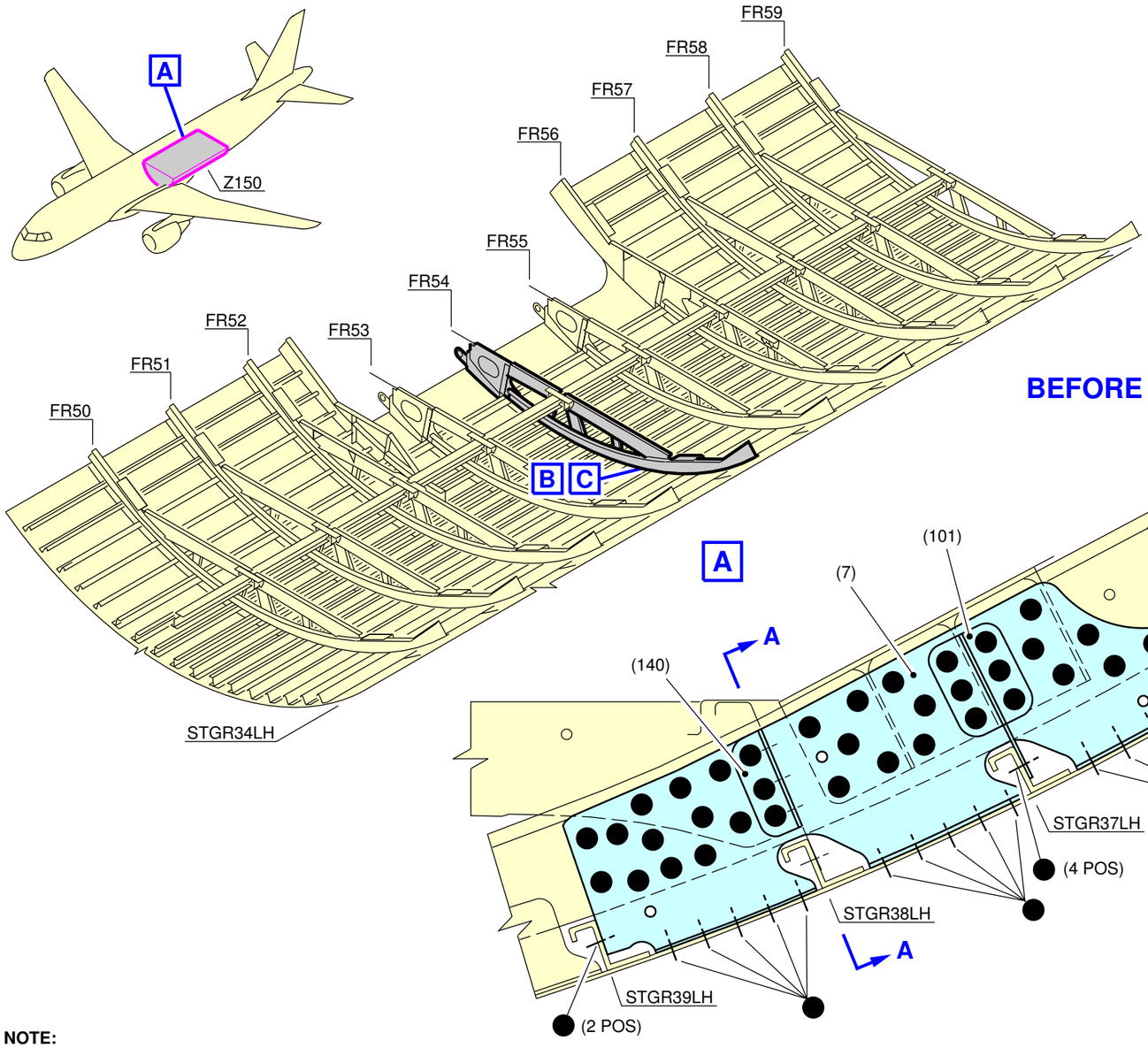
**CONF 005



N_SB_531364_6_BEAE_01_00

NOTE:

● REMOVE RIVETS, ITEM (100)

Figure A-GBEAE - Sheet 01
Replacement of Webs and Angles at Frame 54

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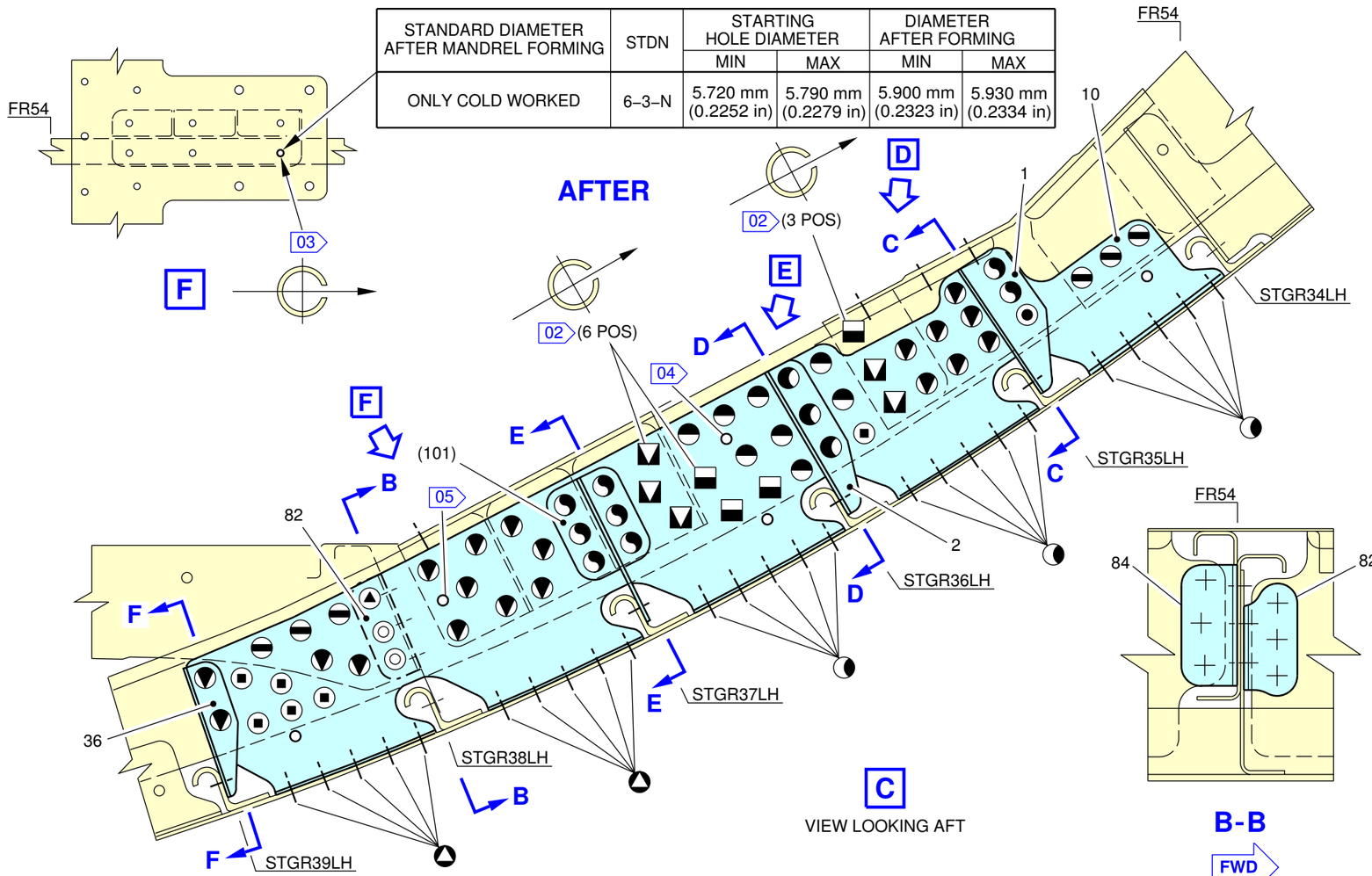
**CONF 005

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



C
VIEW LOOKING AFT

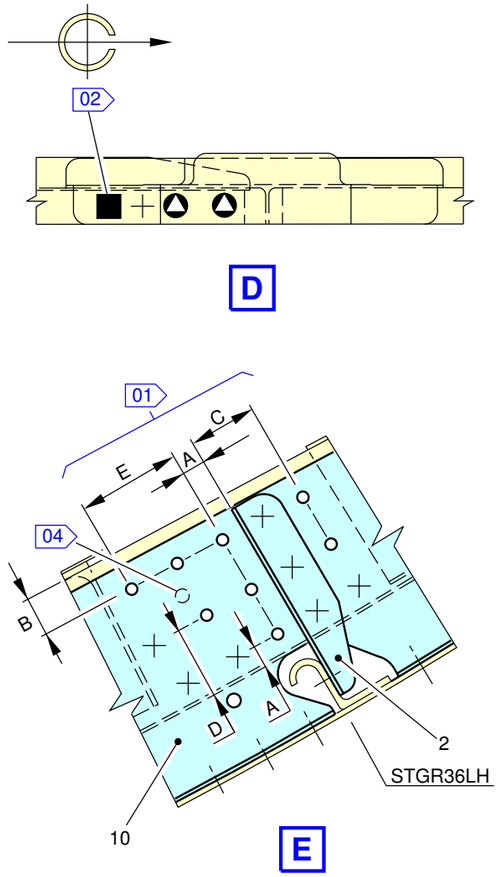
B-B

FWD

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.



E
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

05 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in). FOR MSN 3999 AND SUBSEQUENT.

N_SB_531364_6_BEAE_02_01

Figure A-GBEAE - Sheet 02
Replacement of Webs and Angles at Frame 54

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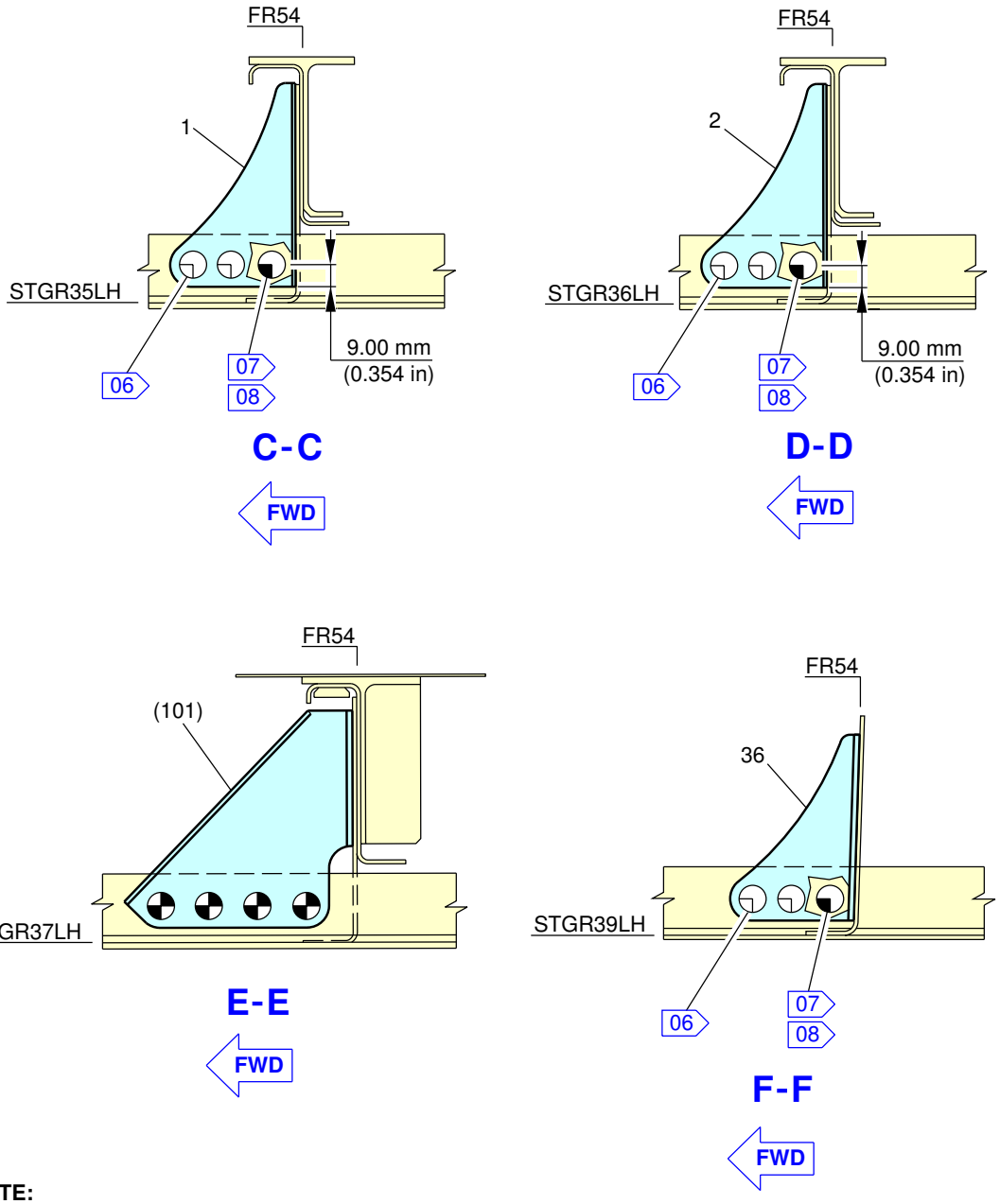
**CONF 005



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BEAE_03_01

Figure A-GBEAE - Sheet 03
Replacement of Webs and Angles at Frame 54

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**CONF 005

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	786	DAN5–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BEAE_04_01

Figure A-GBEAE - Sheet 04
Replacement of Webs and Angles at Frame 54

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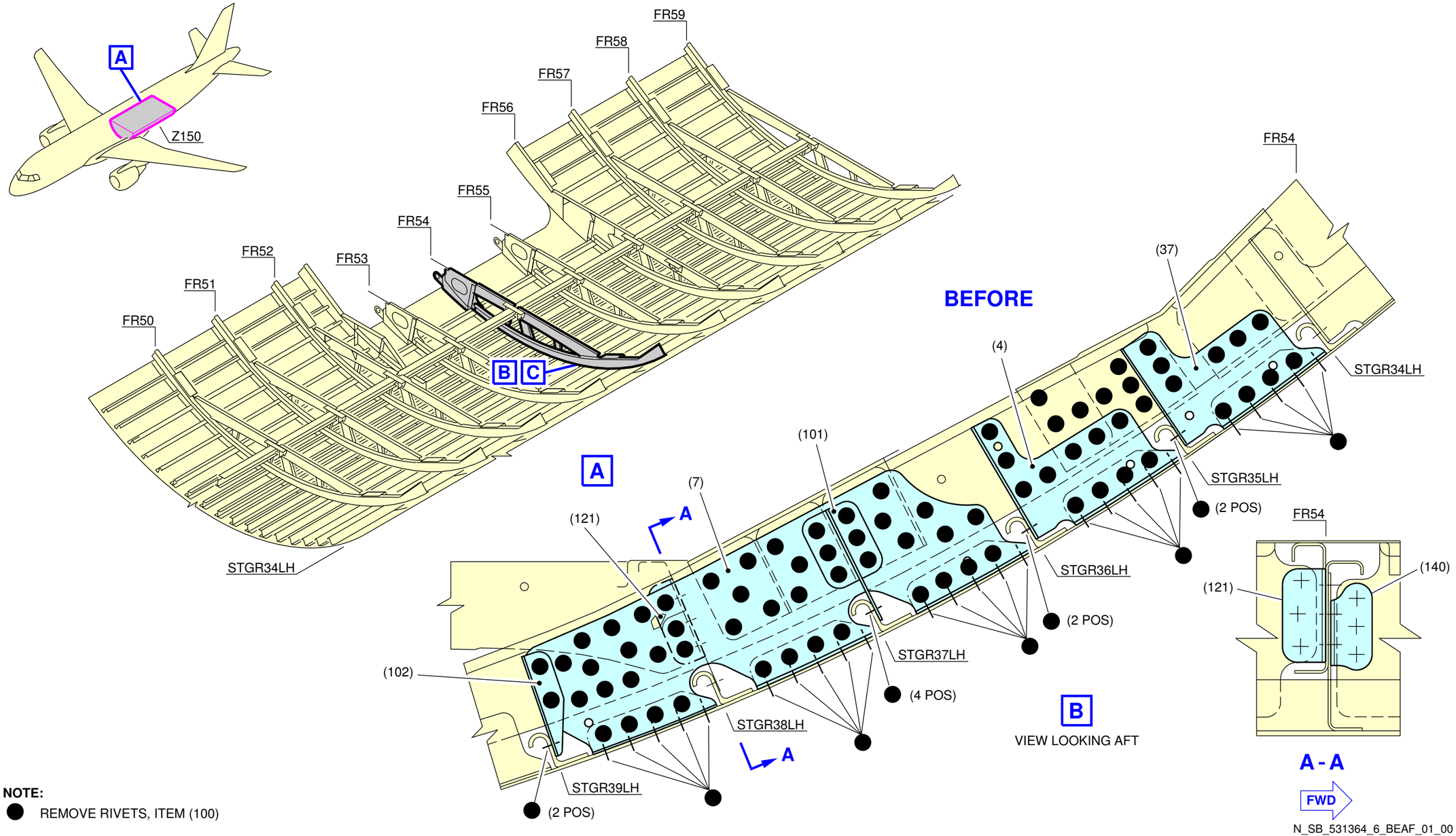
**CONF 006



NOTE:

● REMOVE RIVETS, ITEM (100)

Figure A-GBEAF - Sheet 01
Replacement of Webs and Angles at Frame 54

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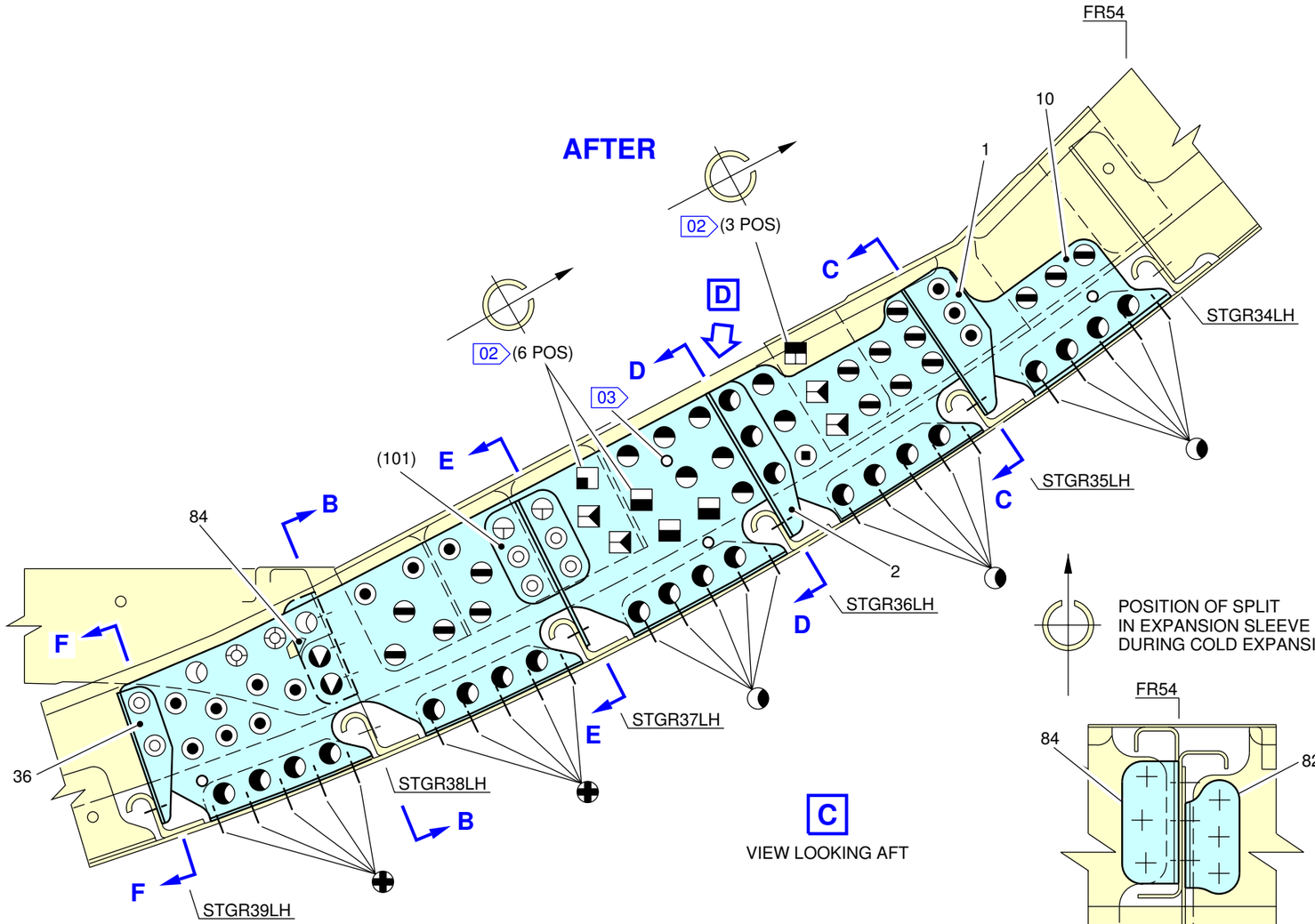
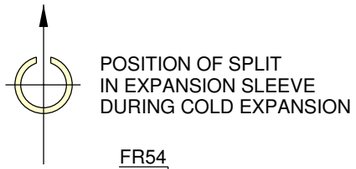
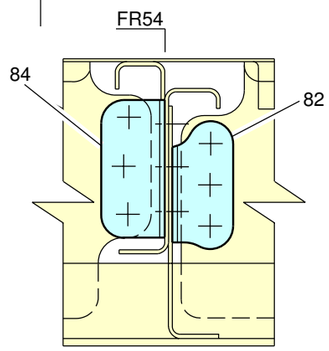
**CONF 006



C

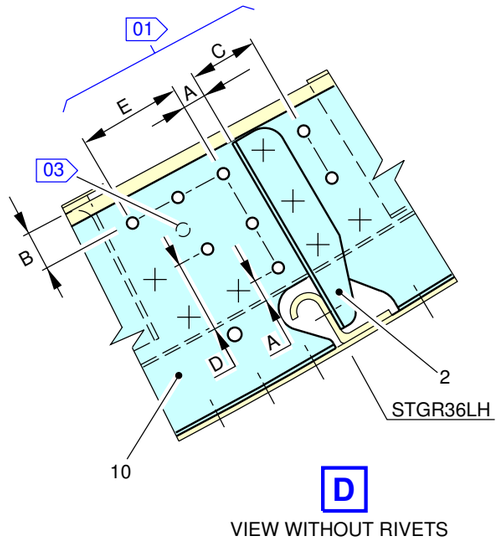
VIEW LOOKING AFT





B-B

FWD



D

VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BEAF_02_01

NOTE:

01 NEW HOLES.

02 ▬ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, ◧◤◪ COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

┼ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

Figure A-GBEAF - Sheet 02
Replacement of Webs and Angles at Frame 54

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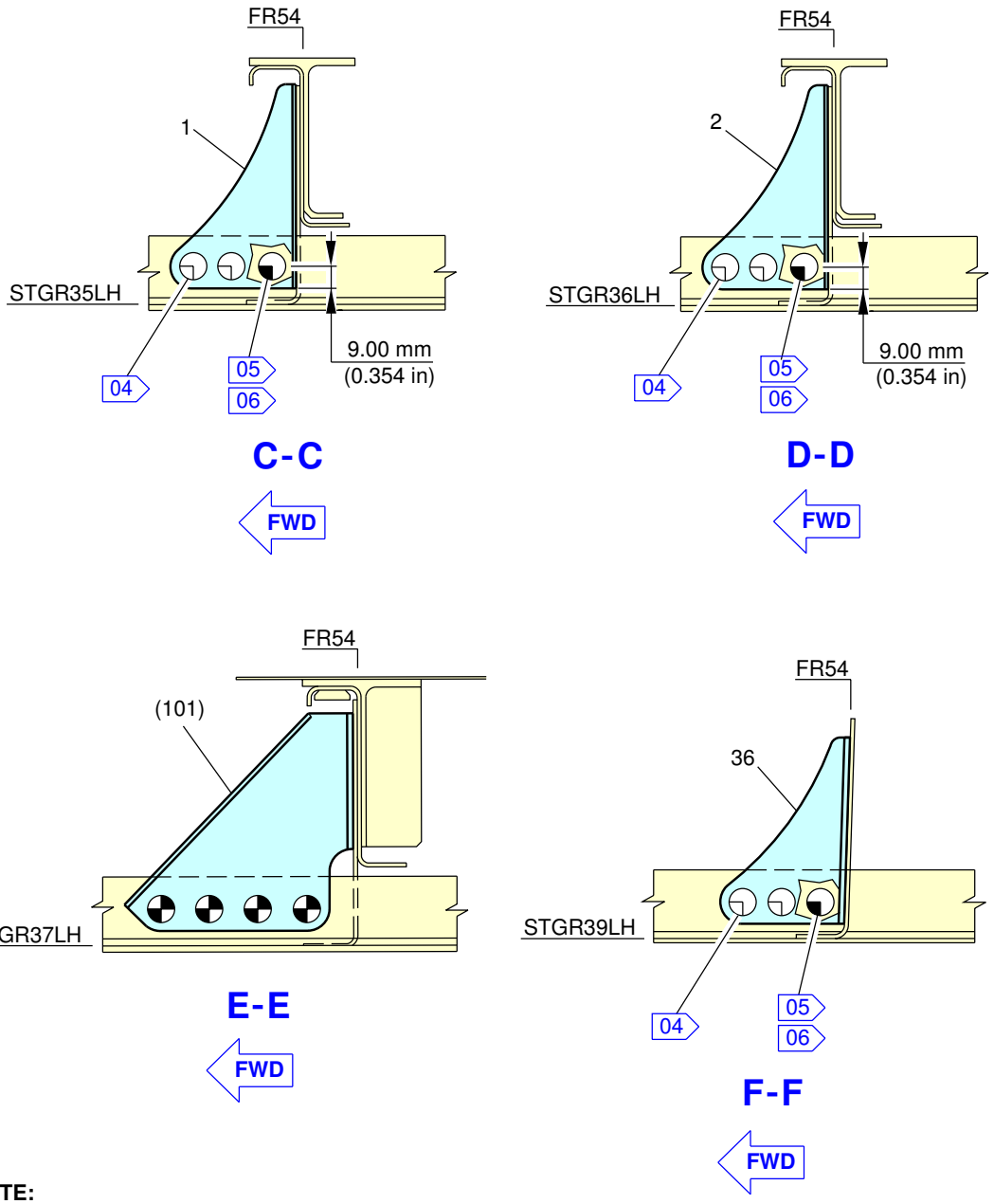
**CONF 006



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BEAF_03_01

Figure A-GBEAF - Sheet 03
Replacement of Webs and Angles at Frame 54

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**CONF 006

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	768	DAN5–6–8X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	784	DAN5–6–4Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	873	DAN6–6–3X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BEAF_04_01

Figure A-GBEAF - Sheet 04
Replacement of Webs and Angles at Frame 54

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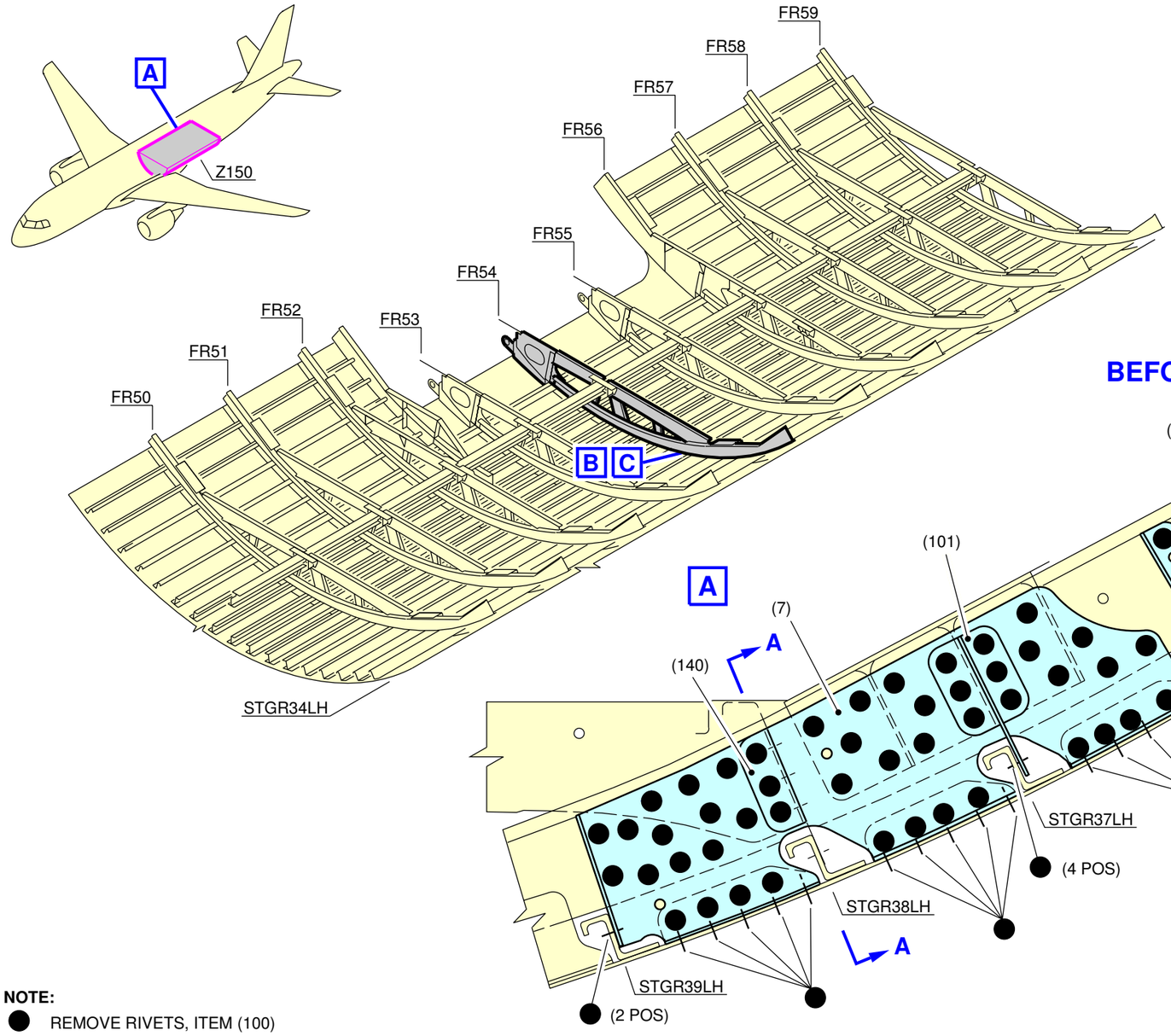
**CONF 007



N_SB_531364_6_BEAG_01_00

NOTE:

● REMOVE RIVETS, ITEM (100)

Figure A-GBEAG - Sheet 01
Replacement of Webs and Angles at Frame 54

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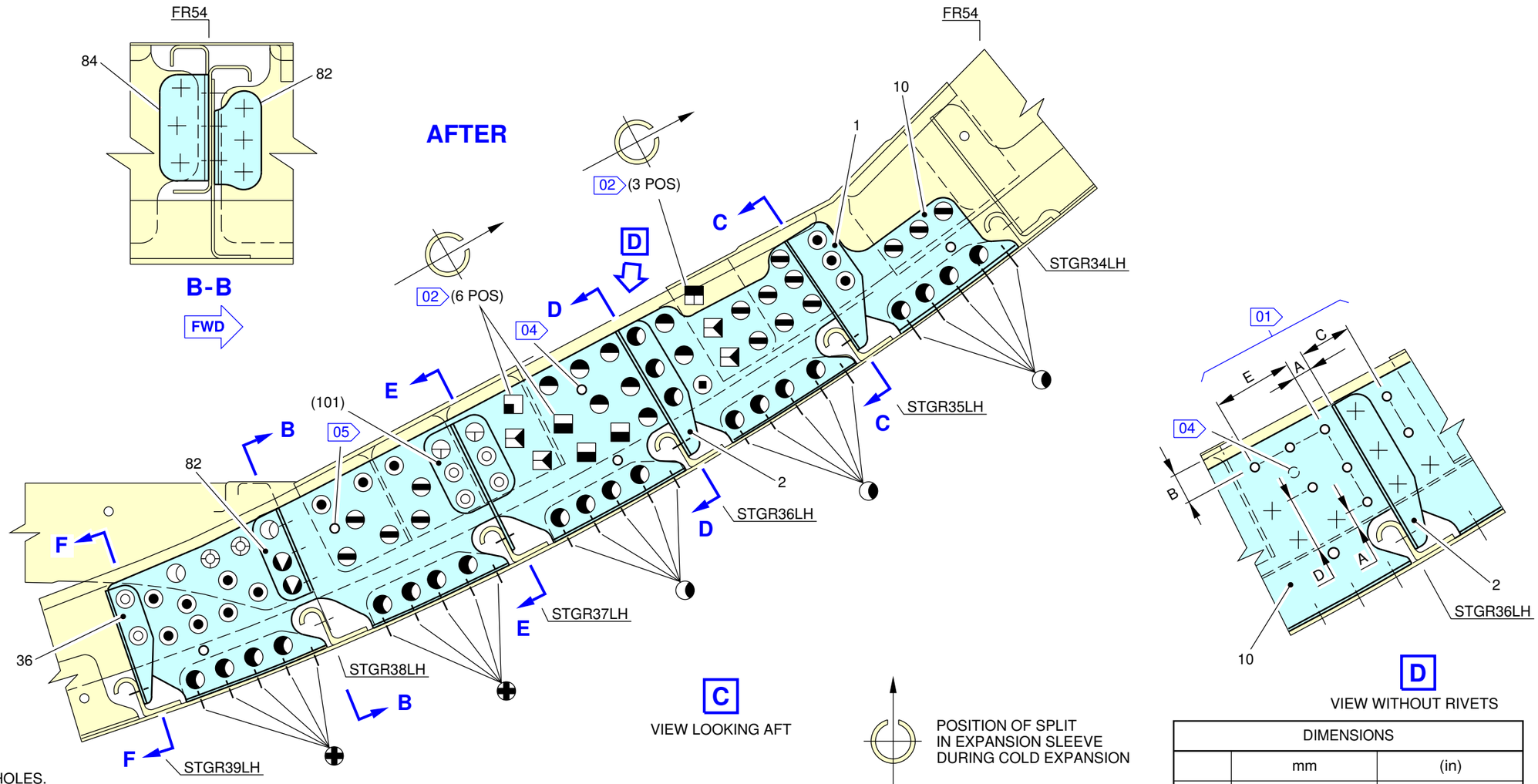
**CONF 007



C
VIEW LOOKING AFT

POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

D
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	18.00	0.709
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BEAG_02_01

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00, COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

05 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in).

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

Figure A-GBEAG - Sheet 02
Replacement of Webs and Angles at Frame 54

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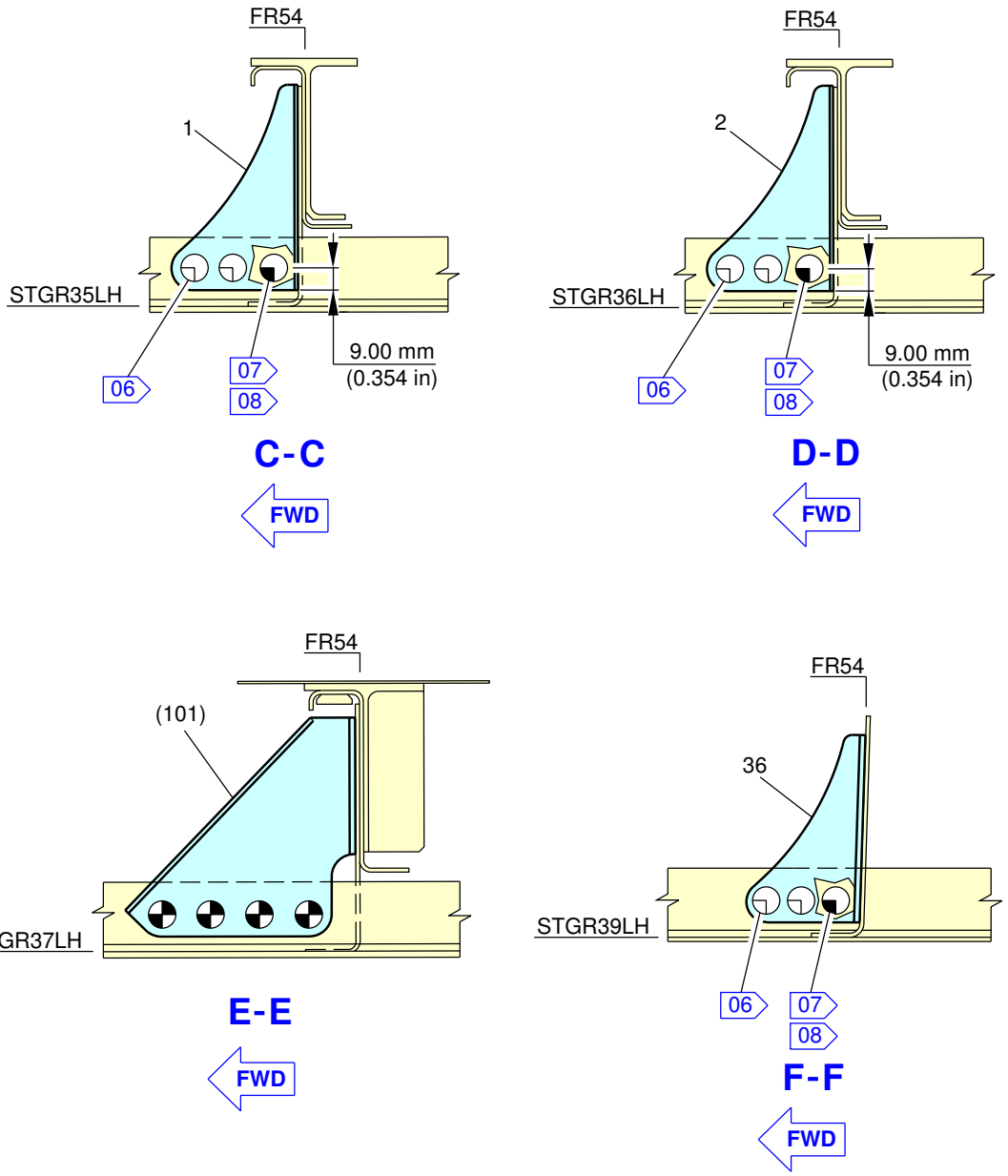
**CONF 007



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BEAG_03_01

Figure A-GBEAG - Sheet 03
Replacement of Webs and Angles at Frame 54

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**CONF 007

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	373	EN6115K3A3	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	375	EN6115K3A5	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	767	DAN5–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	768	DAN5–6–8X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	784	DAN5–6–4Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	873	DAN6–6–3X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BEAG_04_01

Figure A-GBEAG - Sheet 04
Replacement of Webs and Angles at Frame 54

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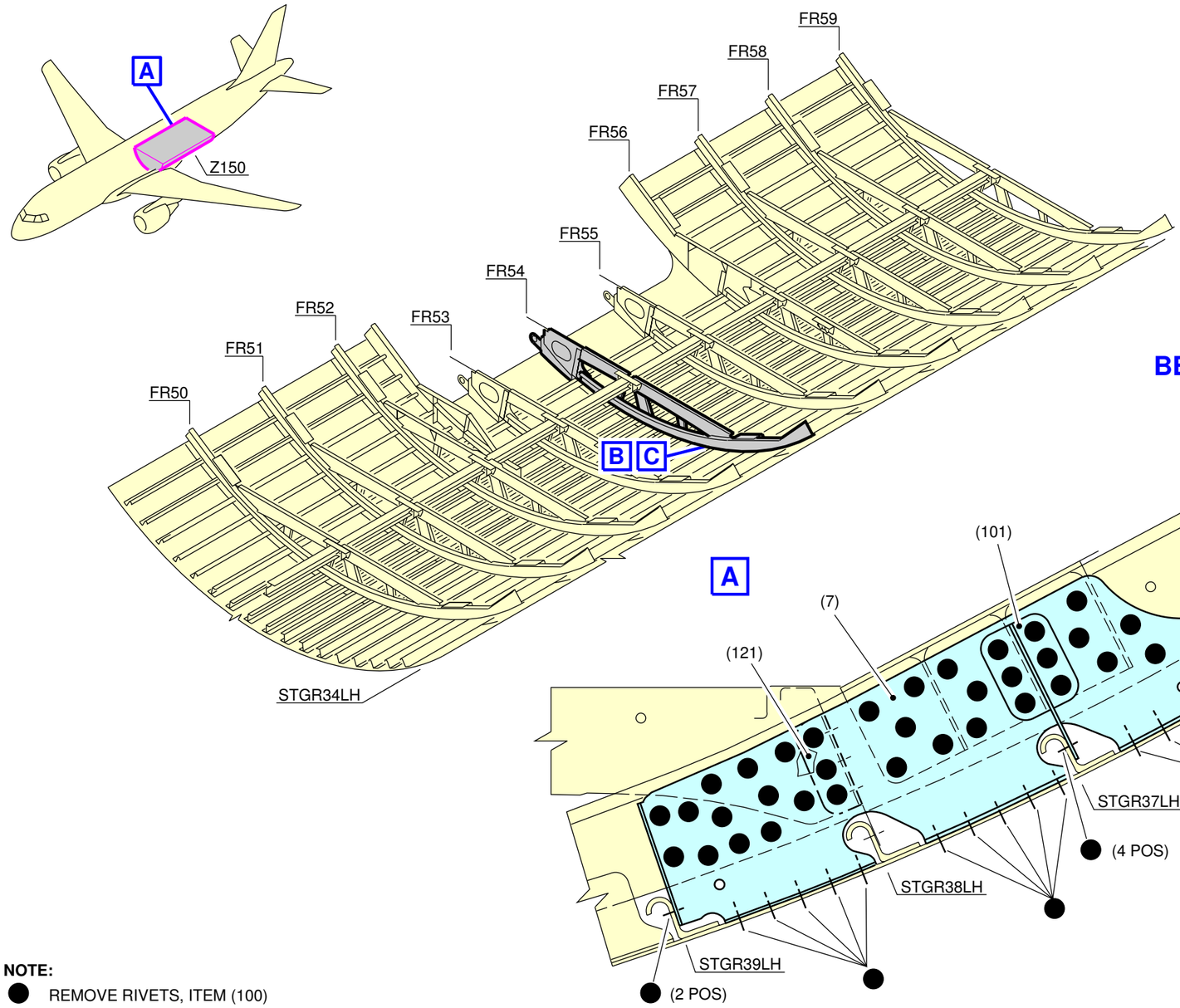
**CONF 008



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BEAH_01_00

Figure A-GBEAH - Sheet 01
Replacement of Webs and Angles at Frame 54

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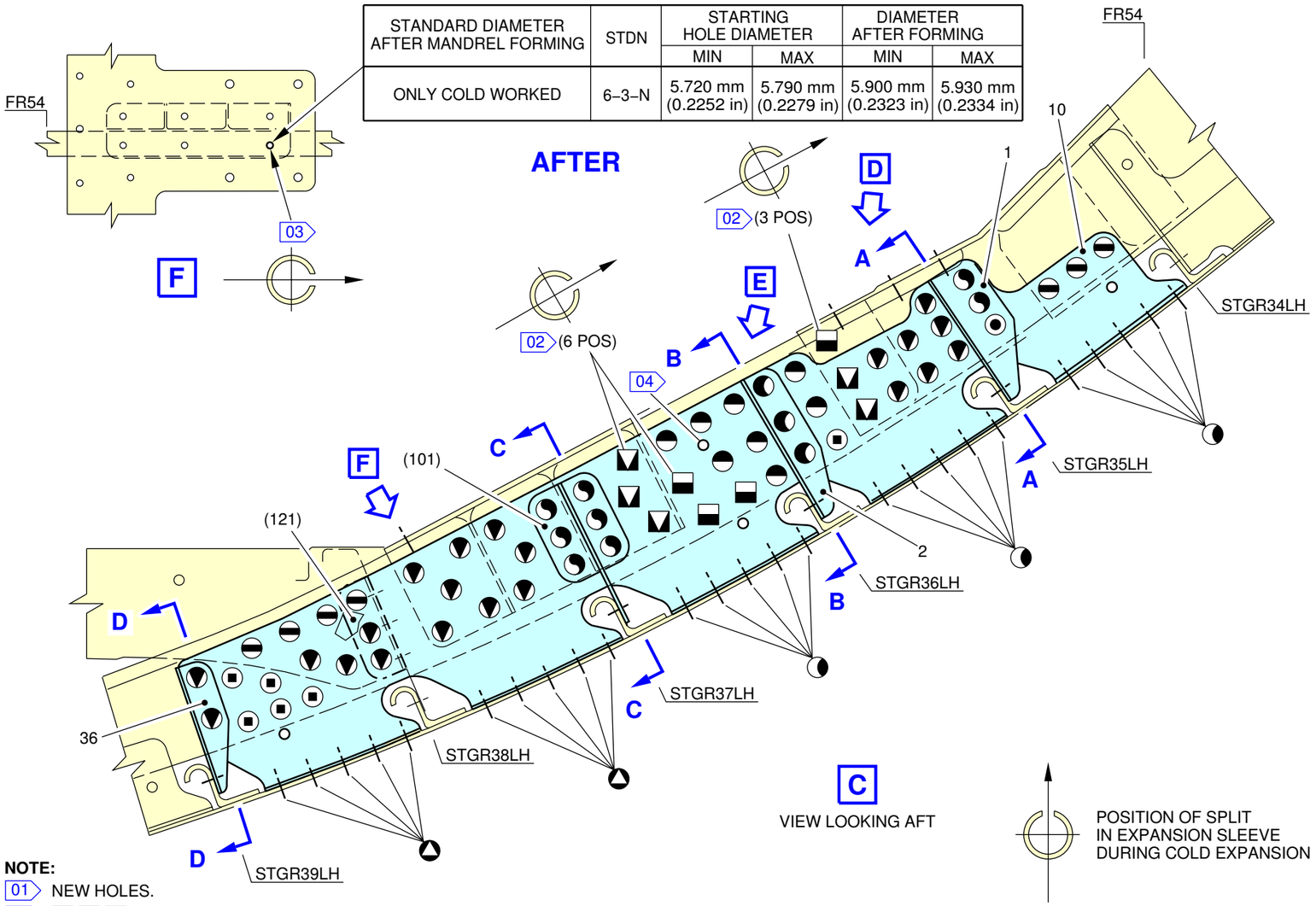
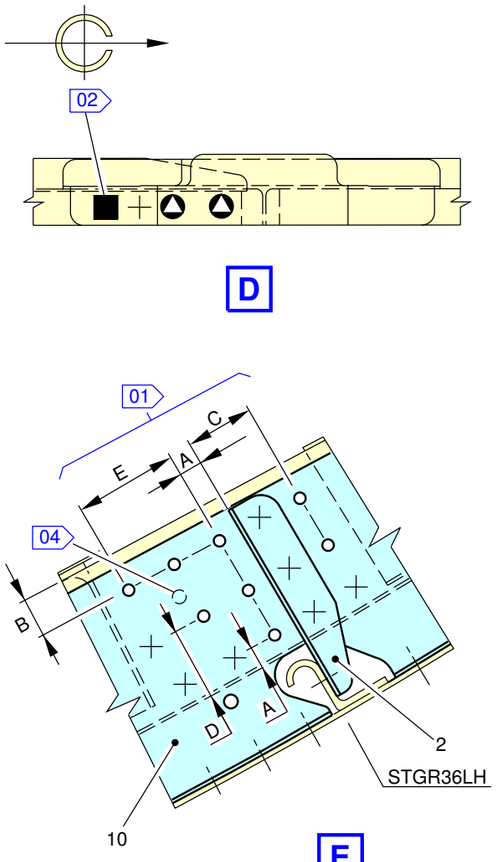
**CONF 008

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



C
VIEW LOOKING AFT

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION



E
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BEAH_02_01

NOTE:

01 NEW HOLES.

02 ▼▬■ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

┼ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

Figure A-GBEAH - Sheet 02
Replacement of Webs and Angles at Frame 54

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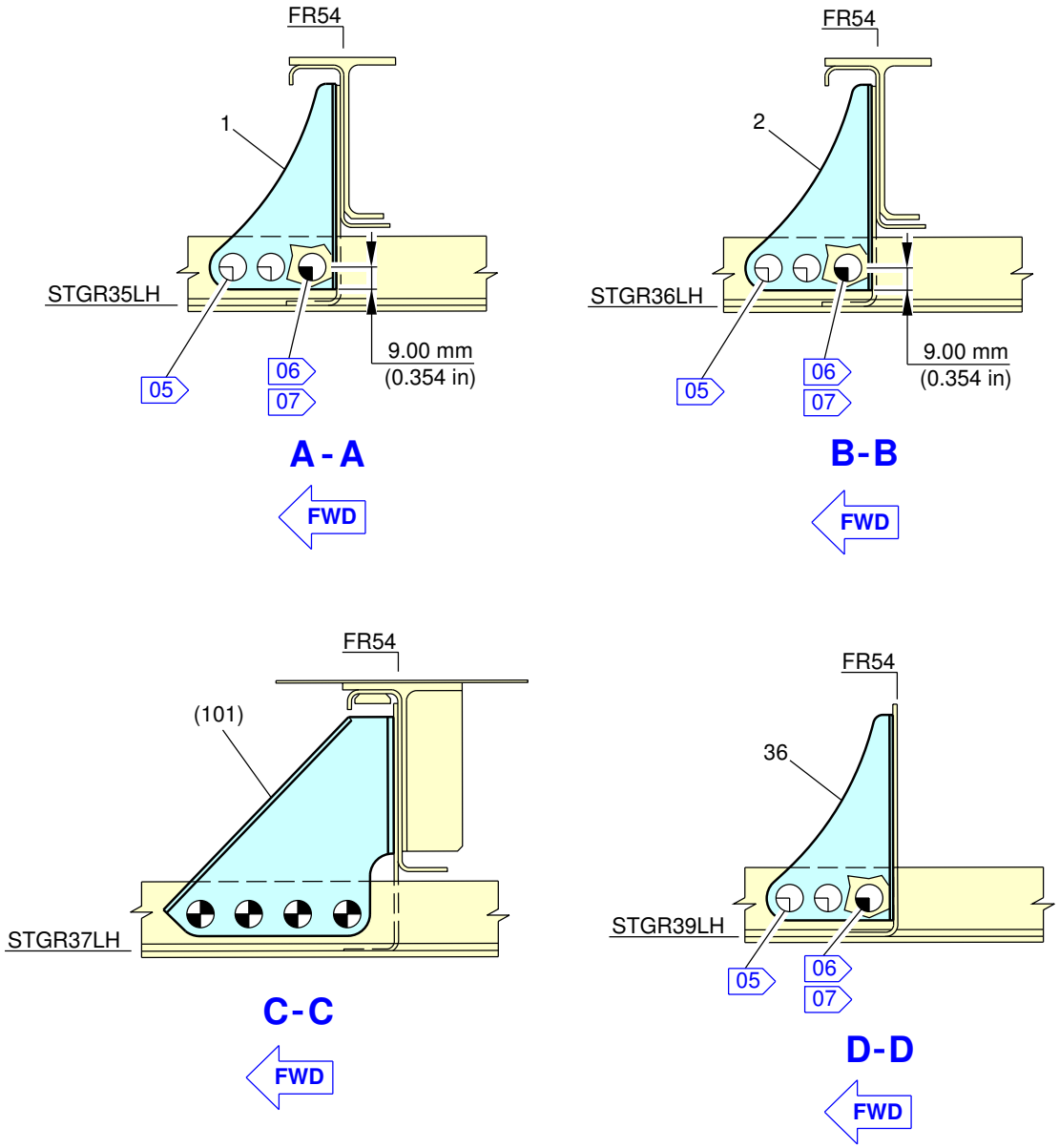
**CONF 008



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BEAH_03_01

Figure A-GBEAH - Sheet 03
Replacement of Webs and Angles at Frame 54

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**CONF 008

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BEAH_04_01

Figure A-GBEAH - Sheet 04
Replacement of Webs and Angles at Frame 54

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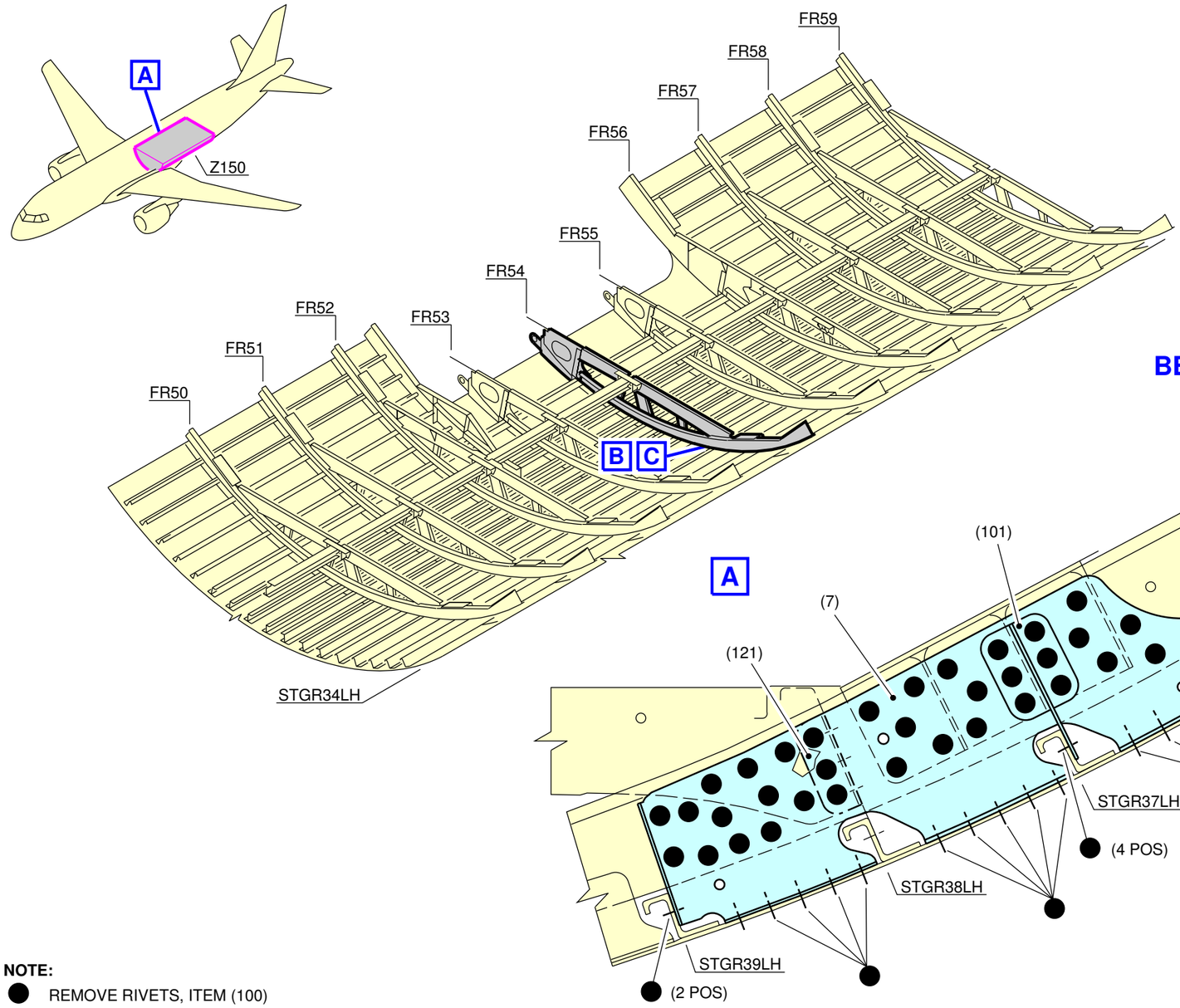
**CONF 009



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BEAJ_01_00

Figure A-GBEAJ - Sheet 01
Replacement of Webs and Angles at Frame 54

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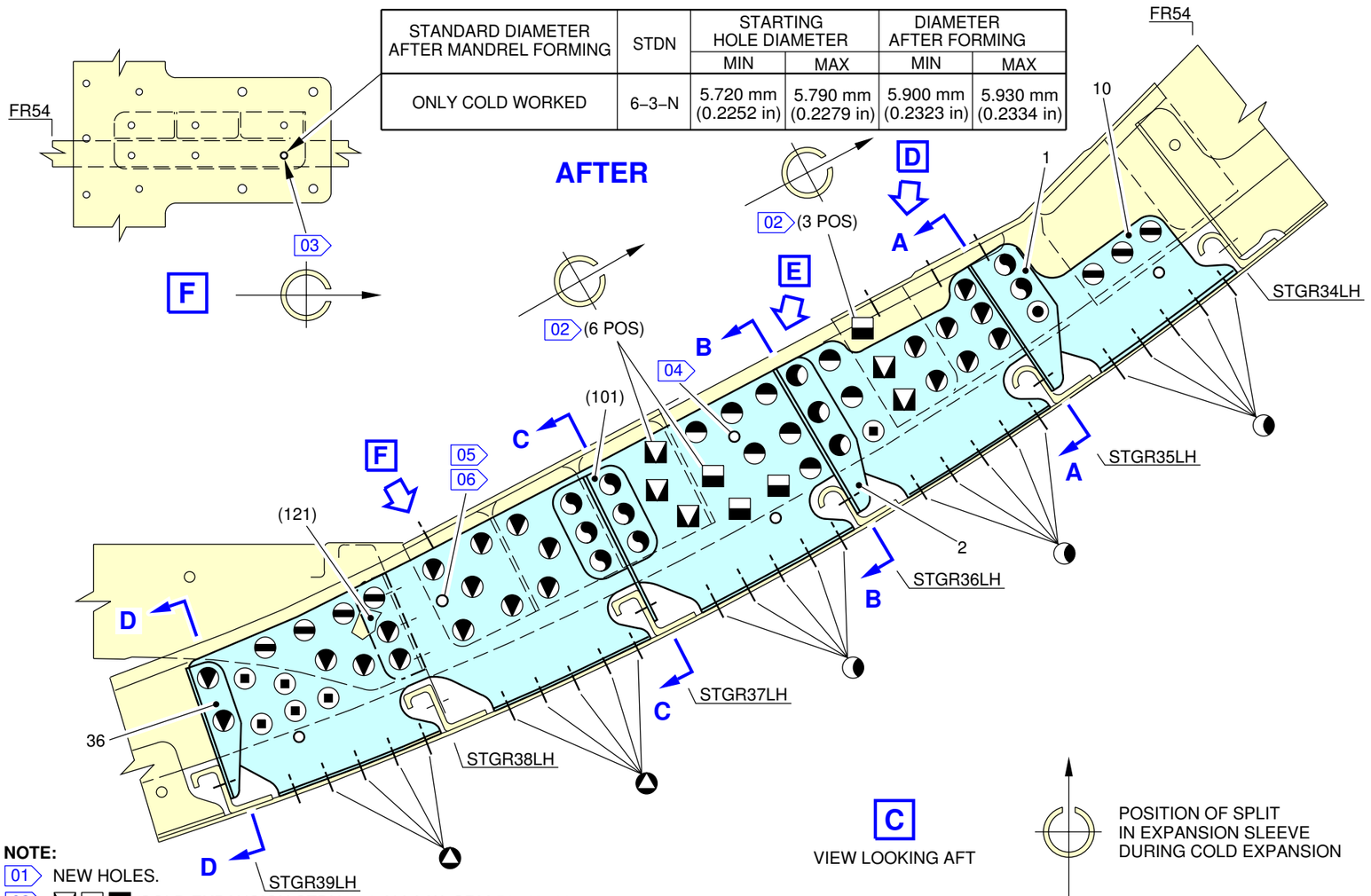
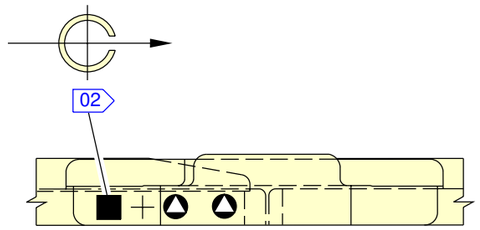
**CONF 009

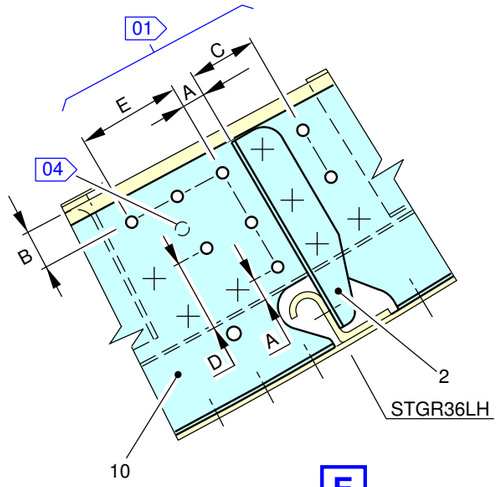
STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



C
VIEW LOOKING AFT

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION





E
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	17.00	0.669
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BEAJ_02_01

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

05 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in).

06 VALID FOR MSN 4005 AND SUBSEQUENT.

EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

Figure A-GBEAJ - Sheet 02
Replacement of Webs and Angles at Frame 54

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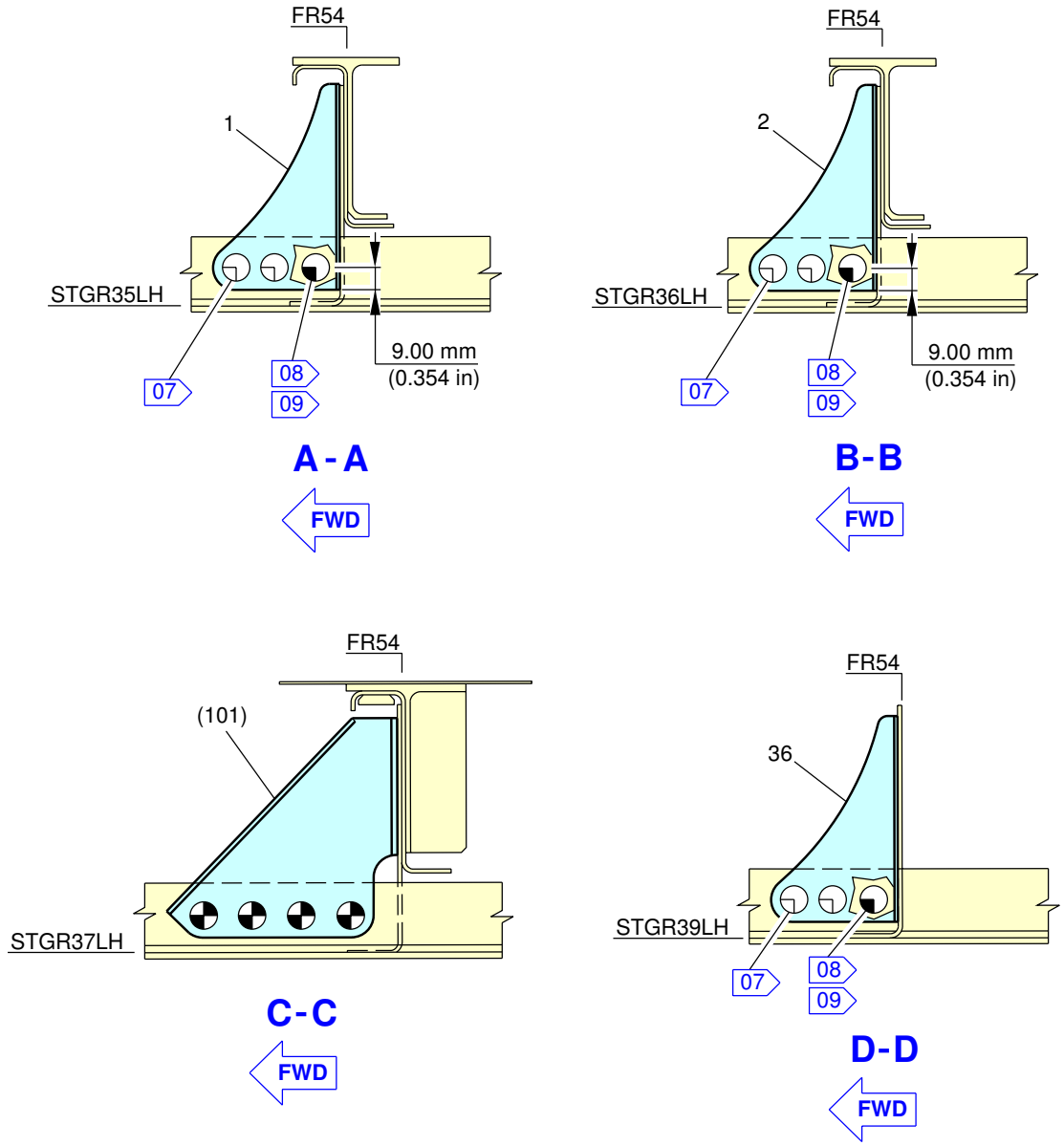
**CONF 009



NOTE:

07 EXISTING PILOT HOLES.

08 COUNTERSINK EXISTING HOLE IN THE STRINGER.

09 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BEAJ_03_01

Figure A-GBEAJ - Sheet 03
Replacement of Webs and Angles at Frame 54

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**CONF 009

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BEAJ_04_01

Figure A-GBEAJ - Sheet 04
Replacement of Webs and Angles at Frame 54

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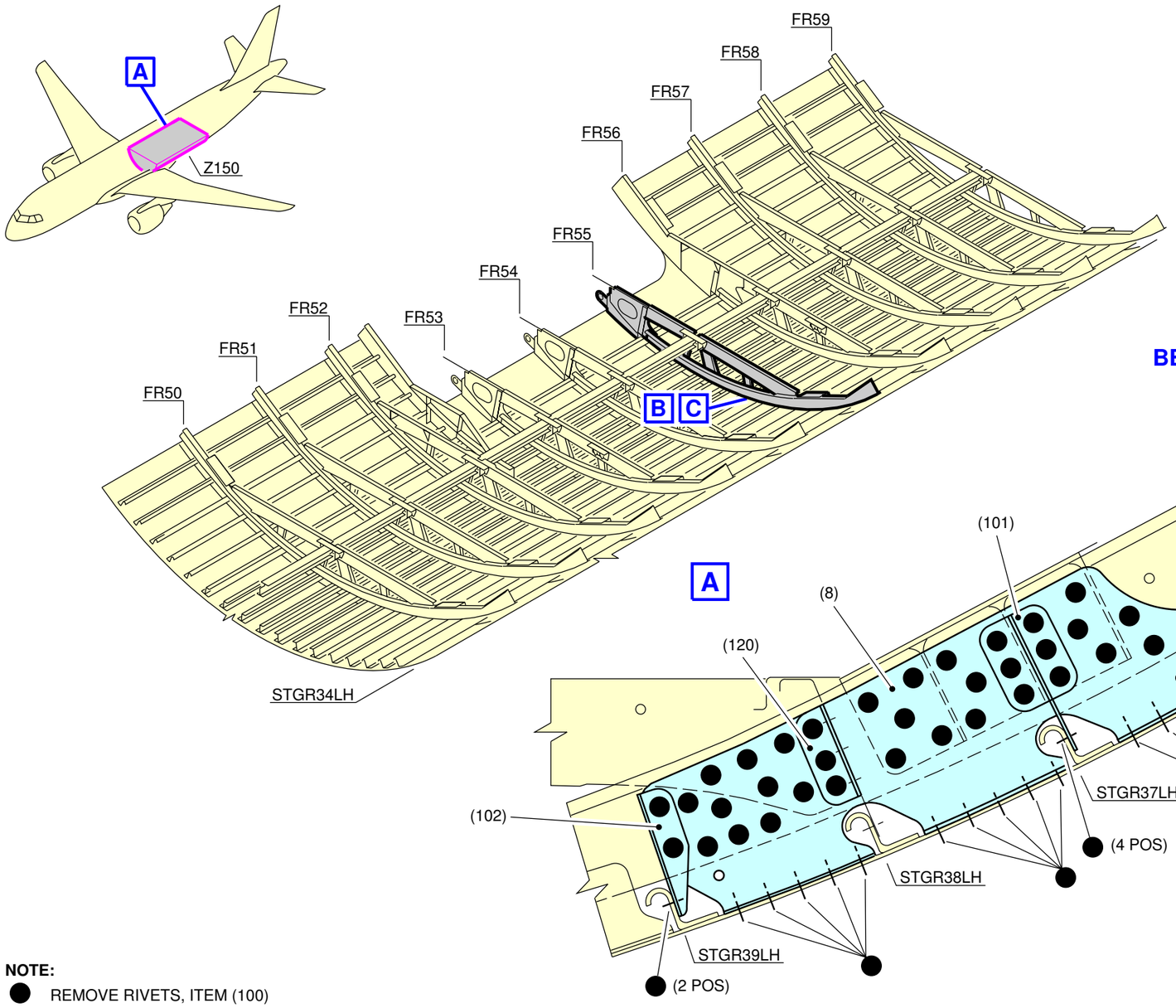
**CONF 001



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BFAA_01_00

Figure A-GBFAA - Sheet 01
Replacement of Webs and Angles at Frame 55

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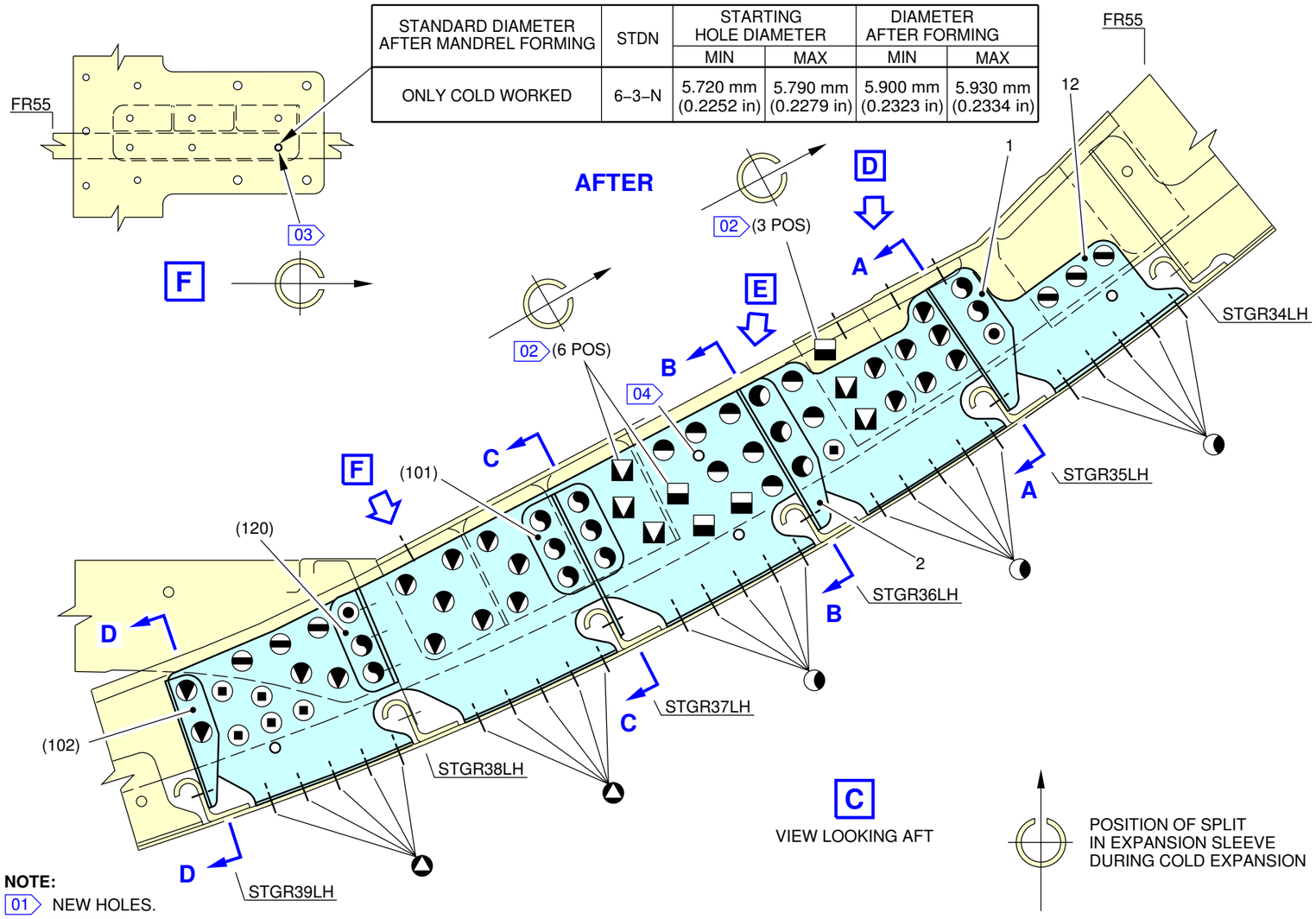
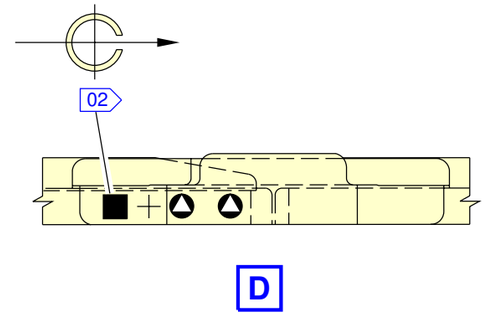
**CONF 001

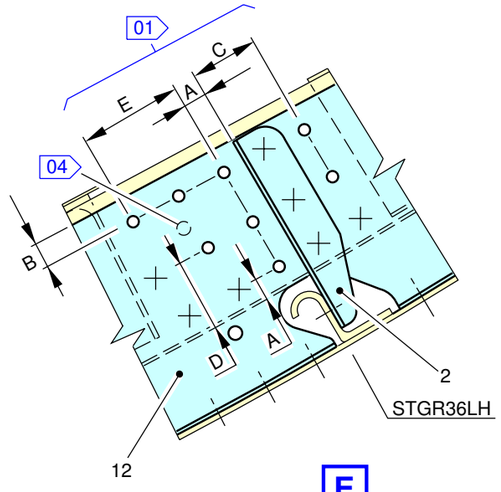
STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



C
VIEW LOOKING AFT

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION





E
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BFAA_02_01

Figure A-GBFAA - Sheet 02
Replacement of Webs and Angles at Frame 55

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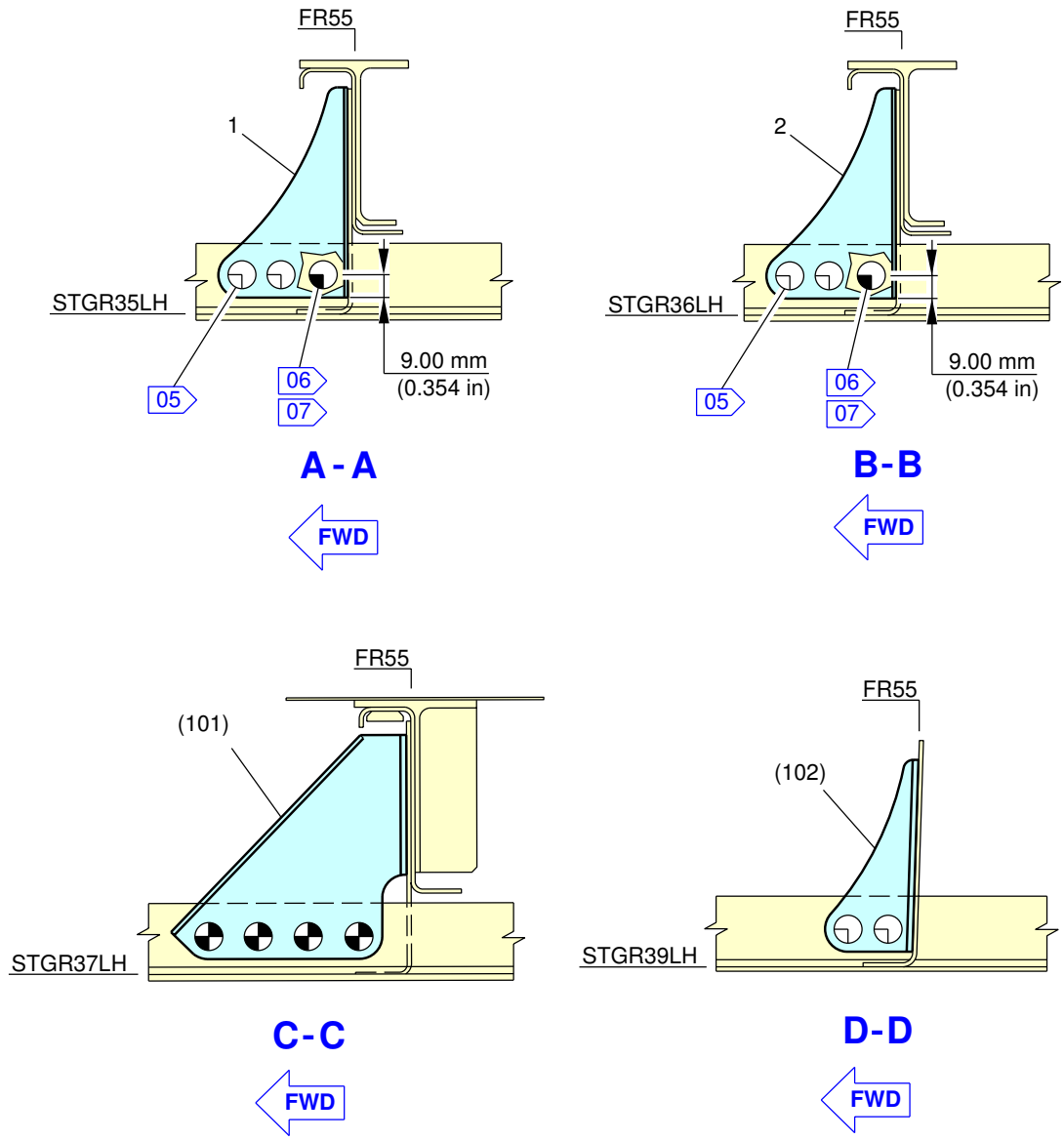
**CONF 001



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BFAA_03_01

Figure A-GBFAA - Sheet 03
Replacement of Webs and Angles at Frame 55

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**CONF 001

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BFAA_04_01

Figure A-GBFAA - Sheet 04
Replacement of Webs and Angles at Frame 55

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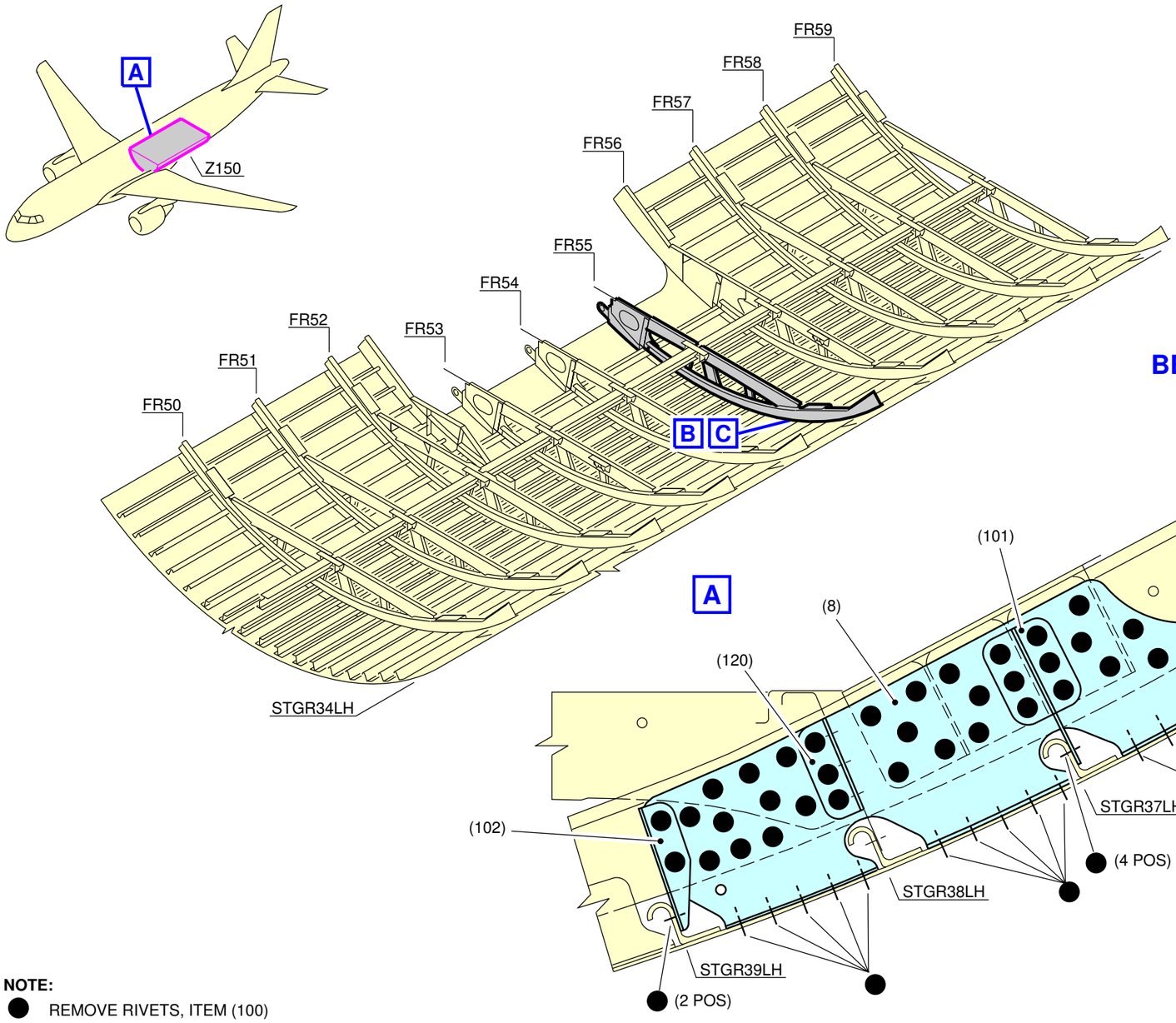
**CONF 002 thru 003



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BFAB_01_00

Figure A-GBFAB - Sheet 01
Replacement of Webs and Angles at Frame 55

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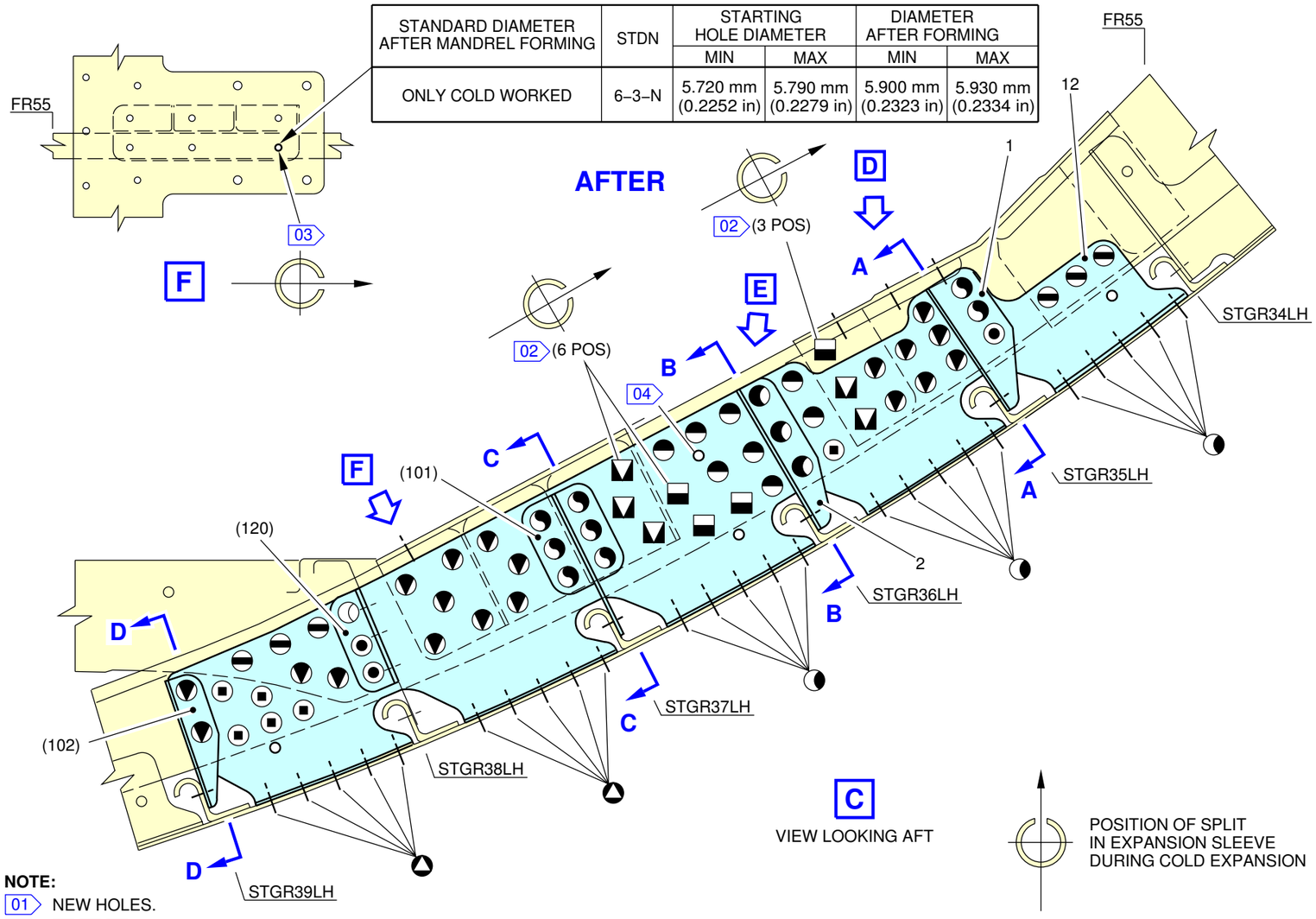
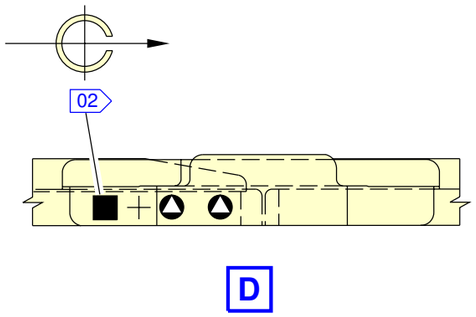
**CONF 002 thru 003

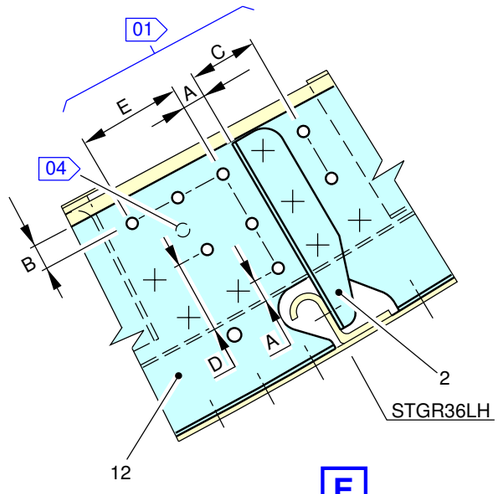
STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



C
VIEW LOOKING AFT

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION





VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES.

02 ◥◬◣ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

┼ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BFAB_02_01

Figure A-GBFAB - Sheet 02
Replacement of Webs and Angles at Frame 55

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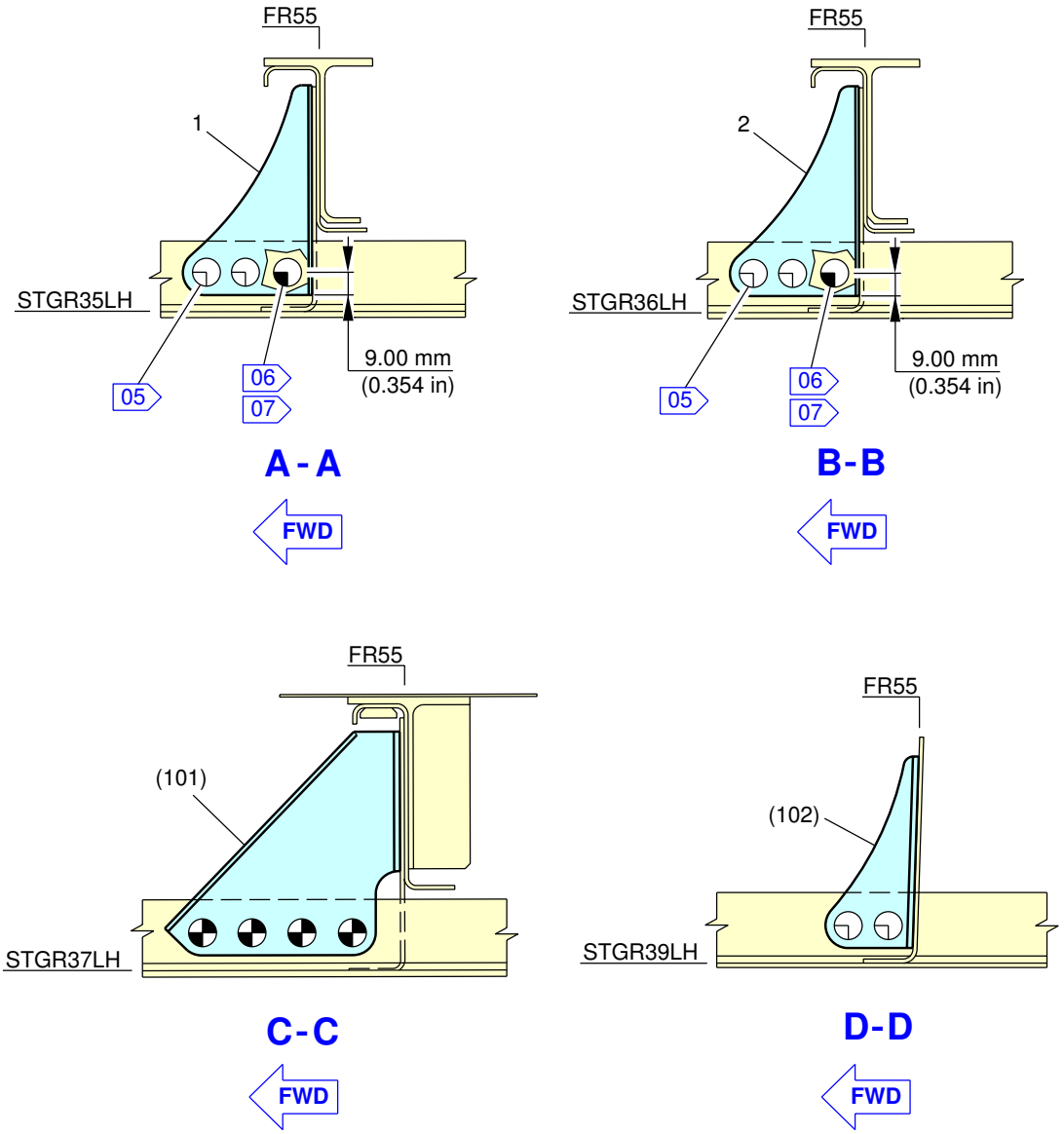
**CONF 002 thru 003



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BFAB_03_01

Figure A-GBFAB - Sheet 03
Replacement of Webs and Angles at Frame 55

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**CONF 002 thru 003

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BFAB_04_01

Figure A-GBFAB - Sheet 04
Replacement of Webs and Angles at Frame 55

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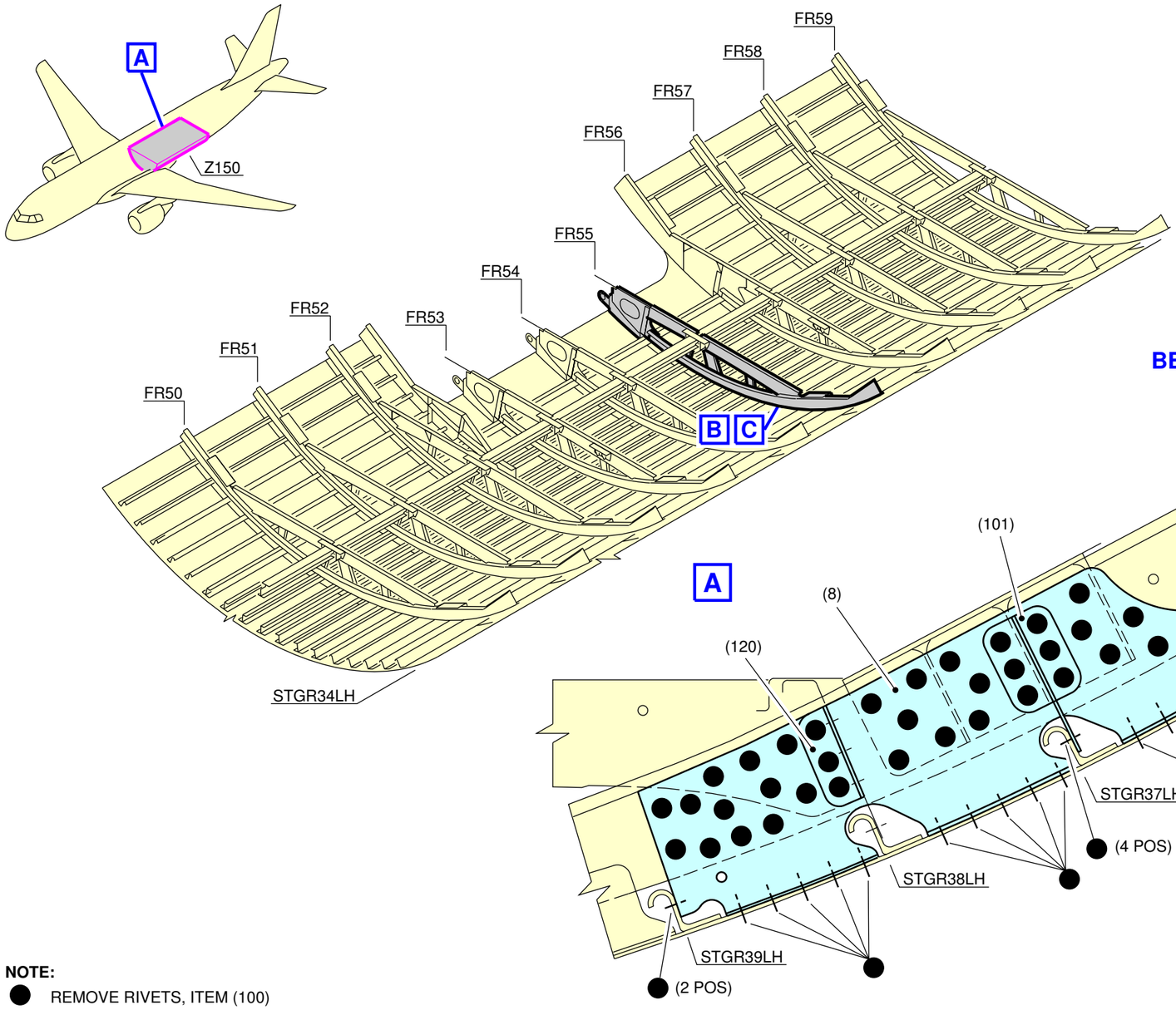
**CONF 004, 006



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BFAD_01_00

Figure A-GBFAD - Sheet 01
Replacement of Webs and Angles at Frame 55

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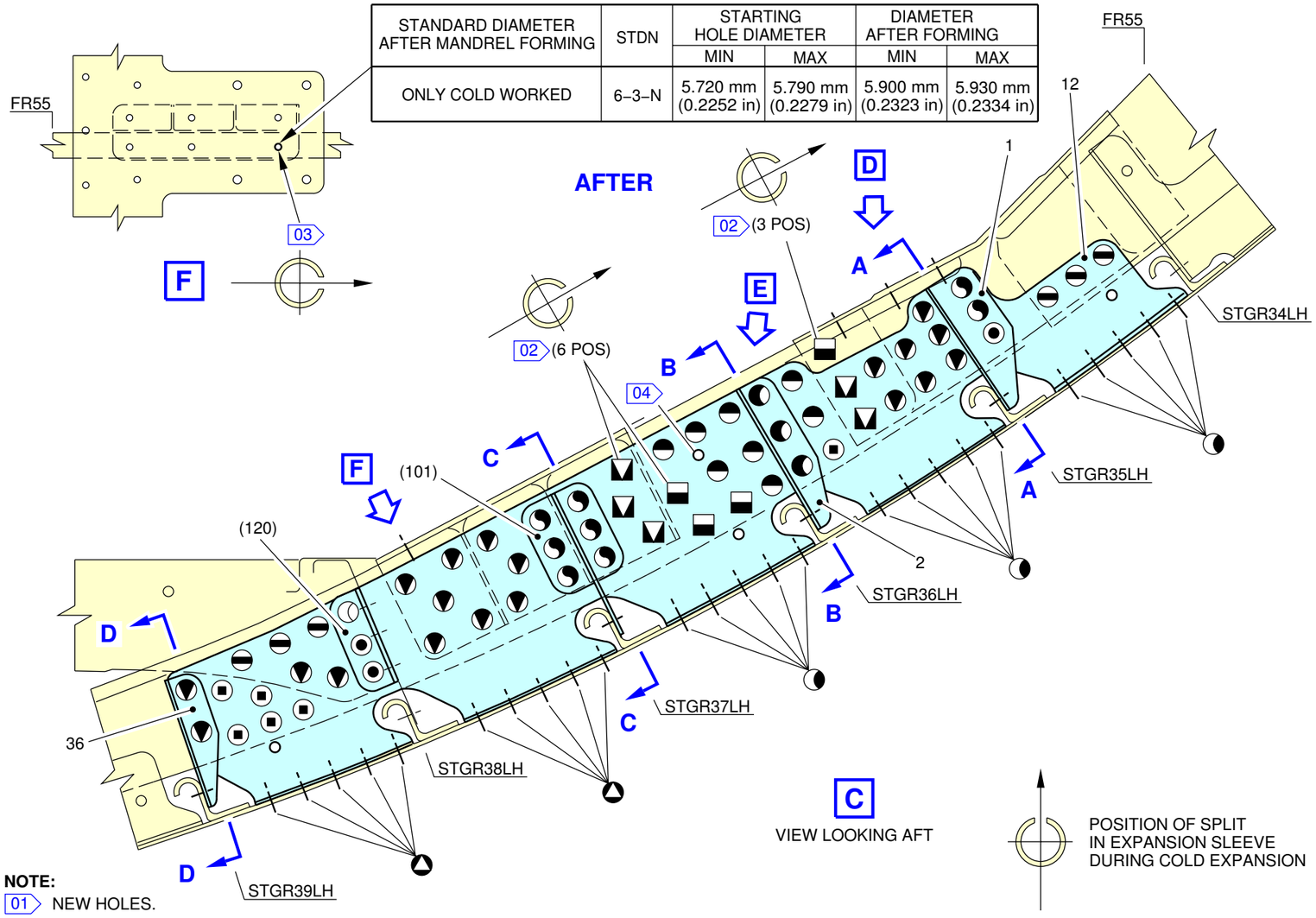
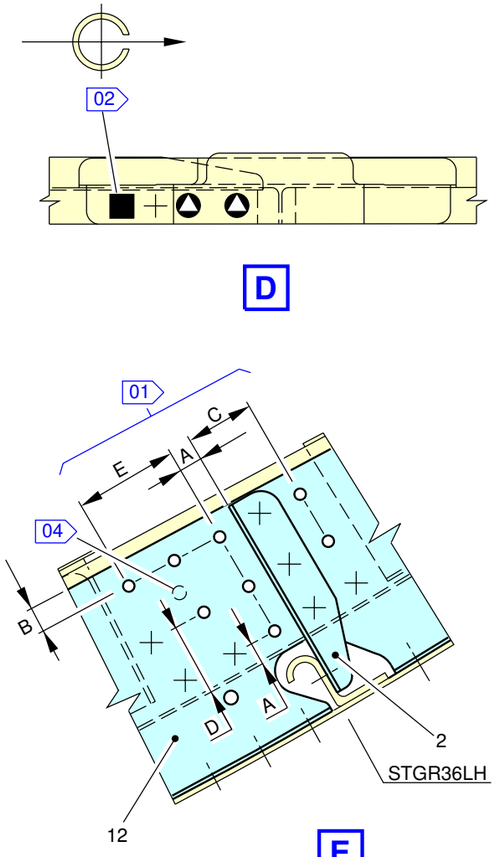
**CONF 004, 006

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



C
VIEW LOOKING AFT

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION



E
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BFAD_02_01

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

Figure A-GBFAD - Sheet 02
Replacement of Webs and Angles at Frame 55

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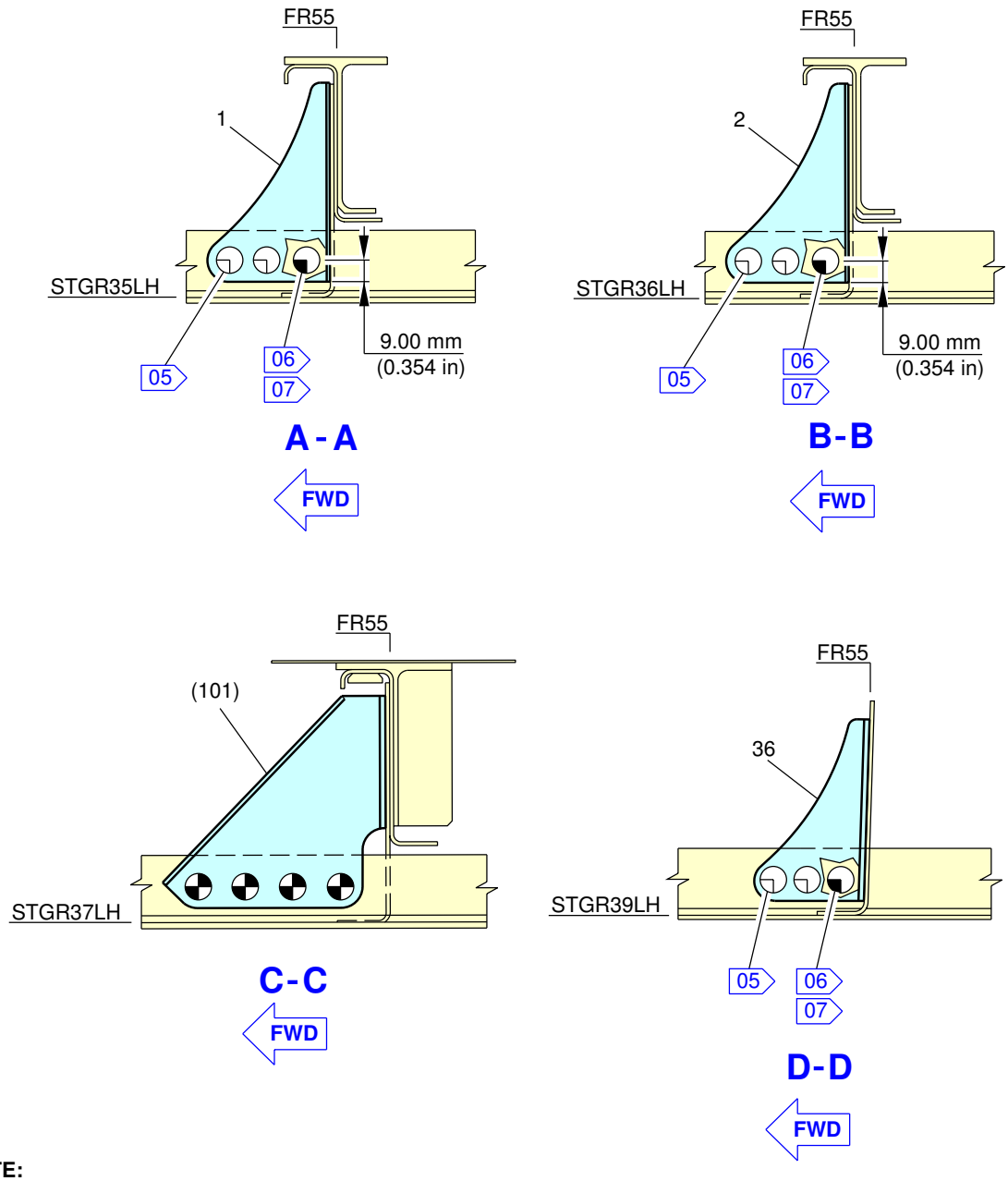
**CONF 004, 006



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BFAD_03_01

Figure A-GBFAD - Sheet 03
Replacement of Webs and Angles at Frame 55

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**CONF 004, 006

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BFAD_04_01

Figure A-GBFAD - Sheet 04
Replacement of Webs and Angles at Frame 55

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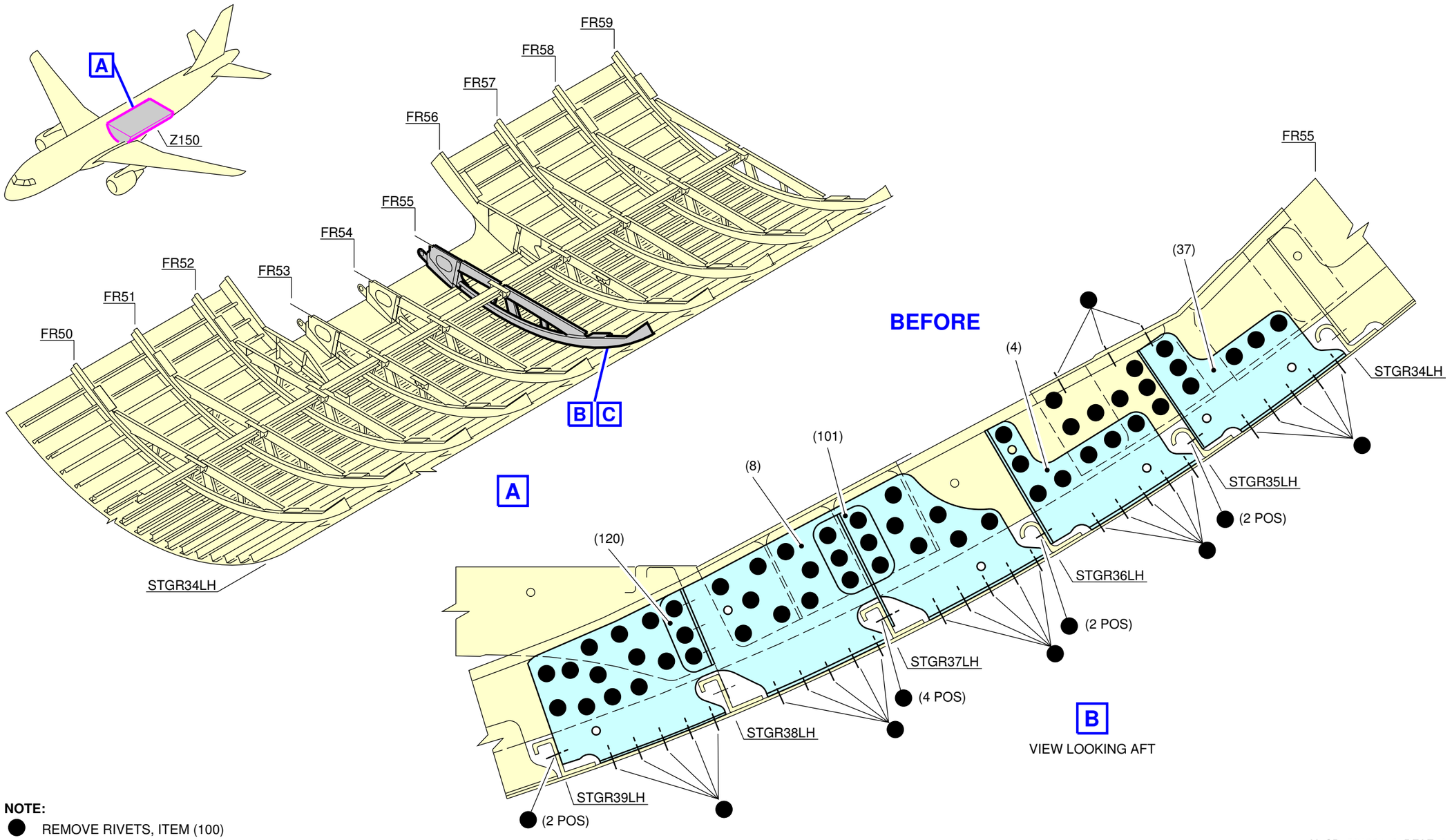
**CONF 005, 007



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BFAE_01_00

Figure A-GBFAE - Sheet 01
Replacement of Webs and Angles at Frame 55

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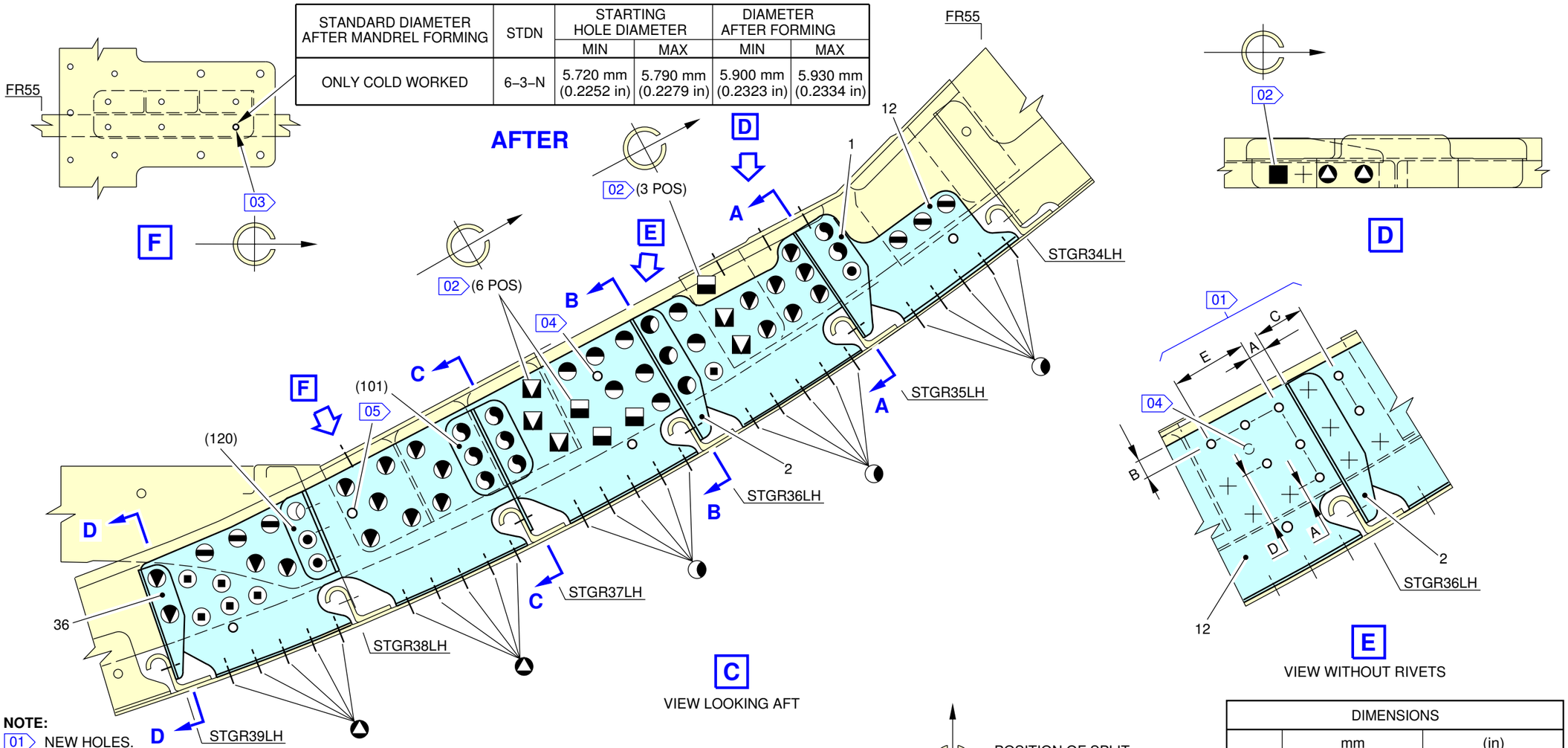
**CONF 005, 007

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



C

VIEW LOOKING AFT

E

VIEW WITHOUT RIVETS

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

05 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in). FOR MSN 3999 AND SUBSEQUENT.

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

N_SB_531364_6_BFAE_02_01

Figure A-GBFAE - Sheet 02
Replacement of Webs and Angles at Frame 55

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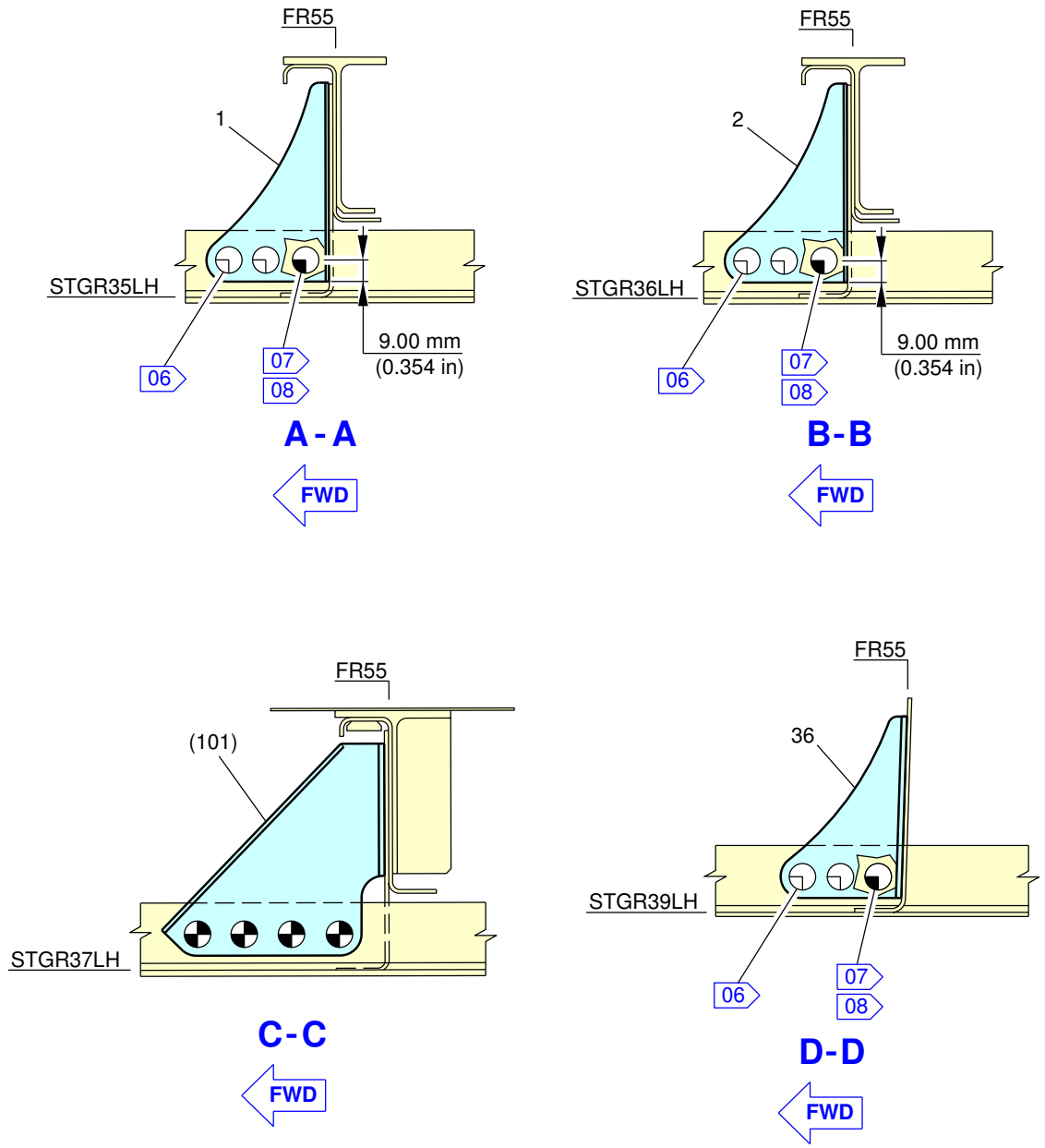
**CONF 005, 007



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BFAE_03_01

Figure A-GBFAE - Sheet 03
Replacement of Webs and Angles at Frame 55

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**CONF 005, 007

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
◒	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
◭	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
■	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
◒	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◑	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◓	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◵	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◙	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◐	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◭	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◔	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◒	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
◉	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
◖	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
◭	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
◓	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BFAE_04_01

Figure A-GBFAE - Sheet 04
Replacement of Webs and Angles at Frame 55

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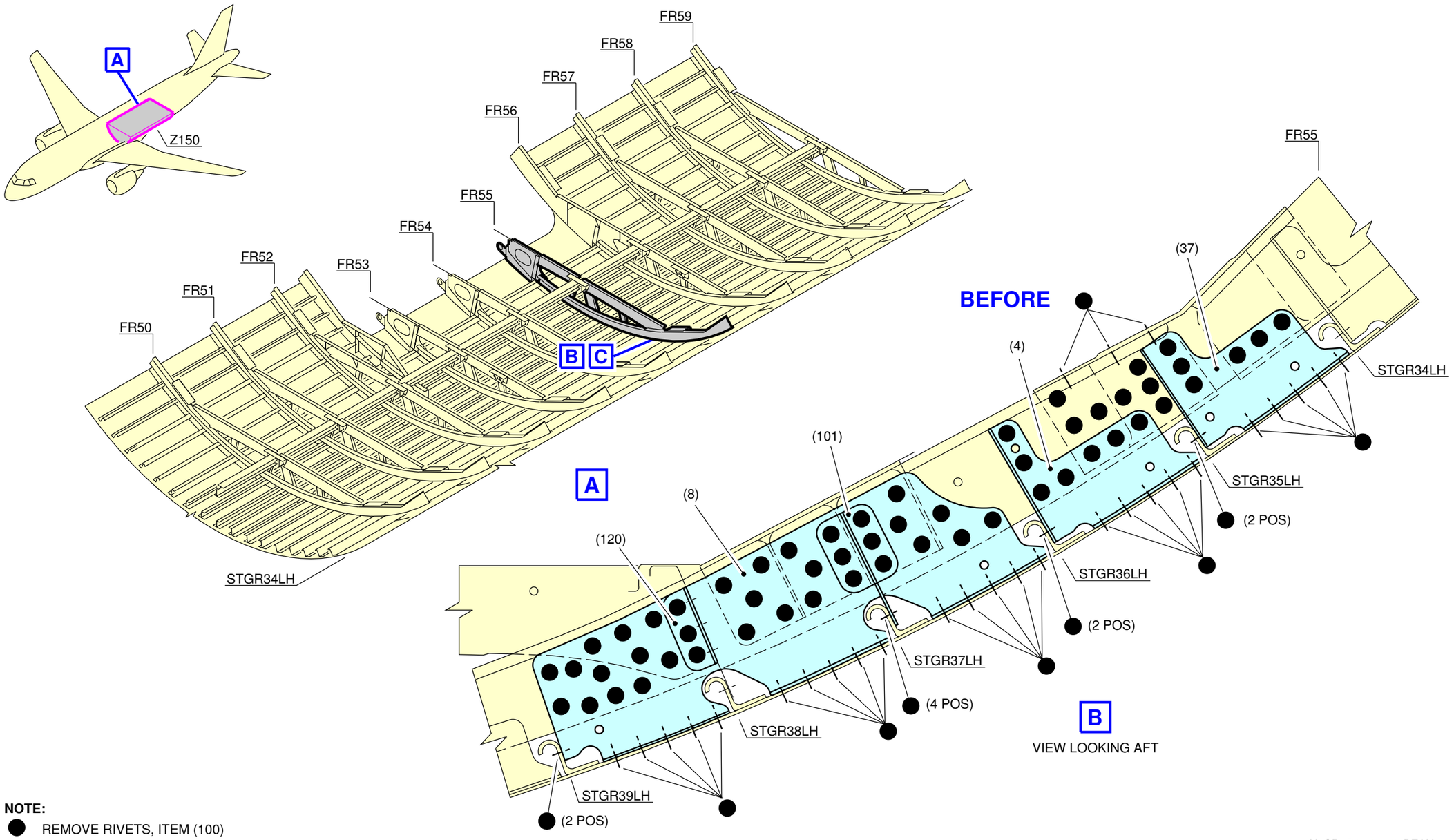
**CONF 008



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BFAH_01_00

Figure A-GBFAH - Sheet 01
Replacement of Webs and Angles at Frame 55

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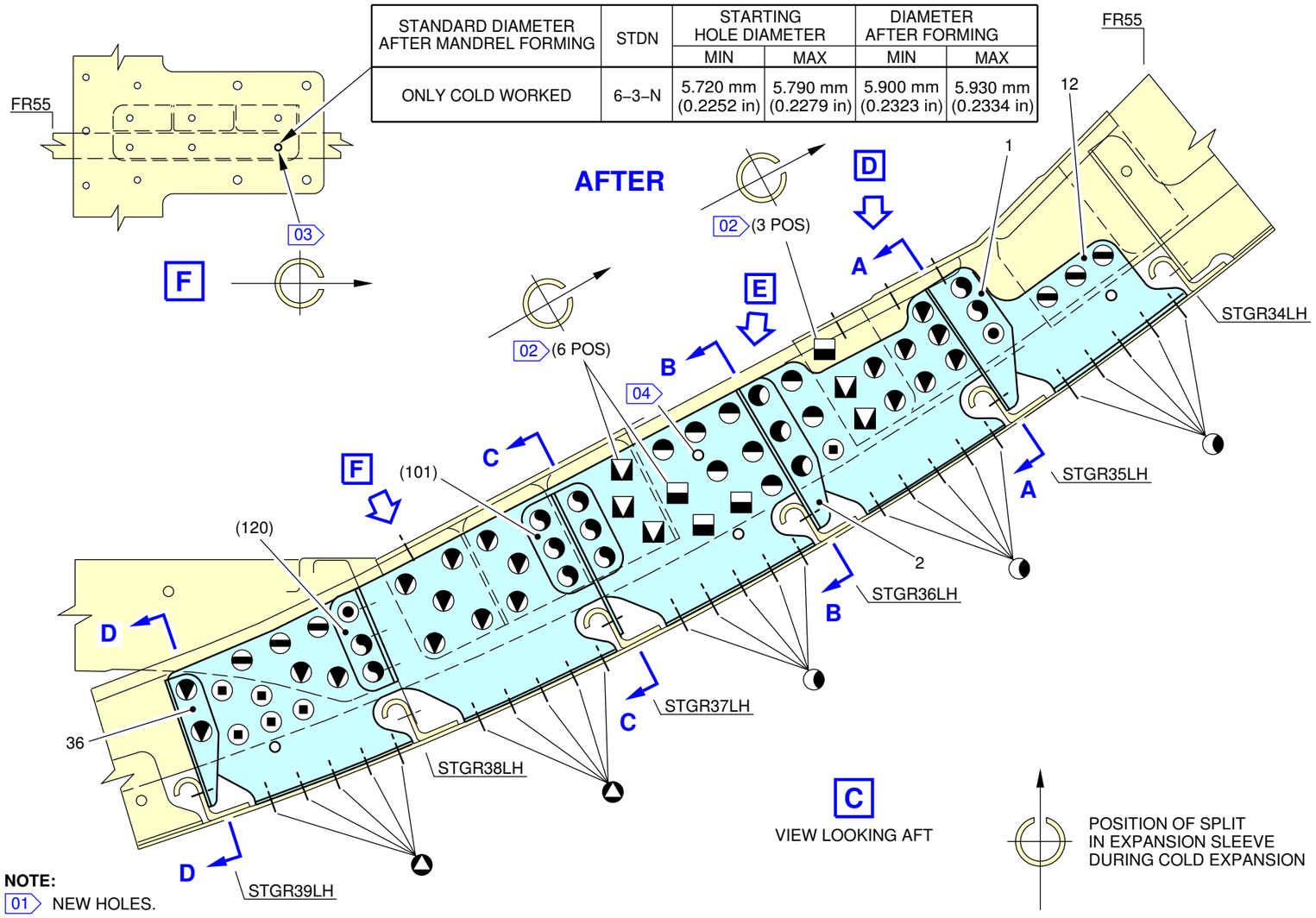
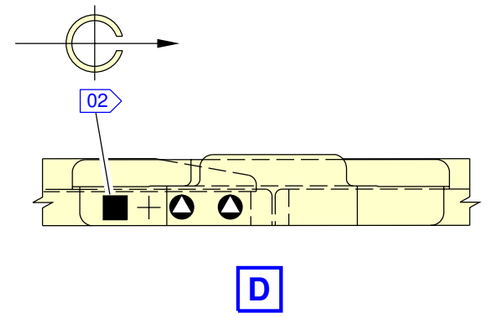
**CONF 008

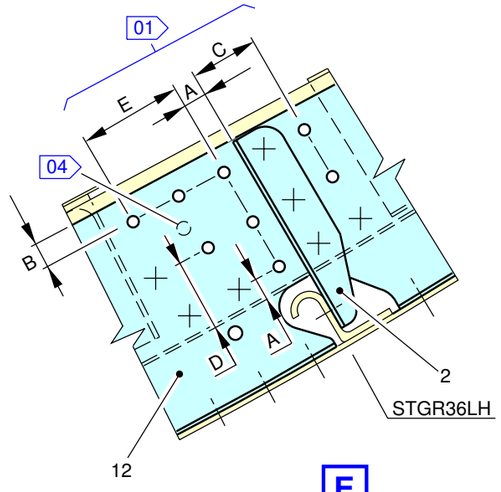
STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



C
VIEW LOOKING AFT

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION





VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES.

02 ◥◬◤ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

┼ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BFAH_02_01

Figure A-GBFAH - Sheet 02
Replacement of Webs and Angles at Frame 55

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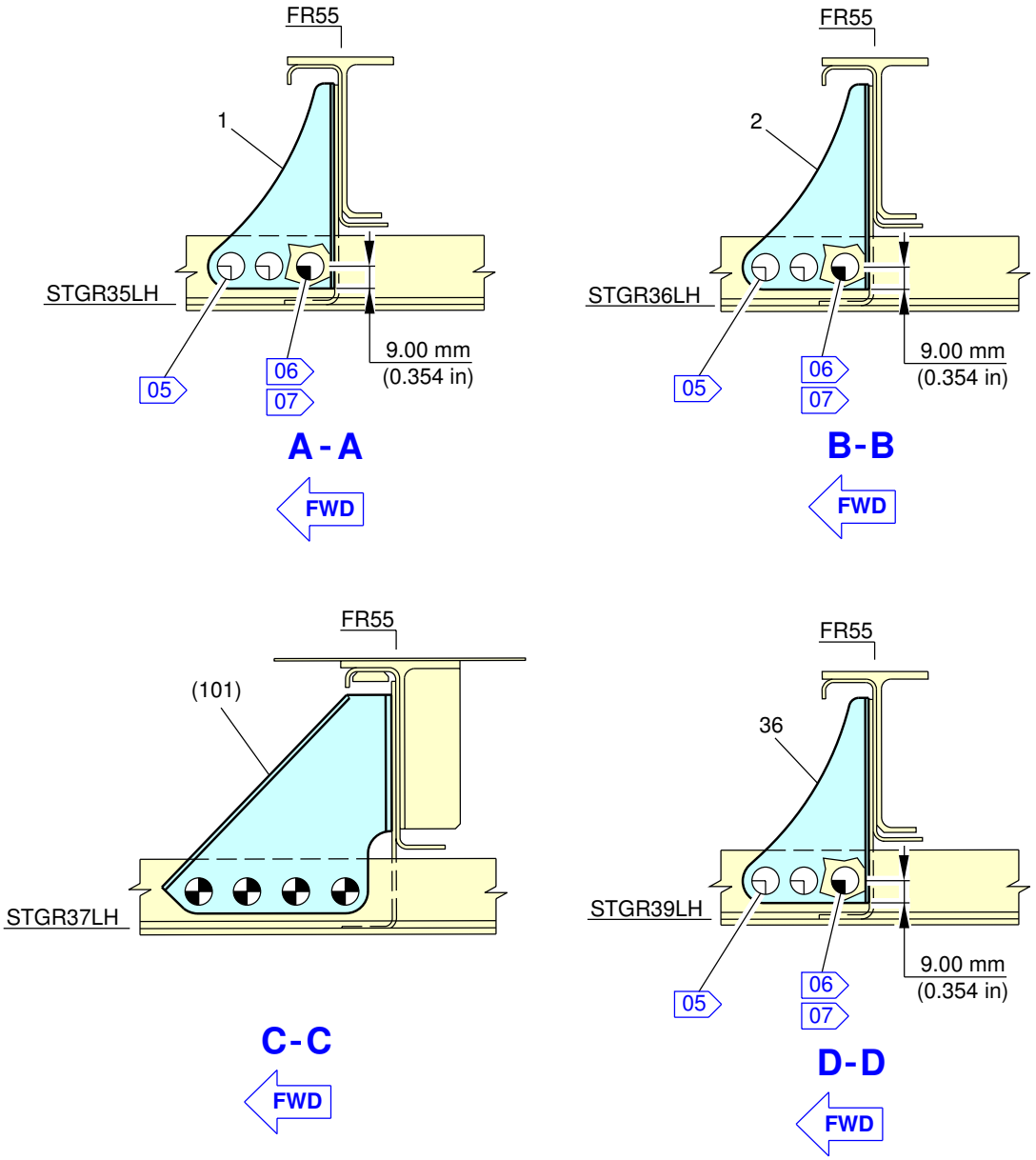
**CONF 008



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BFAH_03_01

Figure A-GBFAH - Sheet 03
Replacement of Webs and Angles at Frame 55

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**CONF 008

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BFAH_04_01

Figure A-GBFAH - Sheet 04
Replacement of Webs and Angles at Frame 55

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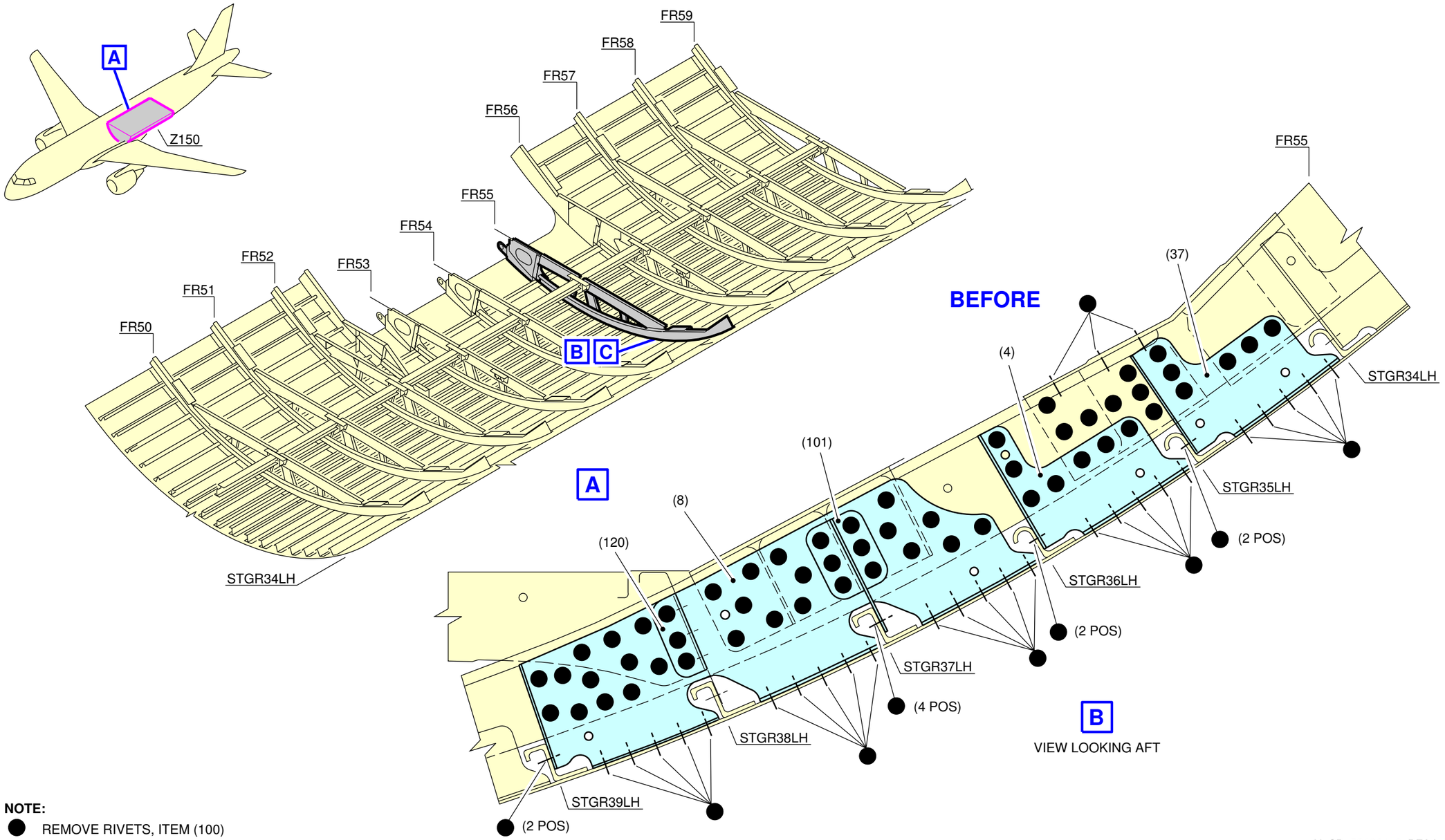
**CONF 009



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BFAJ_01_00

Figure A-GBFAJ - Sheet 01
Replacement of Webs and Angles at Frame 55

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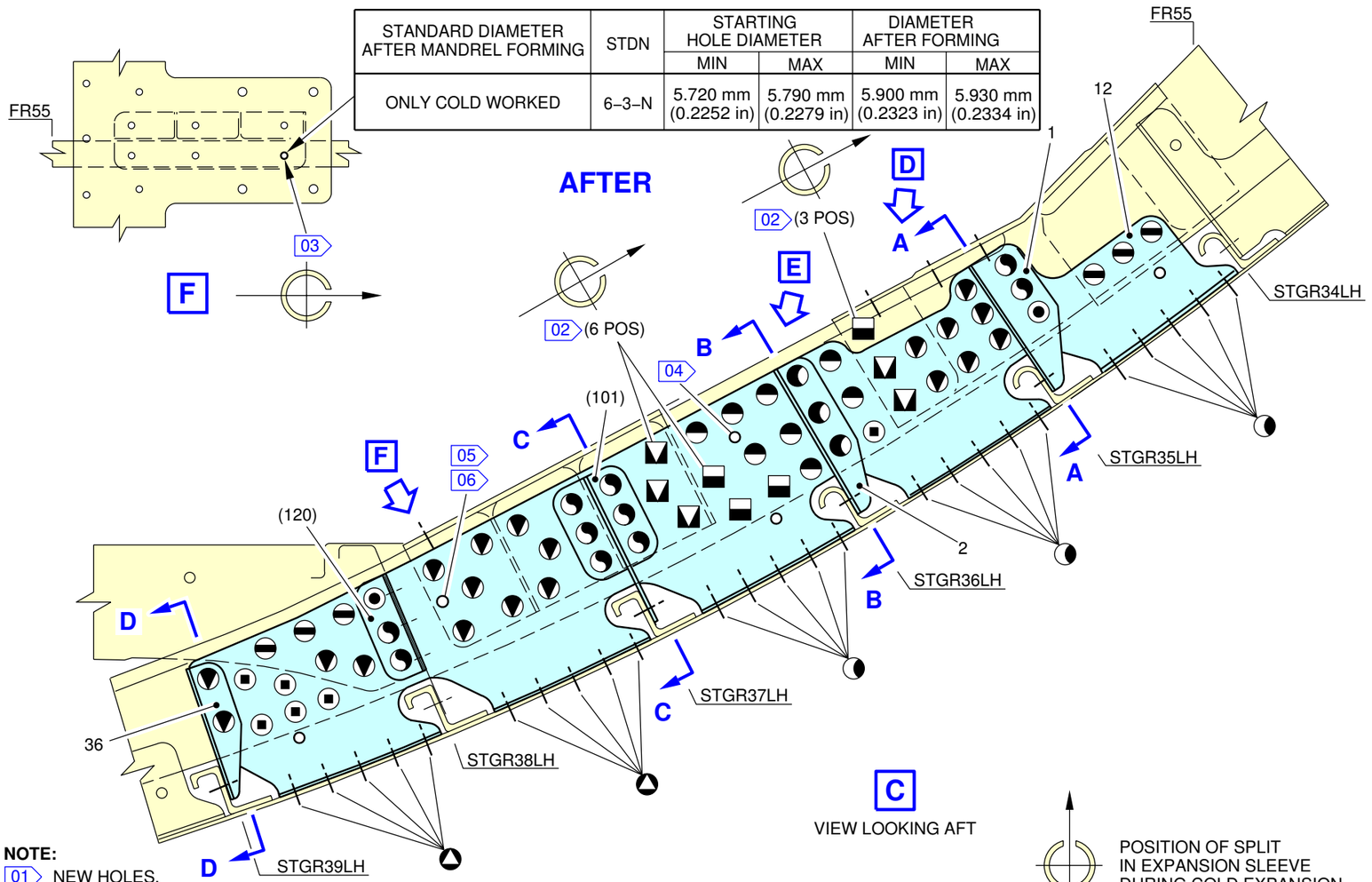
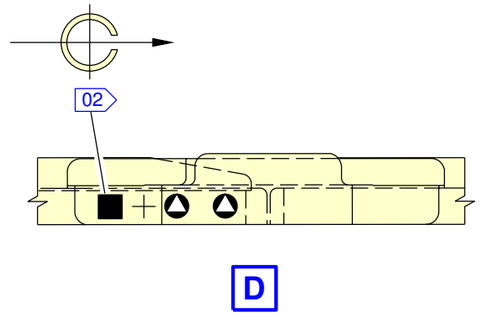
**CONF 009

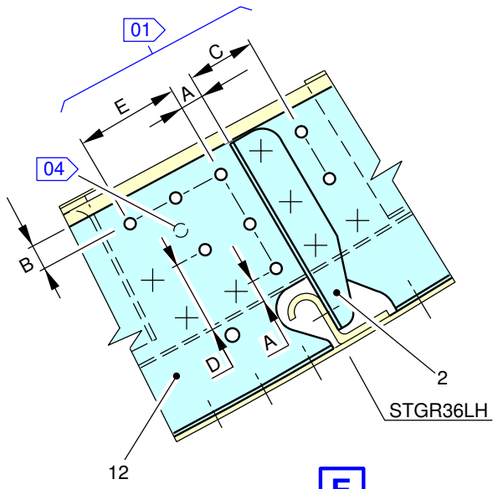
STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



C
VIEW LOOKING AFT

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION





E
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	29.60	1.165
D	32.00	1.260
E	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

05 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in).

06 VALID FOR MSN 4005 AND SUBSEQUENT.

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BFAJ_02_01

Figure A-GBFAJ - Sheet 02
Replacement of Webs and Angles at Frame 55

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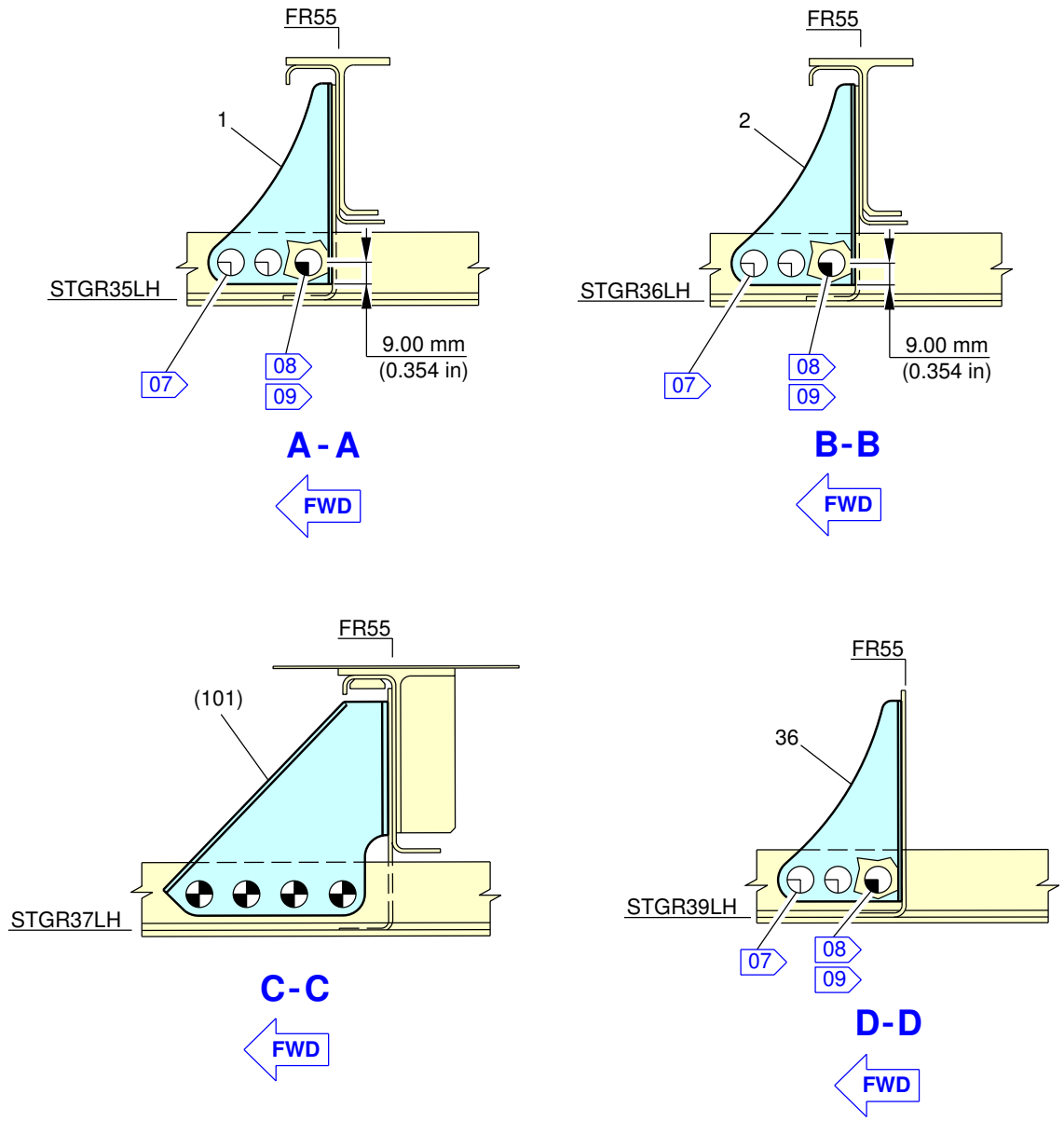
**CONF 009



NOTE:

07 EXISTING PILOT HOLES.

08 COUNTERSINK EXISTING HOLE IN THE STRINGER.

09 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BFAJ_03_01

Figure A-GBFAJ - Sheet 03
Replacement of Webs and Angles at Frame 55

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**CONF 009

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
⬓	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
▽	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
■	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
◒	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◑	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◓	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◱	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◉	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◐	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◍	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◔	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
⊖	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
◉	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
▲	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
◕	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BFAJ_04_01

Figure A-GBFAJ - Sheet 04
Replacement of Webs and Angles at Frame 55

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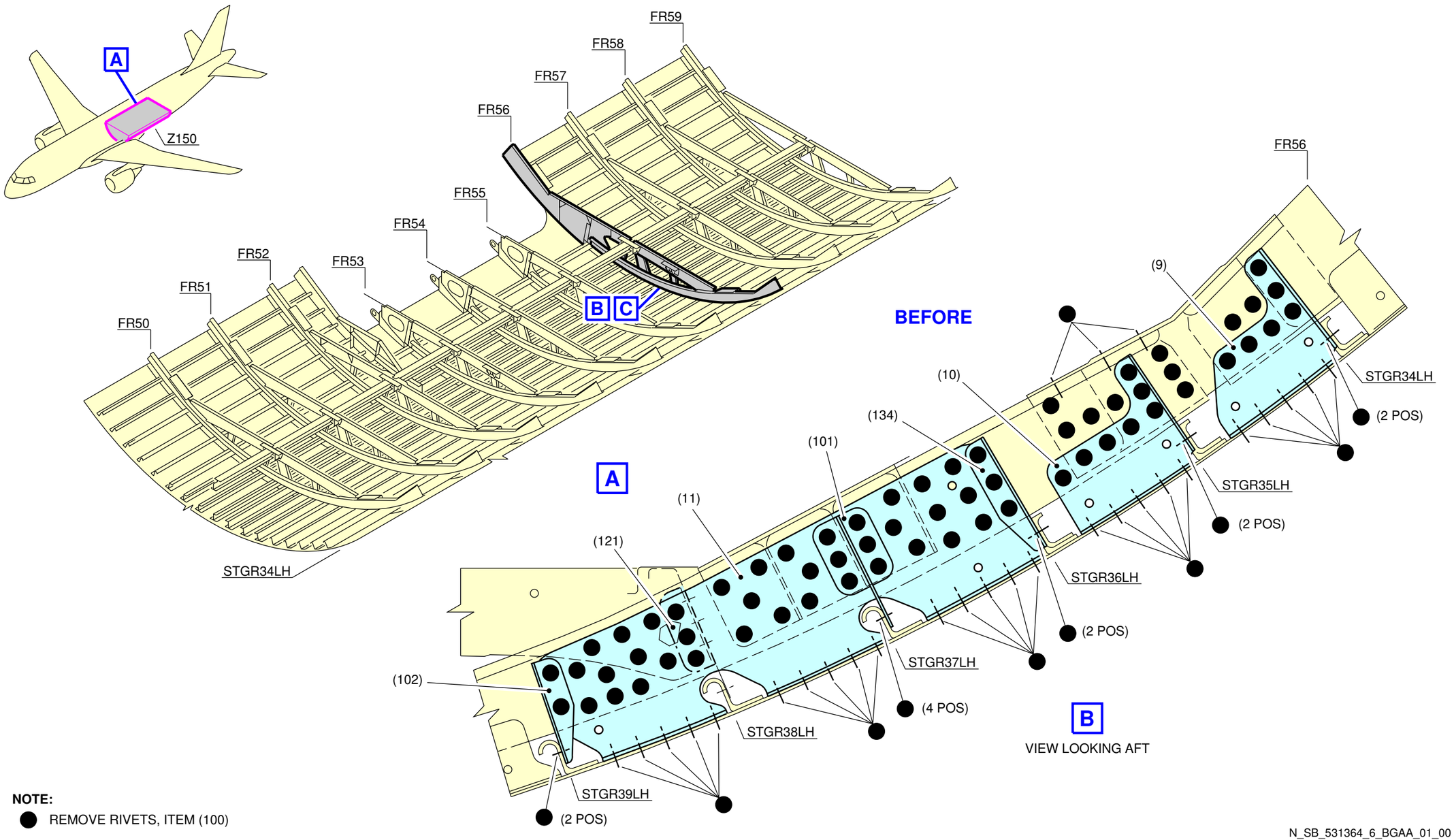
**CONF 001



BEFORE

NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BGAA_01_00

Figure A-GBGAA - Sheet 01
Replacement of Webs and Angles at Frame 56

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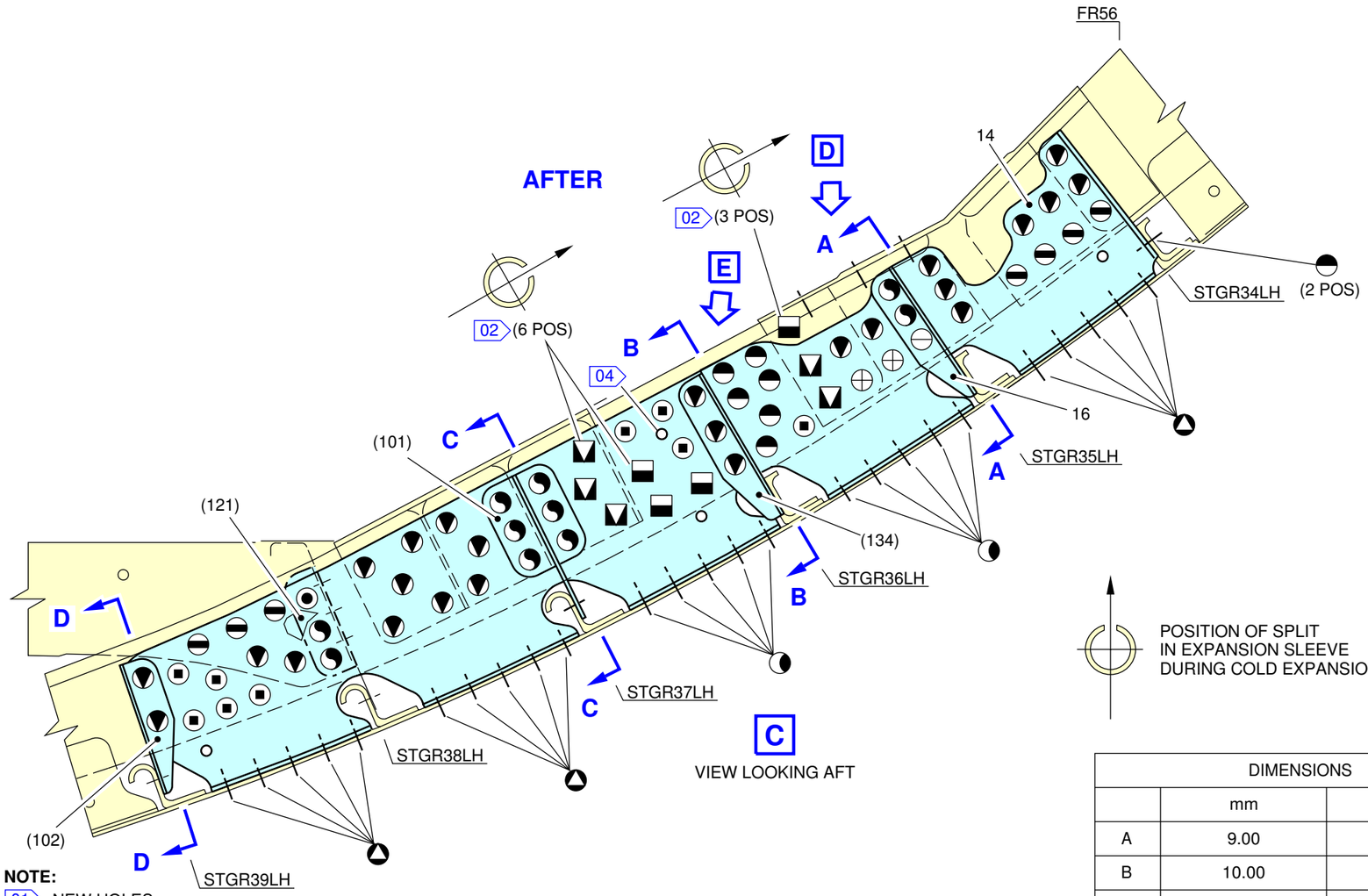
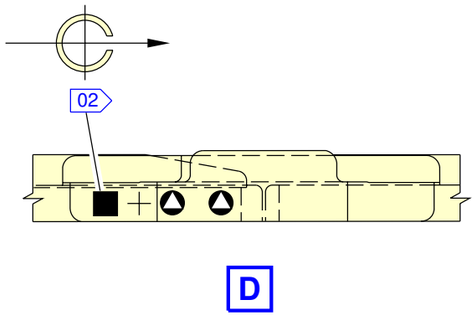
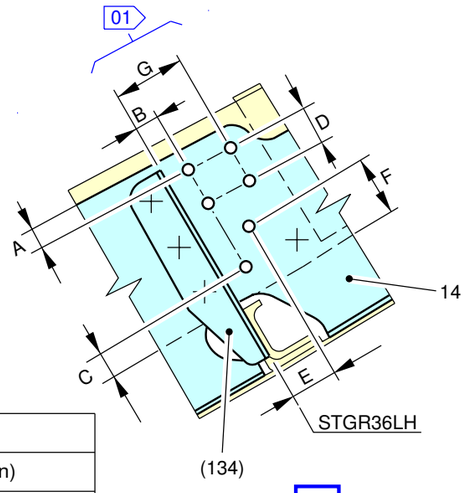
**CONF 001







POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

DIMENSIONS		
	mm	(in)
A	9.00	0.354
B	10.00	0.394
C	11.00	0.433
D	16.00	0.630
E	20.00	0.787
F	25.00	0.984
G	30.00	1.181

NOTE:

01 NEW HOLES

02 ◥◒■ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

┼ EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4

N_SB_531364_6_BGAA_02_01

Figure A-GBGAA - Sheet 02
Replacement of Webs and Angles at Frame 56

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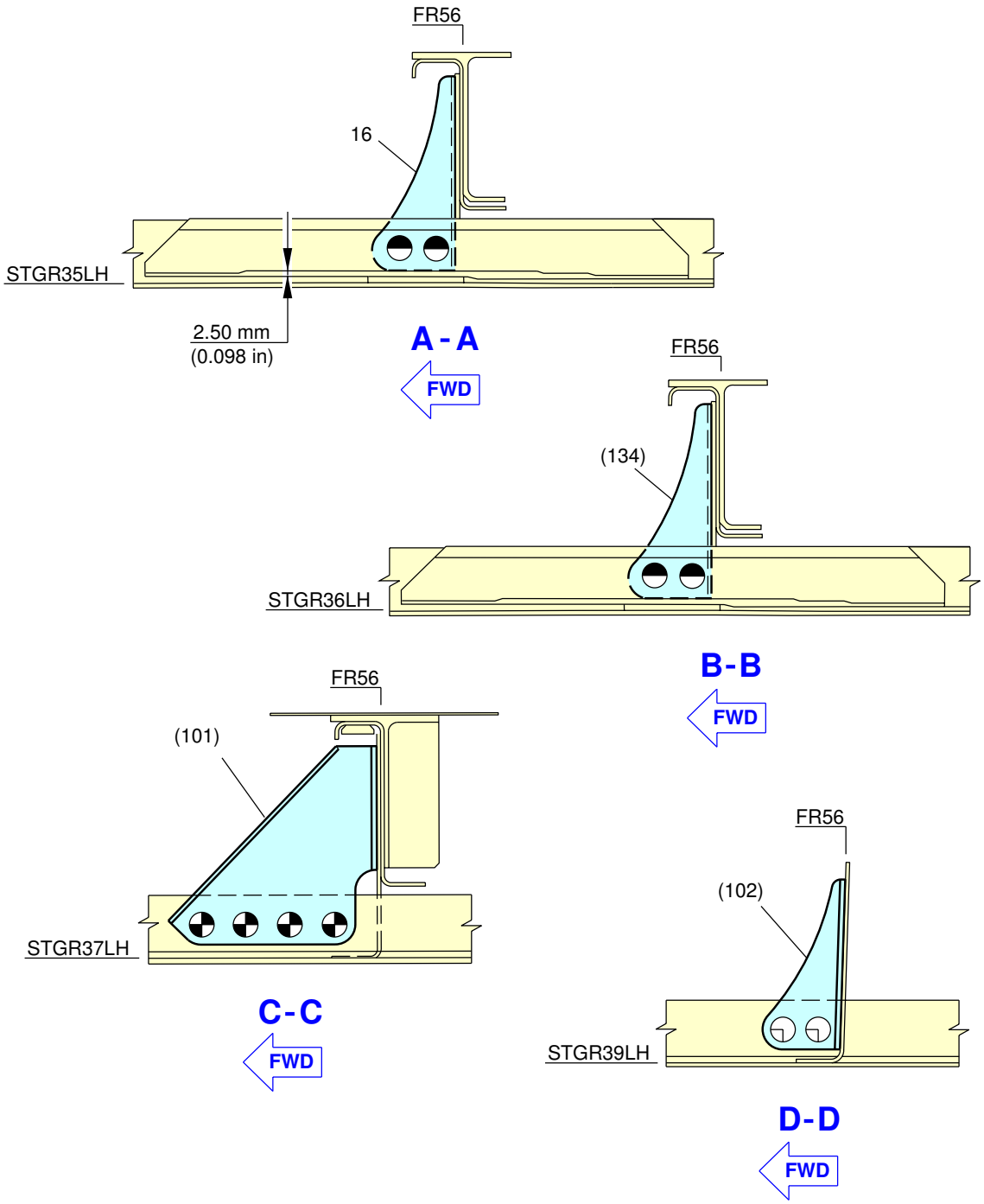
**CONF 001



NOTE:
FOR FASTENER SYMBOLS, REFER TO SHEET 4

N_SB_531364_6_BGAA_03_01

Figure A-GBGAA - Sheet 03
Replacement of Webs and Angles at Frame 56

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**CONF 001

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BGAA_04_01

Figure A-GBGAA - Sheet 04
Replacement of Webs and Angles at Frame 56

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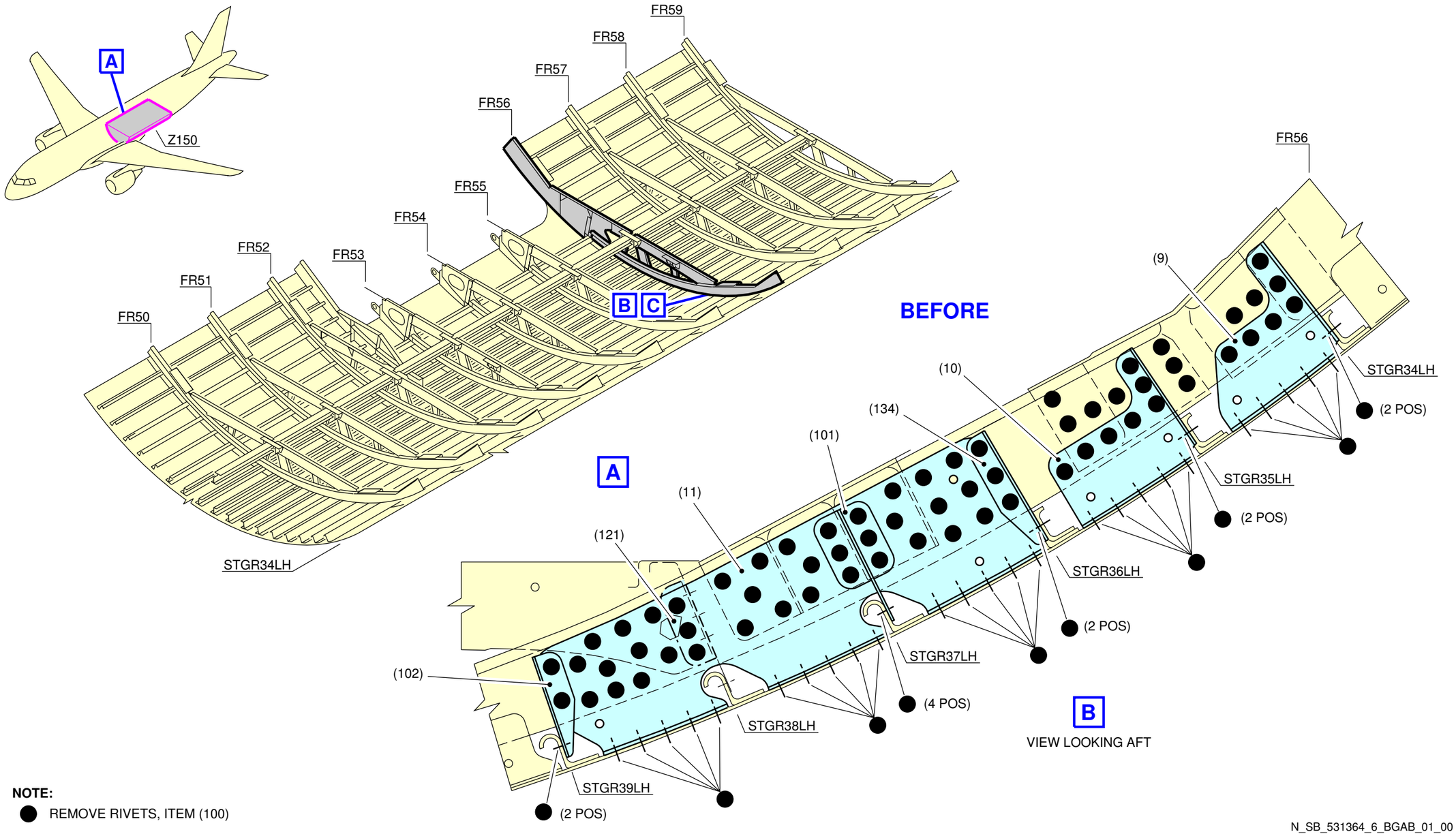
**CONF 002 thru 003



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BGAB_01_00

Figure A-GBGAB - Sheet 01
Replacement of Webs and Angles at Frame 56

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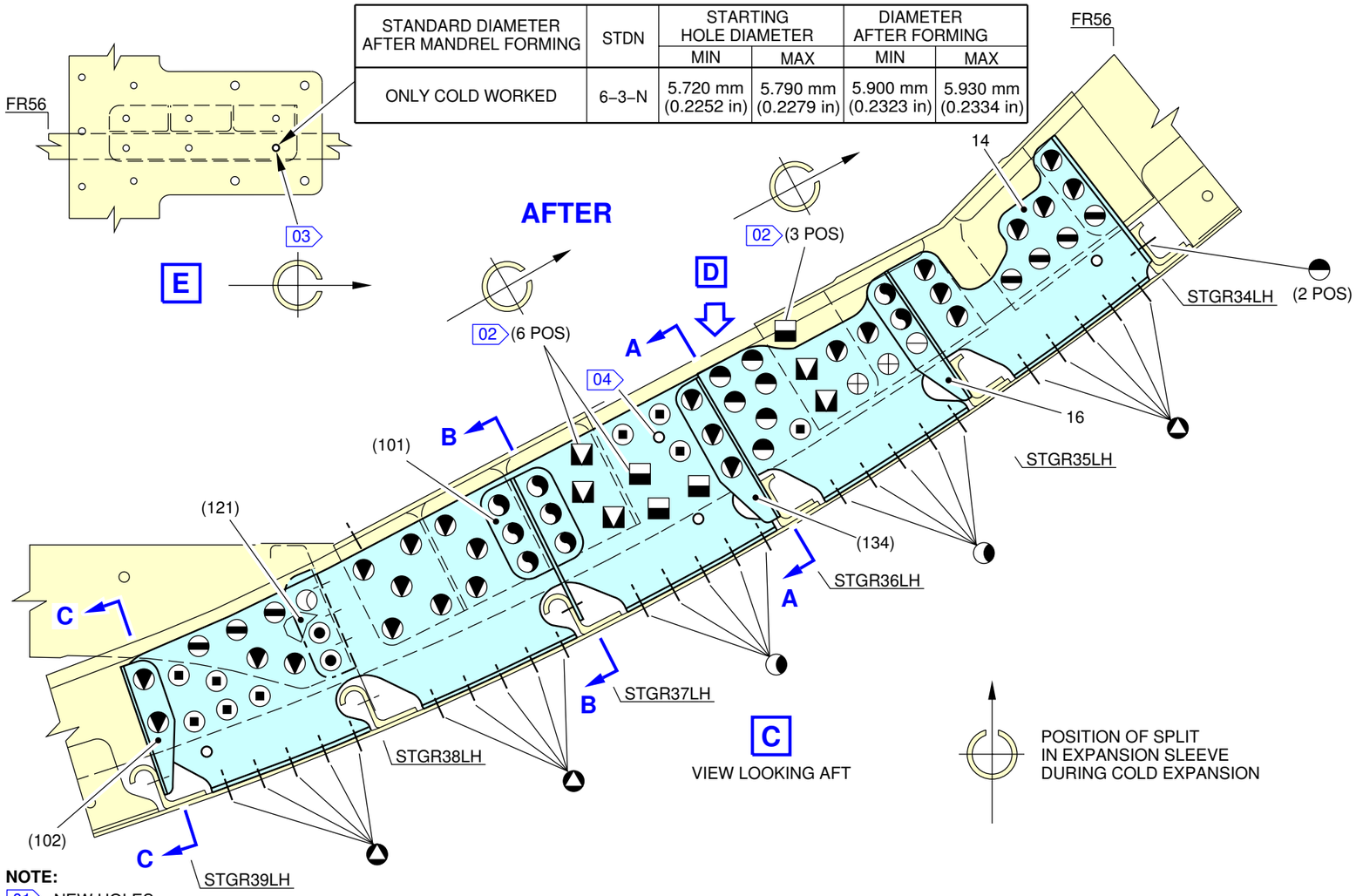
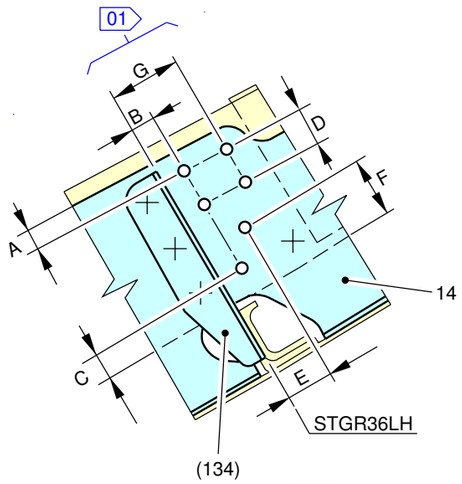
**CONF 002 thru 003

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)





POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

DIMENSIONS		
	mm	(in)
A	9.00	0.354
B	10.00	0.394
C	11.00	0.433
D	16.00	0.630
E	20.00	0.787
F	25.00	0.984
G	30.00	1.181

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BGAB_02_01

Figure A-GBGAB - Sheet 02
Replacement of Webs and Angles at Frame 56

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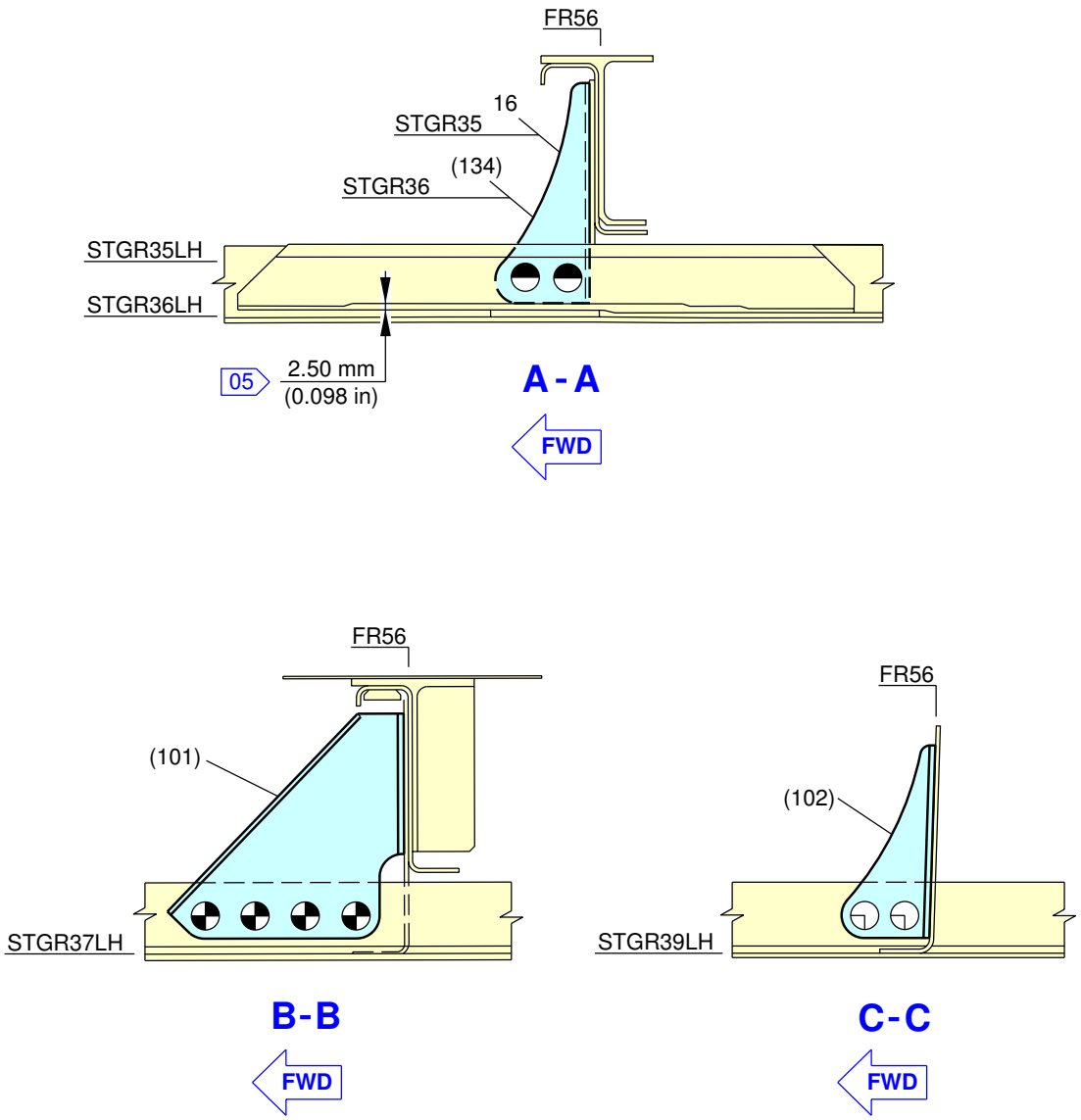
****CONF 002 thru 003**



NOTE:

05 ONLY EFFECTIVE FOR STGR35LH.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BGAB_03_01

Figure A-GBGAB - Sheet 03
Replacement of Webs and Angles at Frame 56

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**CONF 002 thru 003

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BGAB_04_01

Figure A-GBGAB - Sheet 04
Replacement of Webs and Angles at Frame 56

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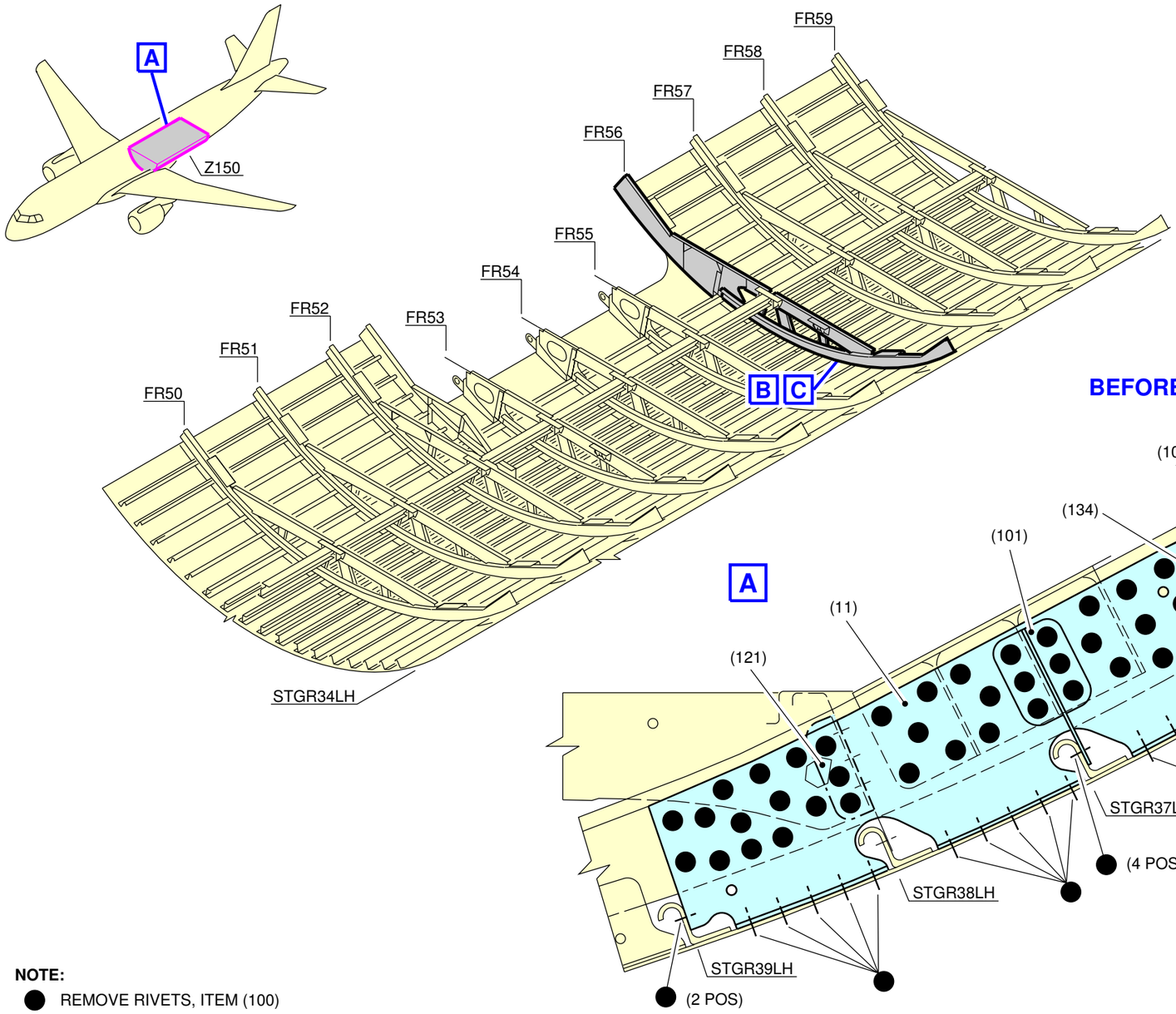
**CONF 004, 006



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BGAD_01_00

Figure A-GBGAD - Sheet 01
Replacement of Webs and Angles at Frame 56

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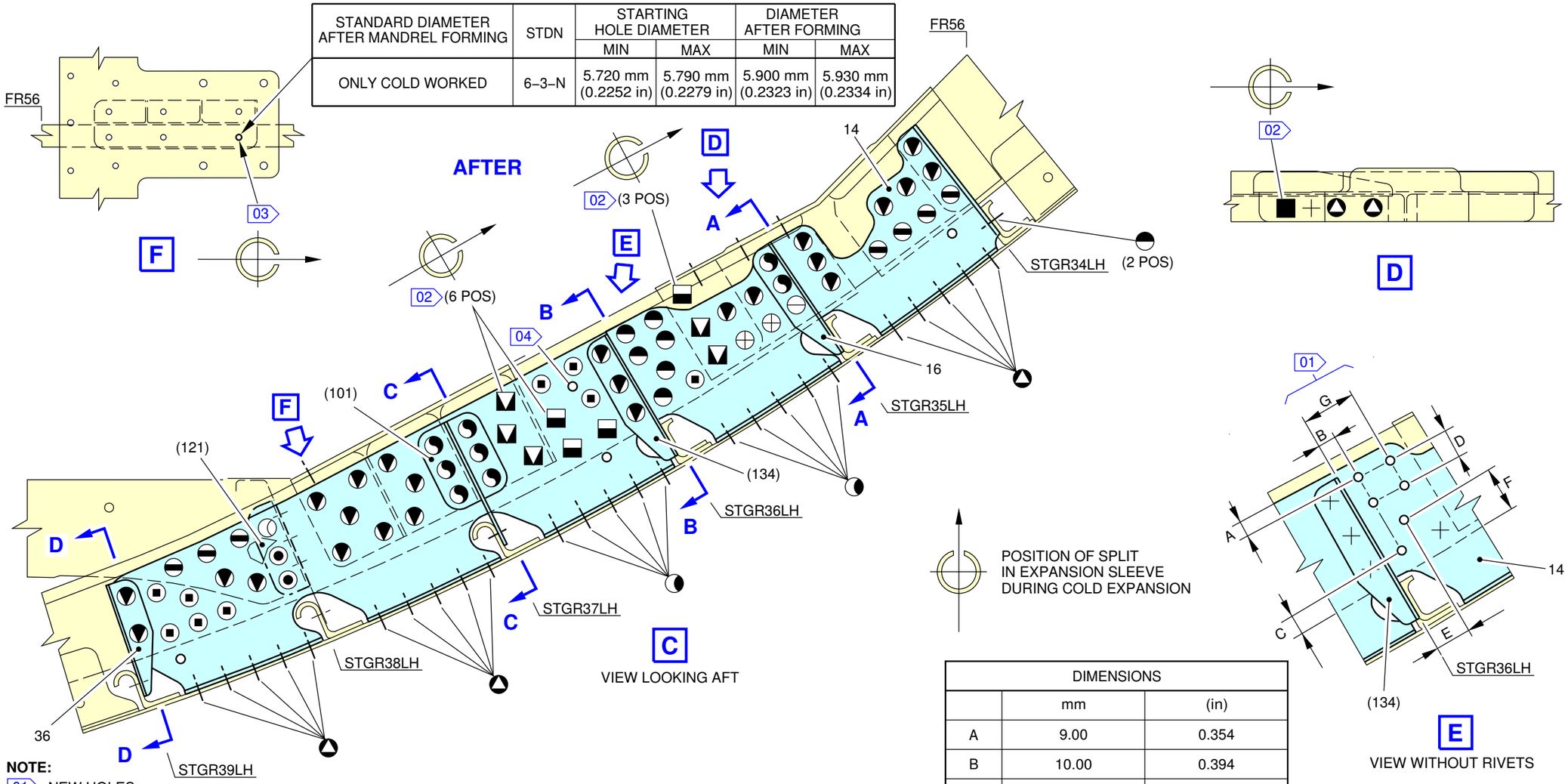
**CONF 004, 006

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

DIMENSIONS		
	mm	(in)
A	9.00	0.354
B	10.00	0.394
C	11.00	0.433
D	16.00	0.630
E	20.00	0.787
F	25.00	0.984
G	30.00	1.181

NOTE:

01 NEW HOLES.

02 ▼▬■ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

┼ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BGAD_02_01

Figure A-GBGAD - Sheet 02
Replacement of Webs and Angles at Frame 56

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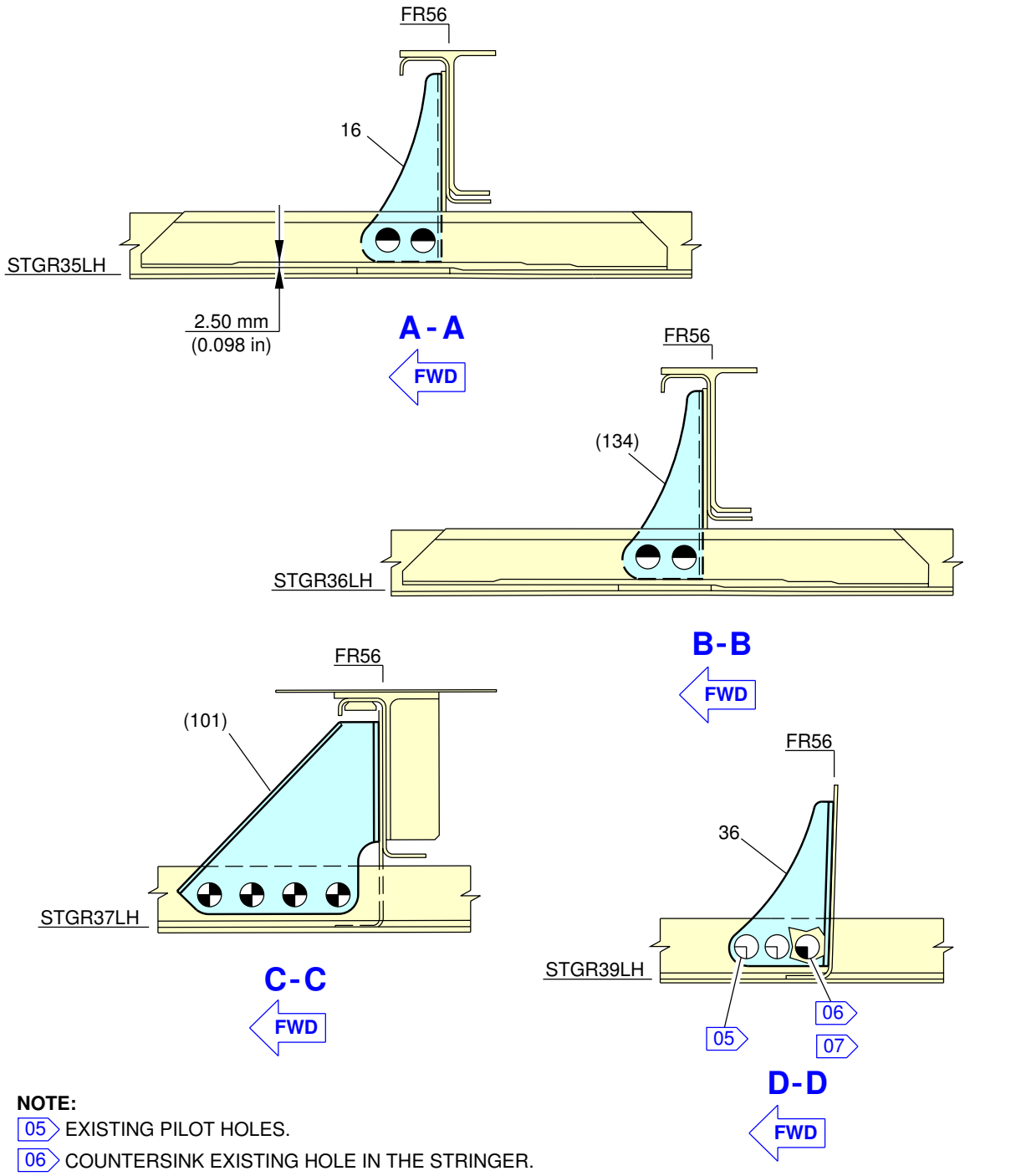
****CONF 004, 006**



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BGAD_03_01

Figure A-GBGAD - Sheet 03
Replacement of Webs and Angles at Frame 56

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**CONF 004, 006

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BGAD_04_01

Figure A-GBGAD - Sheet 04
Replacement of Webs and Angles at Frame 56

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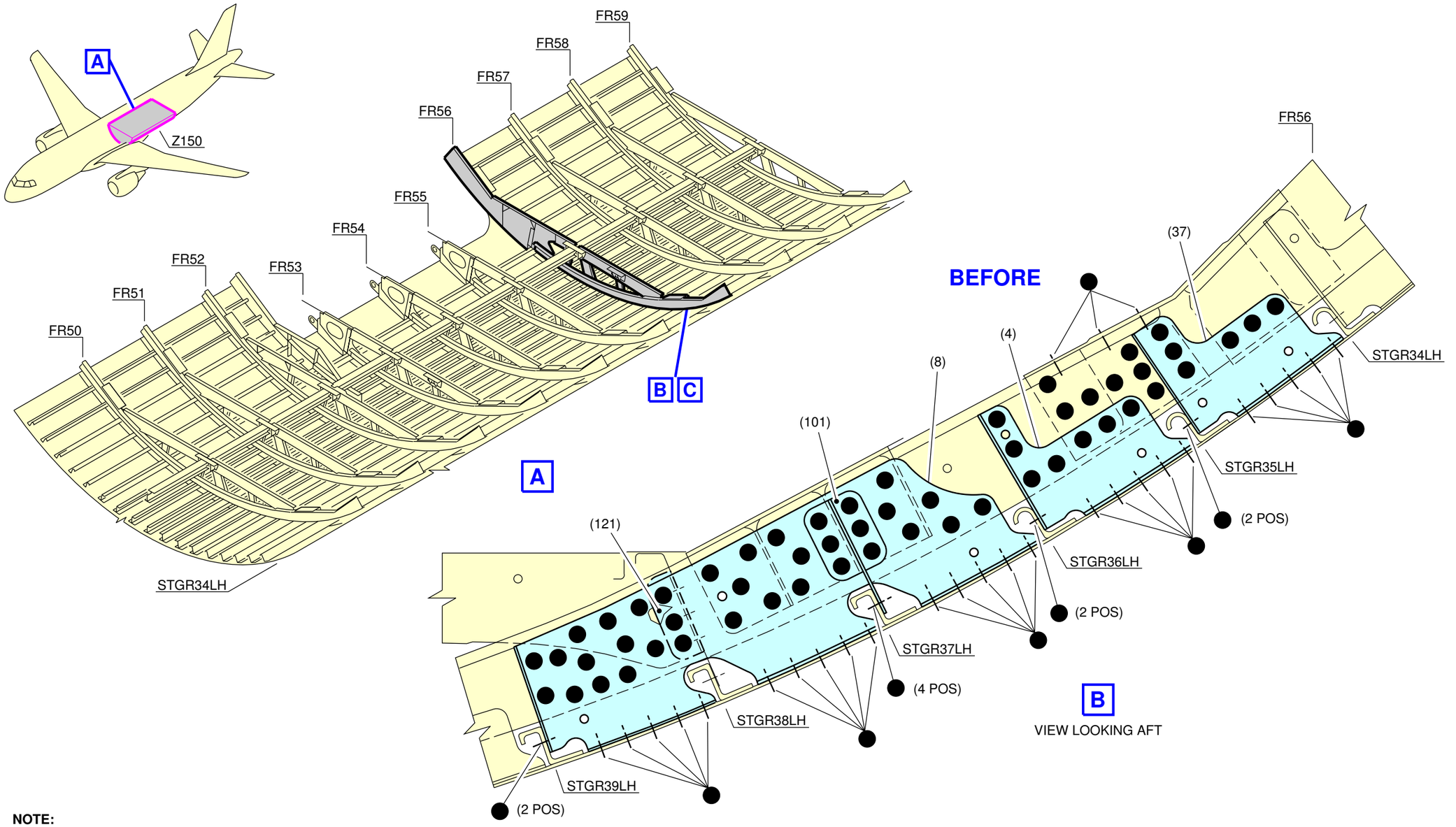
**CONF 005, 007



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BGAE_01_00

Figure A-GBGAE - Sheet 01
Replacement of Webs and Angles at Frame 56

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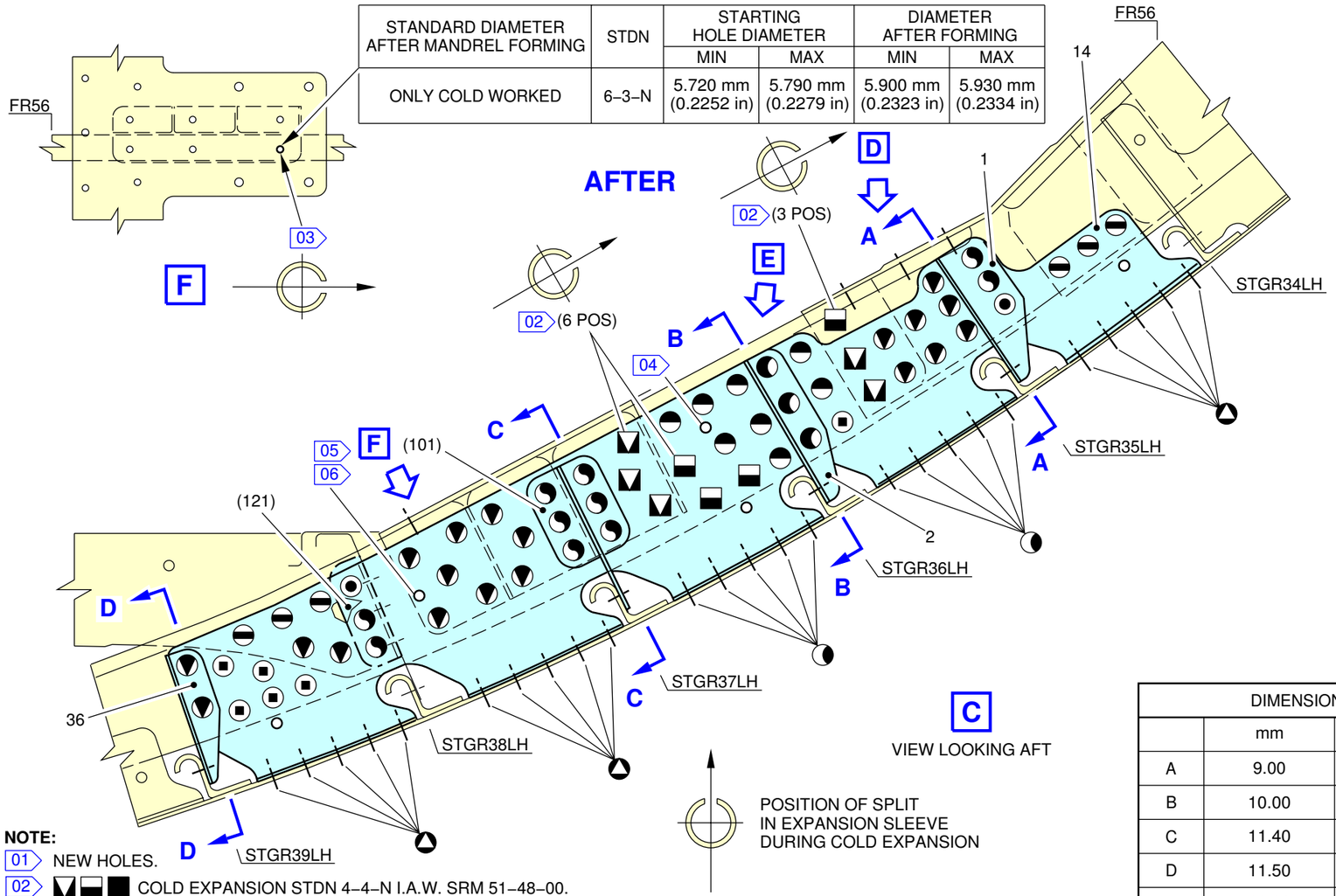
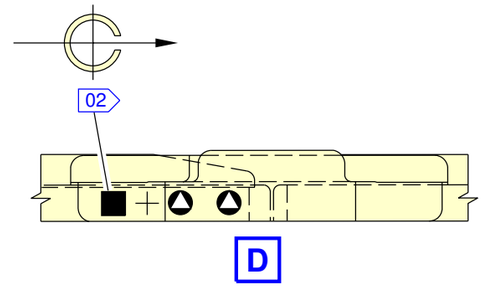
**CONF 005, 007

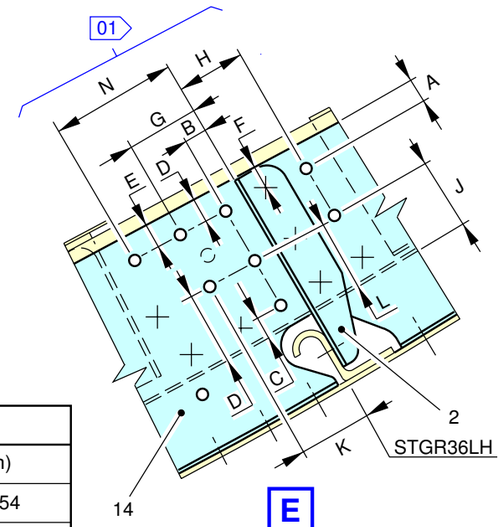
STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



VIEW LOOKING AFT

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION





VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	9.00	0.354
B	10.00	0.394
C	11.40	0.449
D	11.50	0.453
E	12.00	0.472
F	12.40	0.488
G	29.90	1.177
H	30.00	1.181
J	30.10	1.185

DIMENSIONS		
	mm	(in)
K	30.50	1.201
L	33.70	1.327
M	34.00	1.339
N	55.30	2.177

NOTE:

01 NEW HOLES.

02 ◥◨■ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

05 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB, TO A DIAMETER OF 4.300 mm (0.1692 in).

06 VALID FOR MSN 4005 AND SUBSEQUENT.

┼ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BGAE_02_01

Figure A-GBGAE - Sheet 02
Replacement of Webs and Angles at Frame 56

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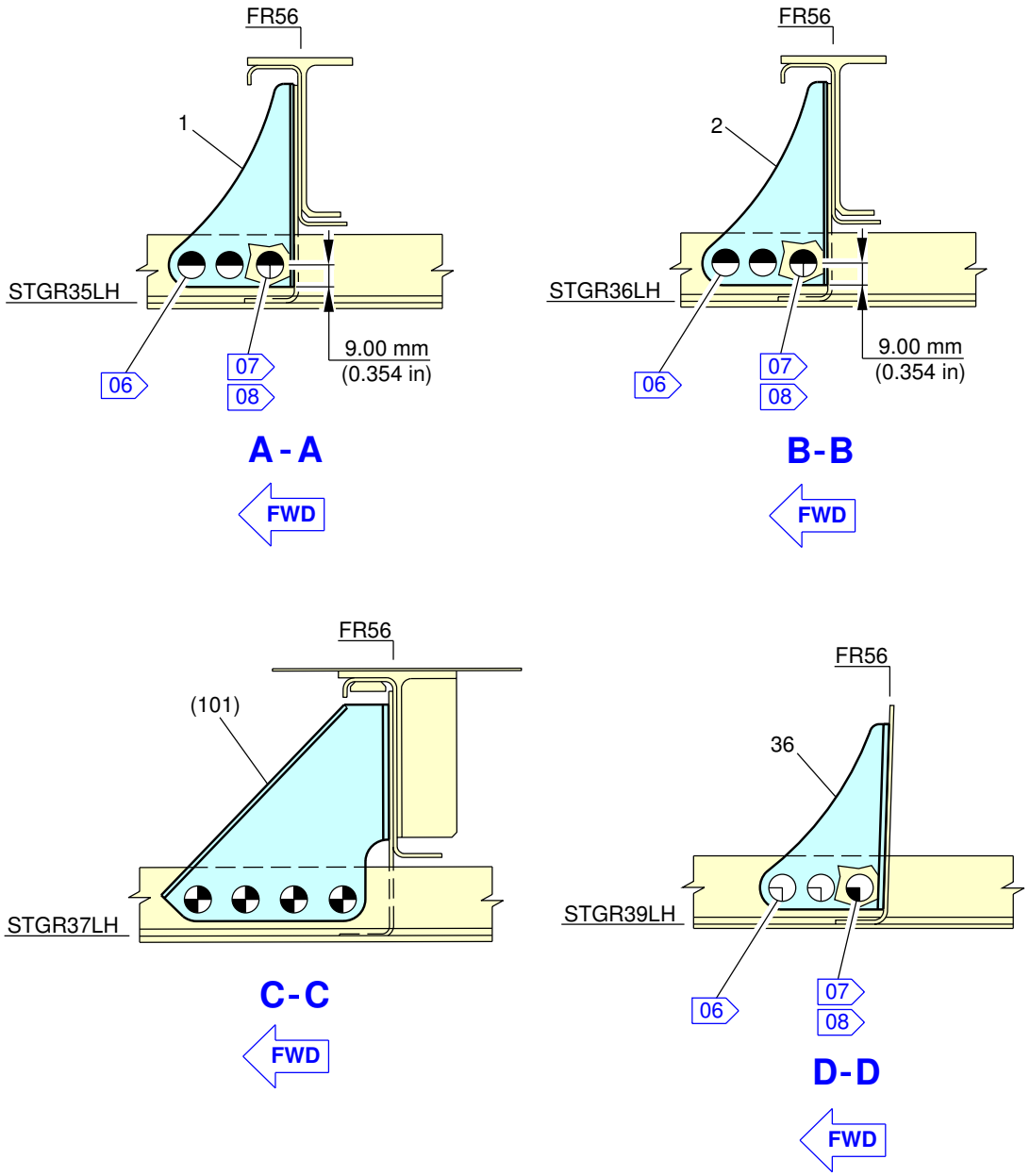
**CONF 005, 007



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BGAE_03_01

Figure A-GBGAE - Sheet 03
Replacement of Webs and Angles at Frame 56

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**CONF 005, 007

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BGAE_04_01

Figure A-GBGAE - Sheet 04
Replacement of Webs and Angles at Frame 56

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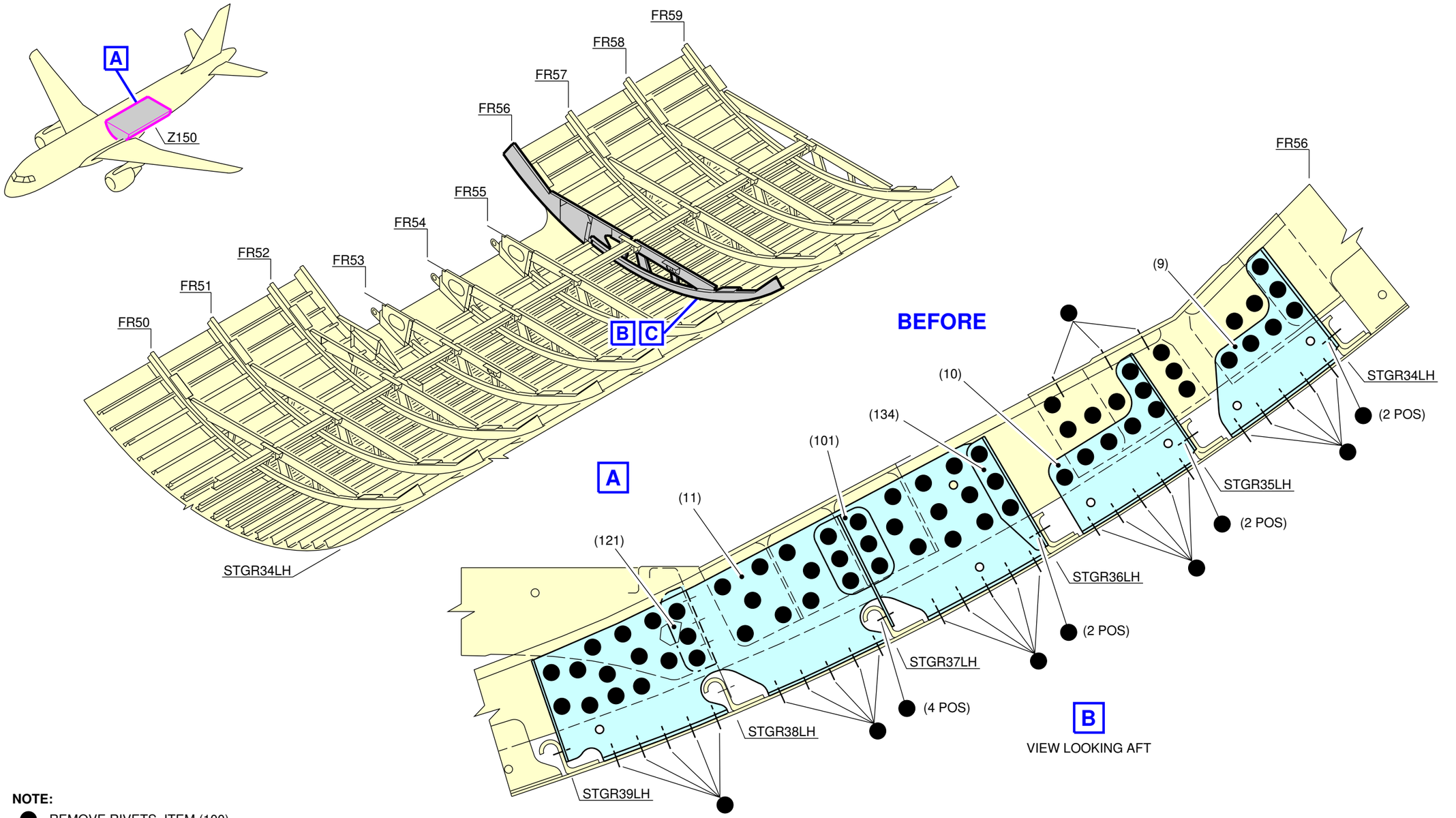
**CONF 008



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BGAH_01_00

Figure A-GBGAH - Sheet 01
Replacement of Webs and Angles at Frame 56

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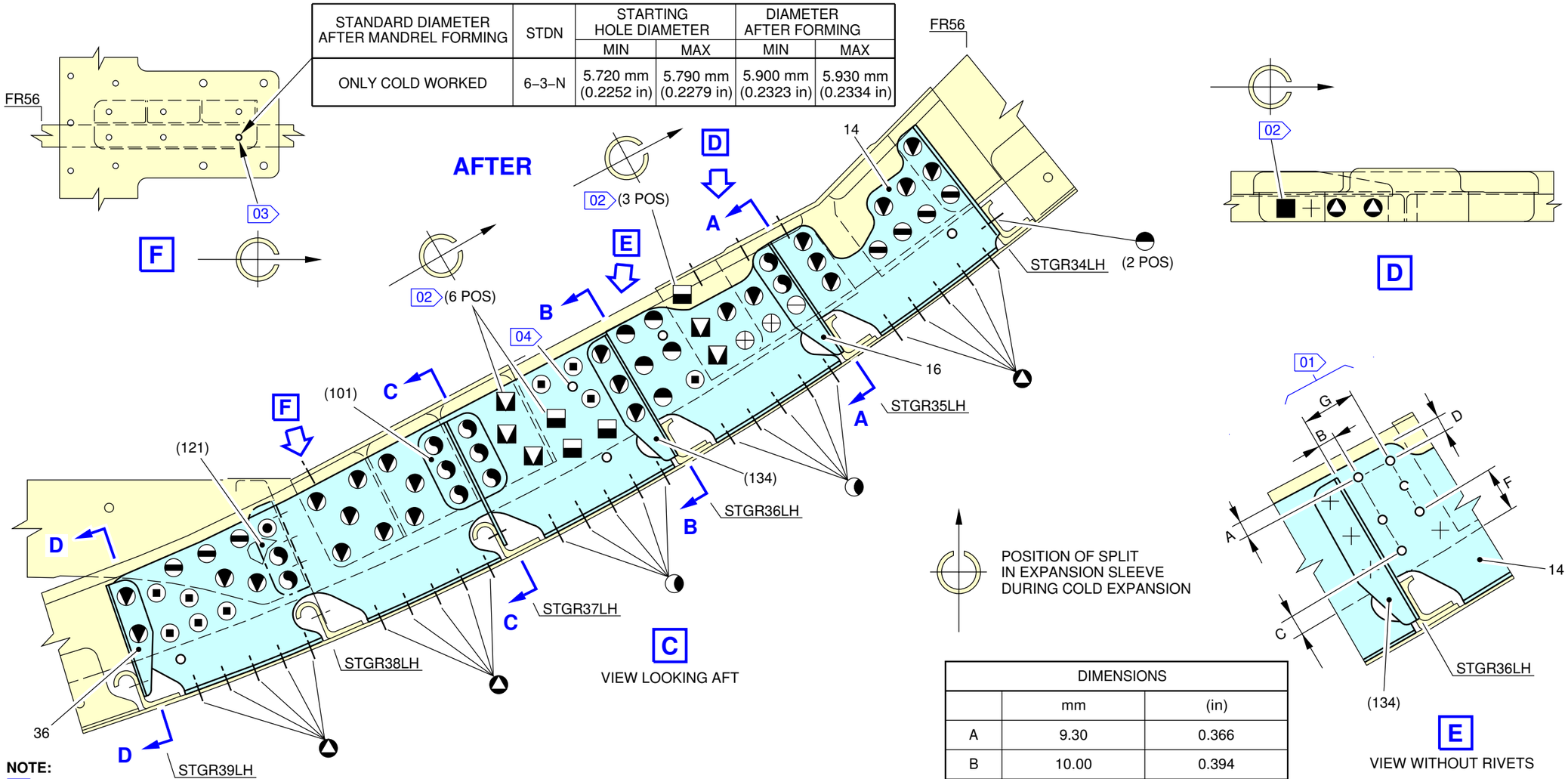
**CONF 008

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

DIMENSIONS		
	mm	(in)
A	9.30	0.366
B	10.00	0.394
C	11.30	0.445
D	9.00	0.354
F	30.10	1.185
G	30.00	1.181

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BGAH_02_01

Figure A-GBGAH - Sheet 02
Replacement of Webs and Angles at Frame 56

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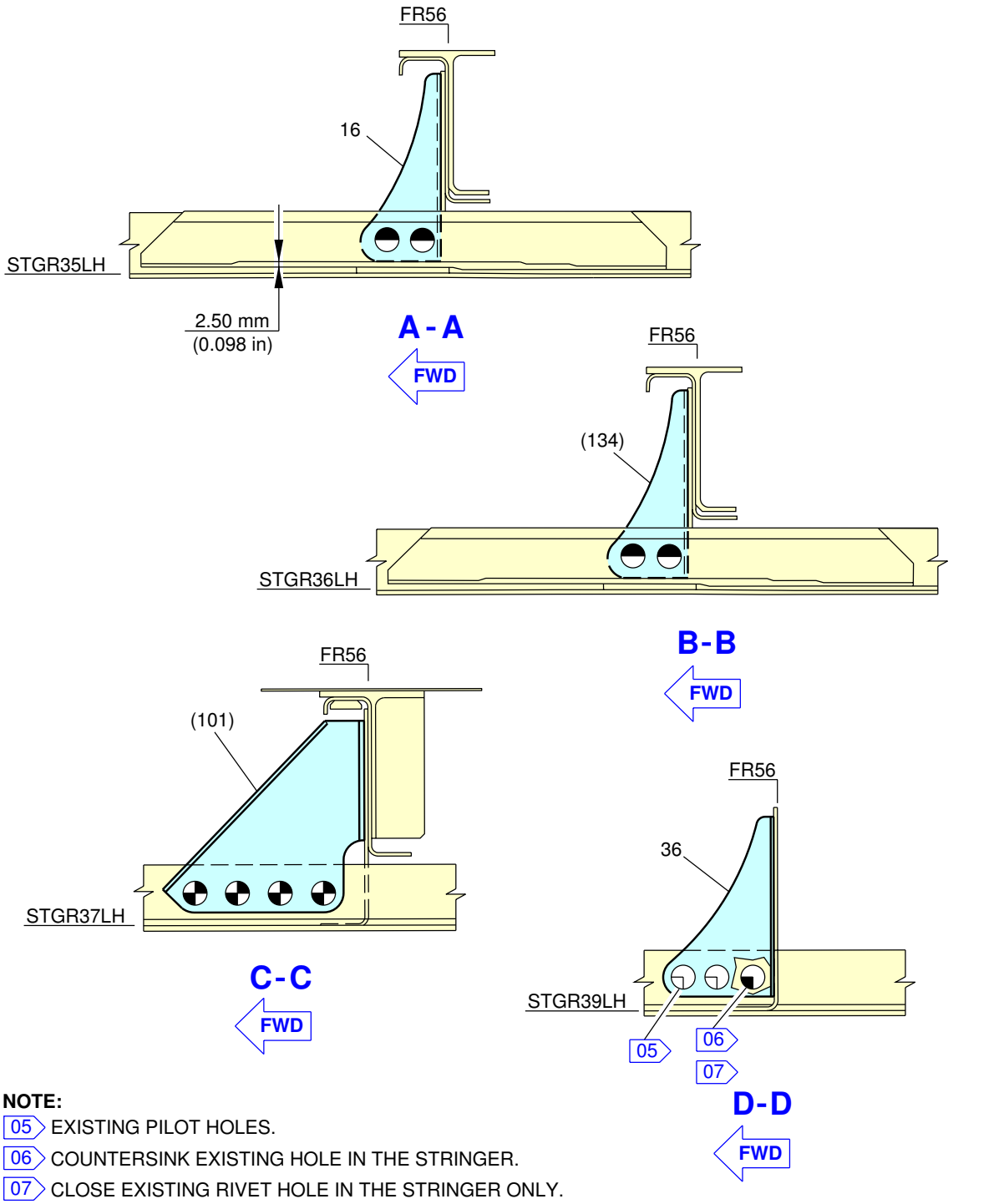
**CONF 008



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BGAH_03_01

Figure A-GBGAH - Sheet 03
Replacement of Webs and Angles at Frame 56

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**CONF 008

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
◒	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
▽	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
■	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
◒	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◑	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◓	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◱	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◙	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
▼	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◔	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
⊖	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
◉	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
▲	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
◕	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
⊕	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
⊖	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BGAH_04_01

Figure A-GBGAH - Sheet 04
Replacement of Webs and Angles at Frame 56

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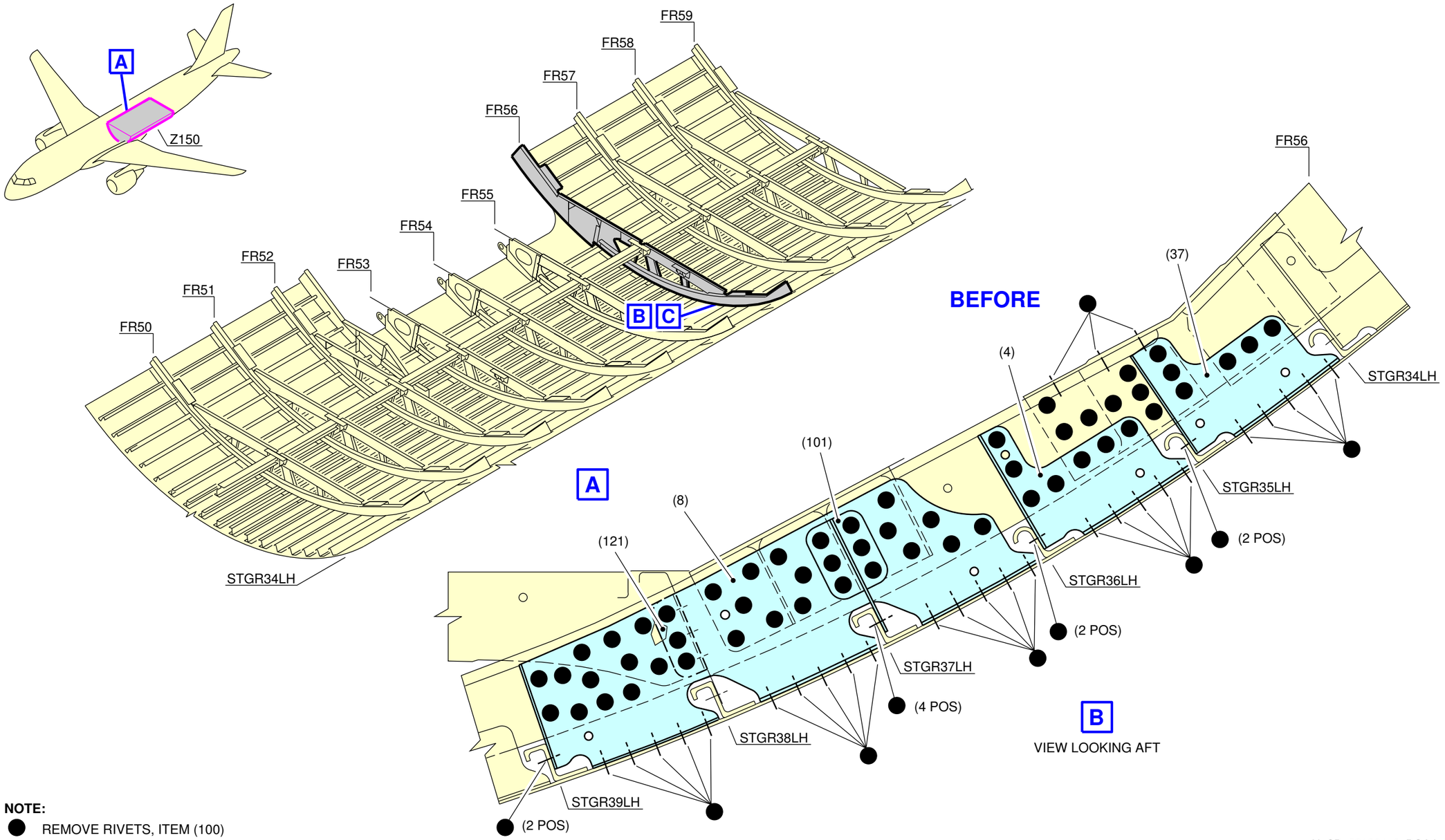
**CONF 009



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BGAJ_01_00

Figure A-GBGAJ - Sheet 01
Replacement of Webs and Angles at Frame 56

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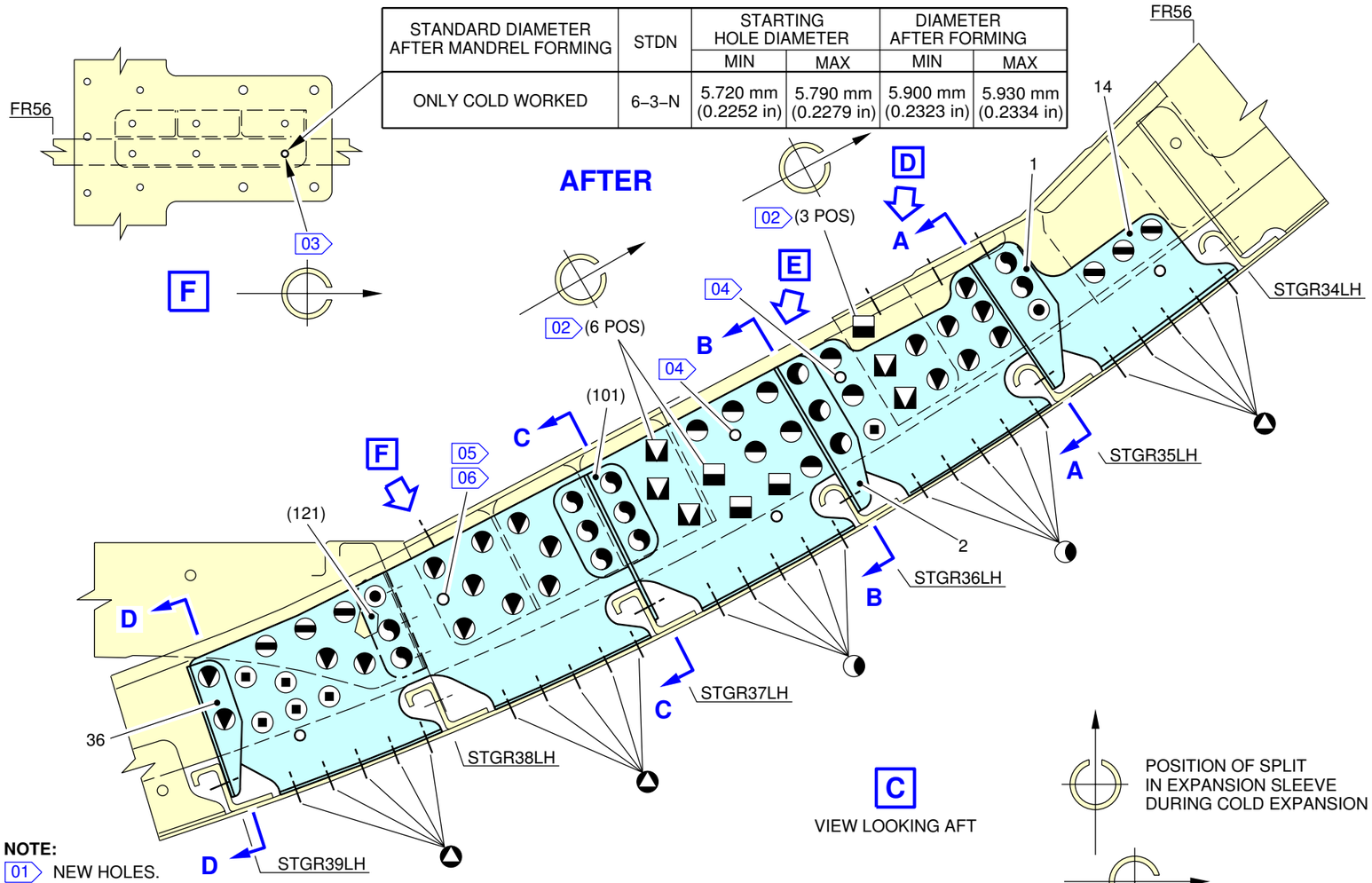
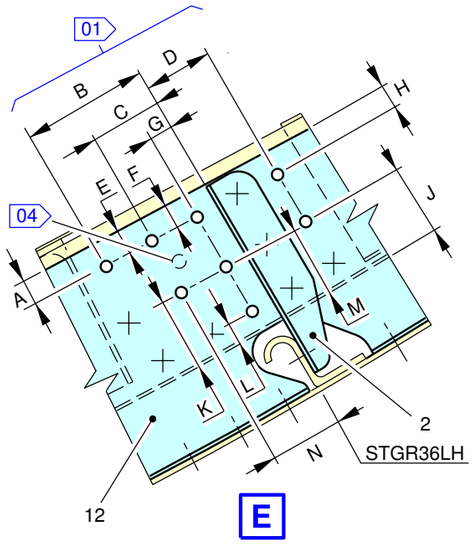
**CONF 009

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



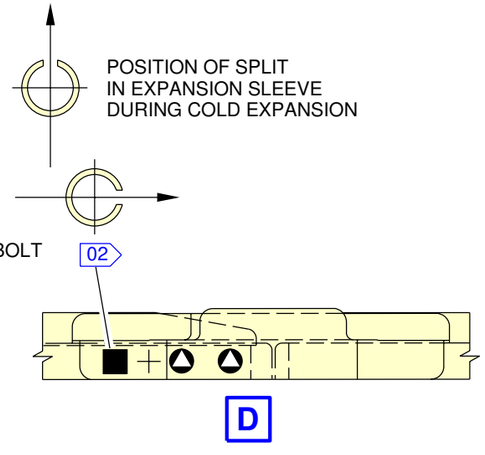
C

VIEW LOOKING AFT



E

VIEW WITHOUT RIVETS



DIMENSIONS		
	mm	(in)
A	12.00	0.472
B	55.30	2.177
C	29.90	1.177
D	30.00	1.181
E	11.50	0.453
F	12.40	0.488
G	10.00	0.394
H	9.00	0.354
J	30.10	1.185
K	34.00	1.339
L	11.40	0.449
M	33.70	1.327
N	30.50	1.201

N_SB_531364_6_BGAJ_02_01

NOTE:

01 NEW HOLES.

02 ■ ■ ■ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

05 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in).

06 VALID FOR MSN 4005 AND SUBSEQUENT.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

Figure A-GBGAJ - Sheet 02
Replacement of Webs and Angles at Frame 56

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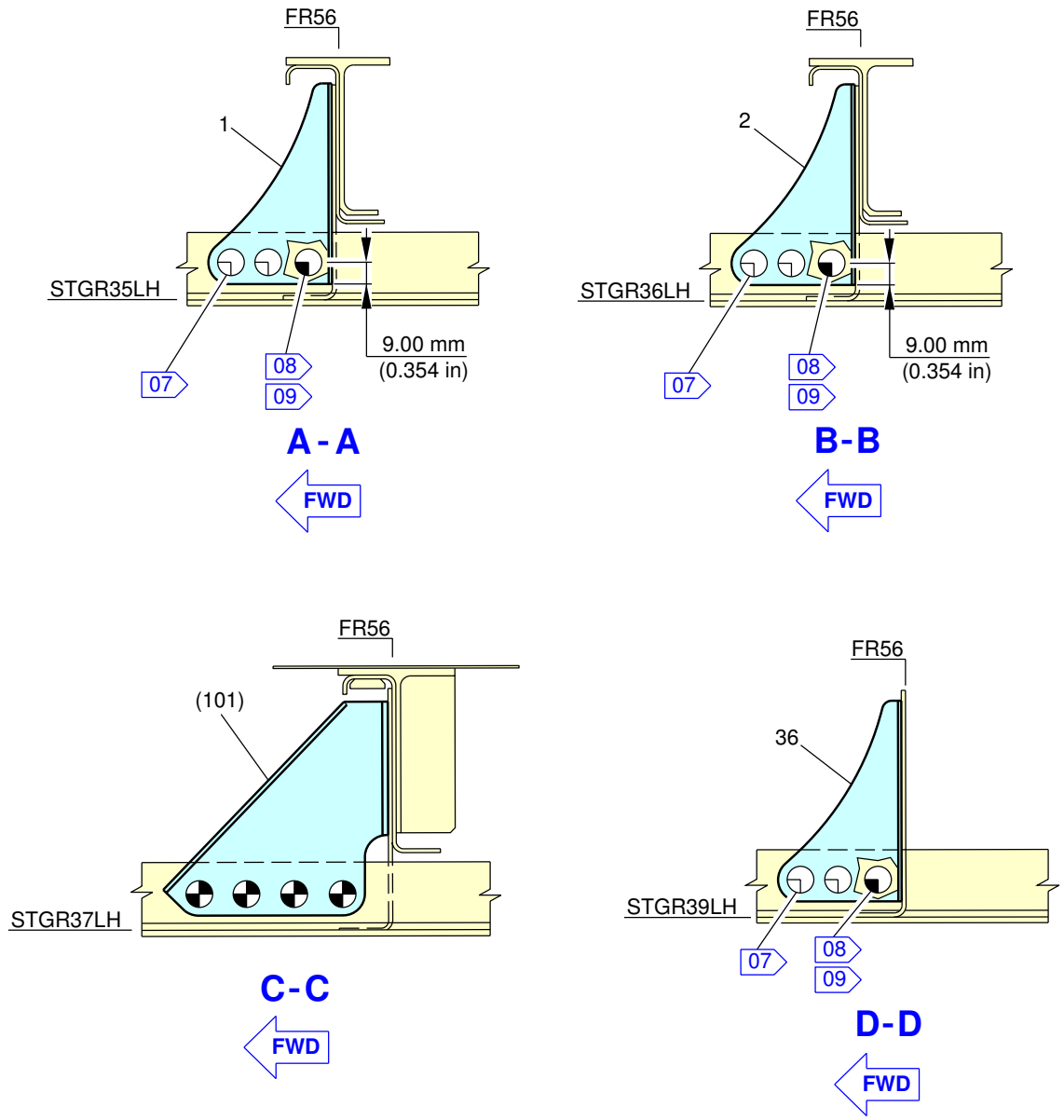
**CONF 009



NOTE:

07 EXISTING PILOT HOLES.

08 COUNTERSINK EXISTING HOLE IN THE STRINGER.

09 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BGAJ_03_01

Figure A-GBGAJ - Sheet 03
Replacement of Webs and Angles at Frame 56

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**CONF 009

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BGAJ_04_01

Figure A-GBGAJ - Sheet 04
Replacement of Webs and Angles at Frame 56

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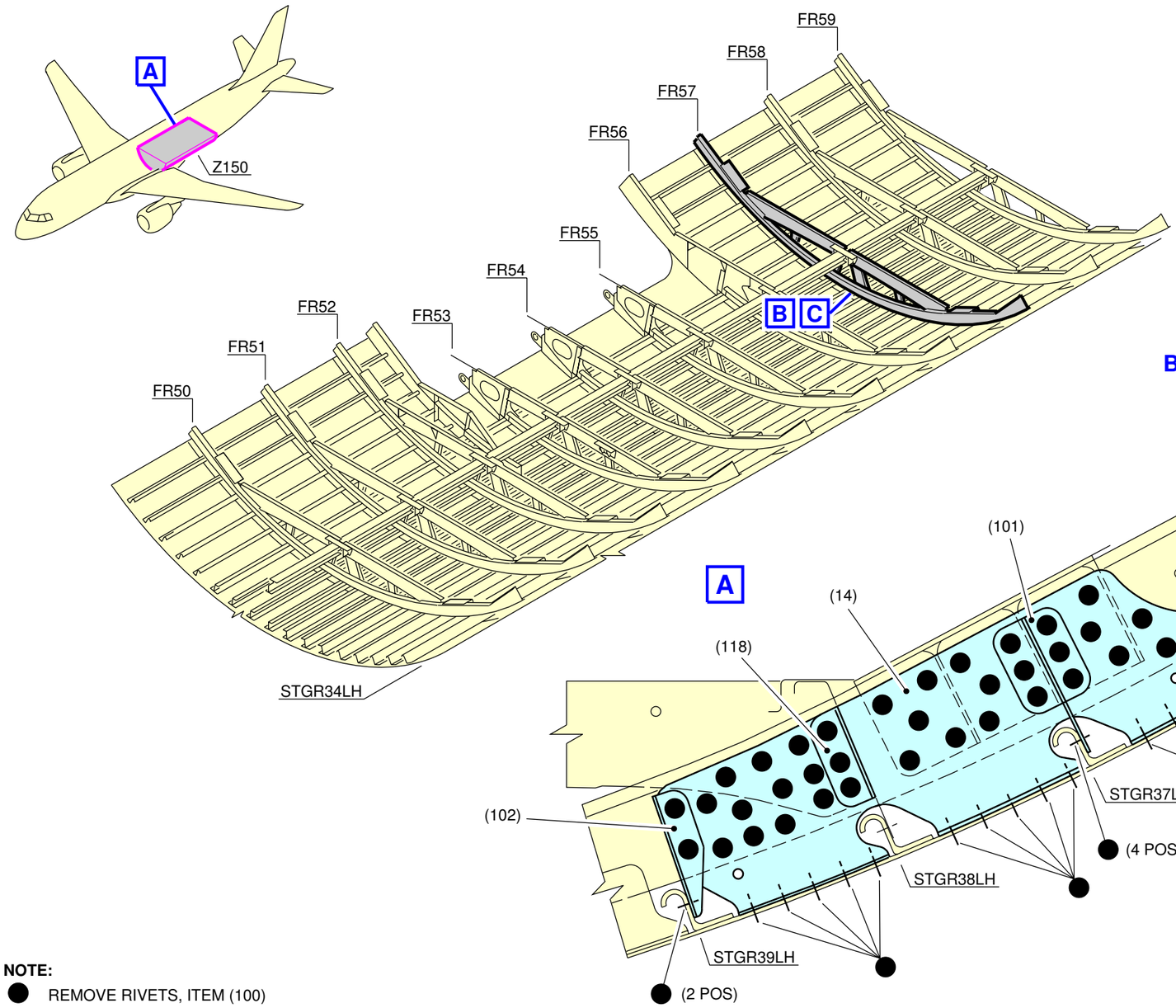
**CONF 001



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BHAA_01_00

Figure A-GBHAA - Sheet 01
Replacement of Webs and Angles at Frame 57

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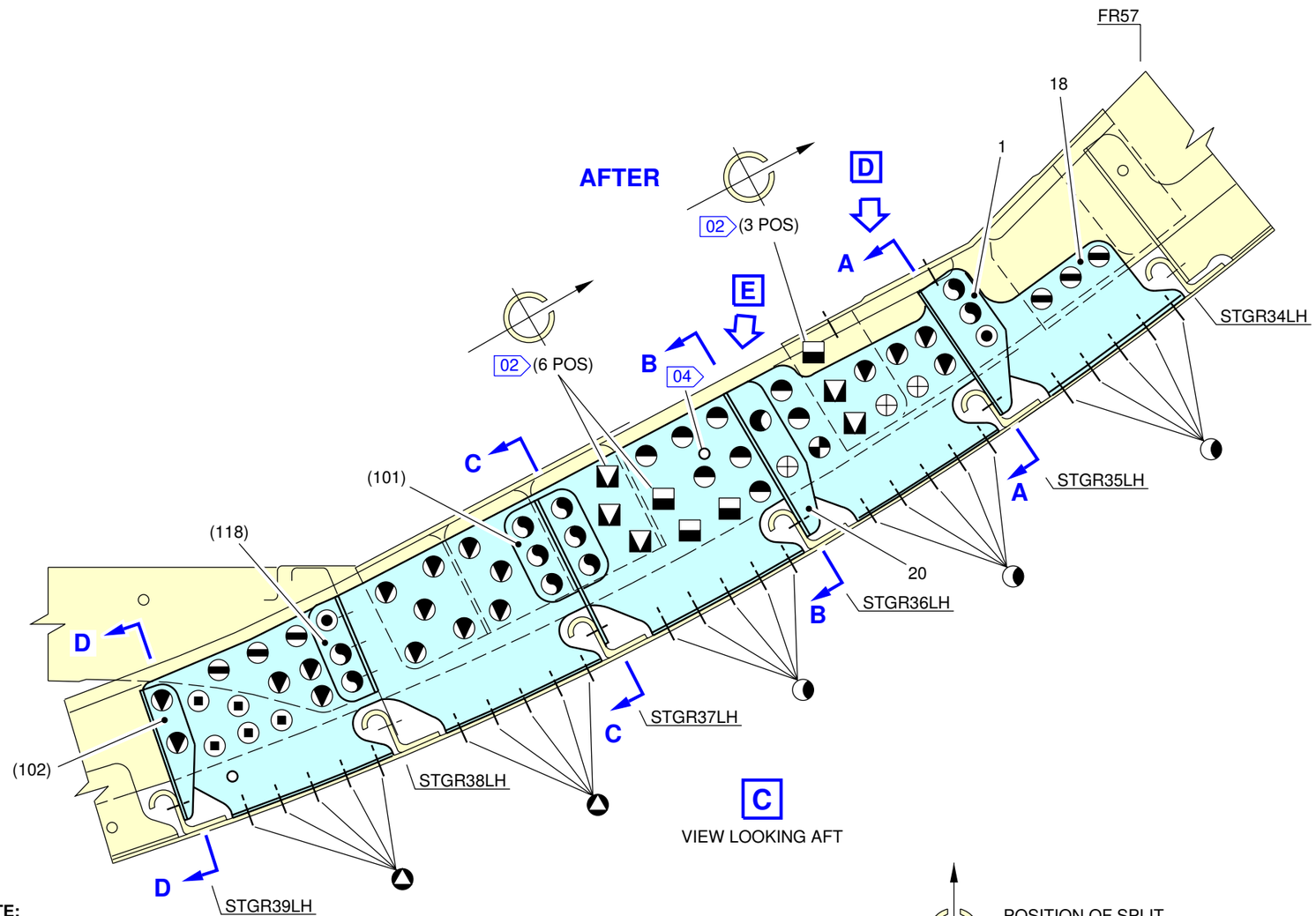
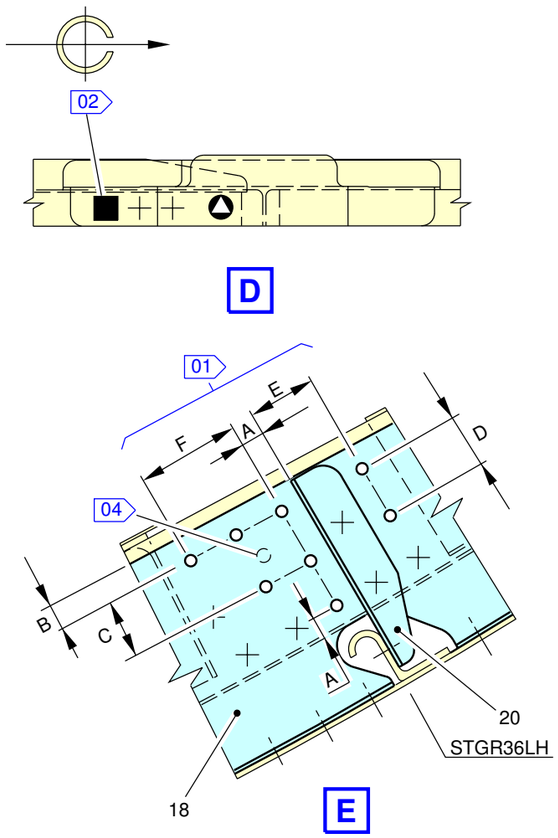
**CONF 001



C
VIEW LOOKING AFT



E
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	19.00	0.748
D	23.50	0.925
E	28.60	1.126
F	2 x 22.50	2 x 0.886

N_SB_531364_6_BHAA_02_01

NOTE:

01 NEW HOLES.

02 ◪◨■ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

Figure A-GBHAA - Sheet 02
Replacement of Webs and Angles at Frame 57

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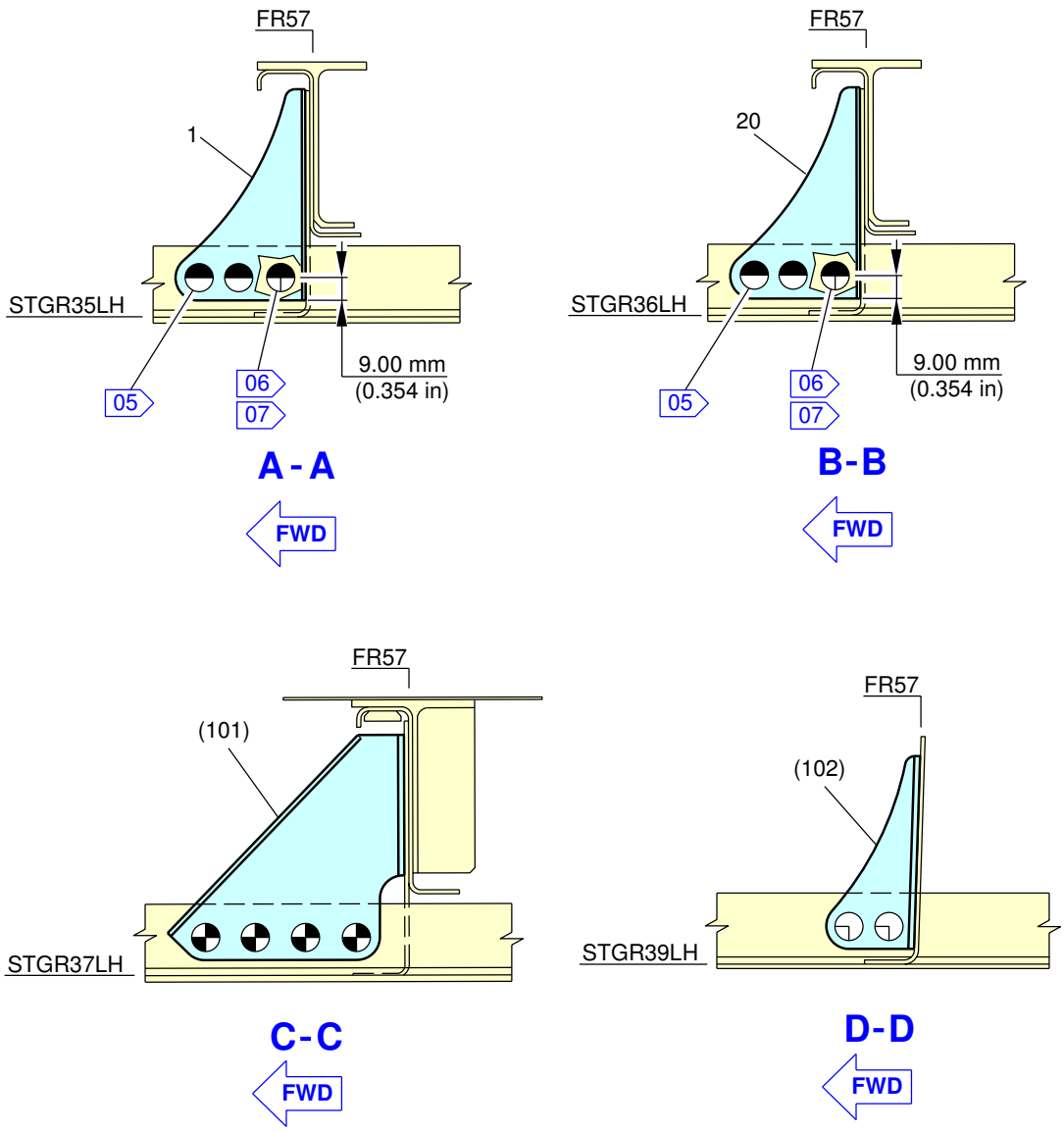
****CONF 001**



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BHAA_03_01

Figure A-GBHAA - Sheet 03
Replacement of Webs and Angles at Frame 57

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**CONF 001

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BHAA_04_01

Figure A-GBHAA - Sheet 04
Replacement of Webs and Angles at Frame 57

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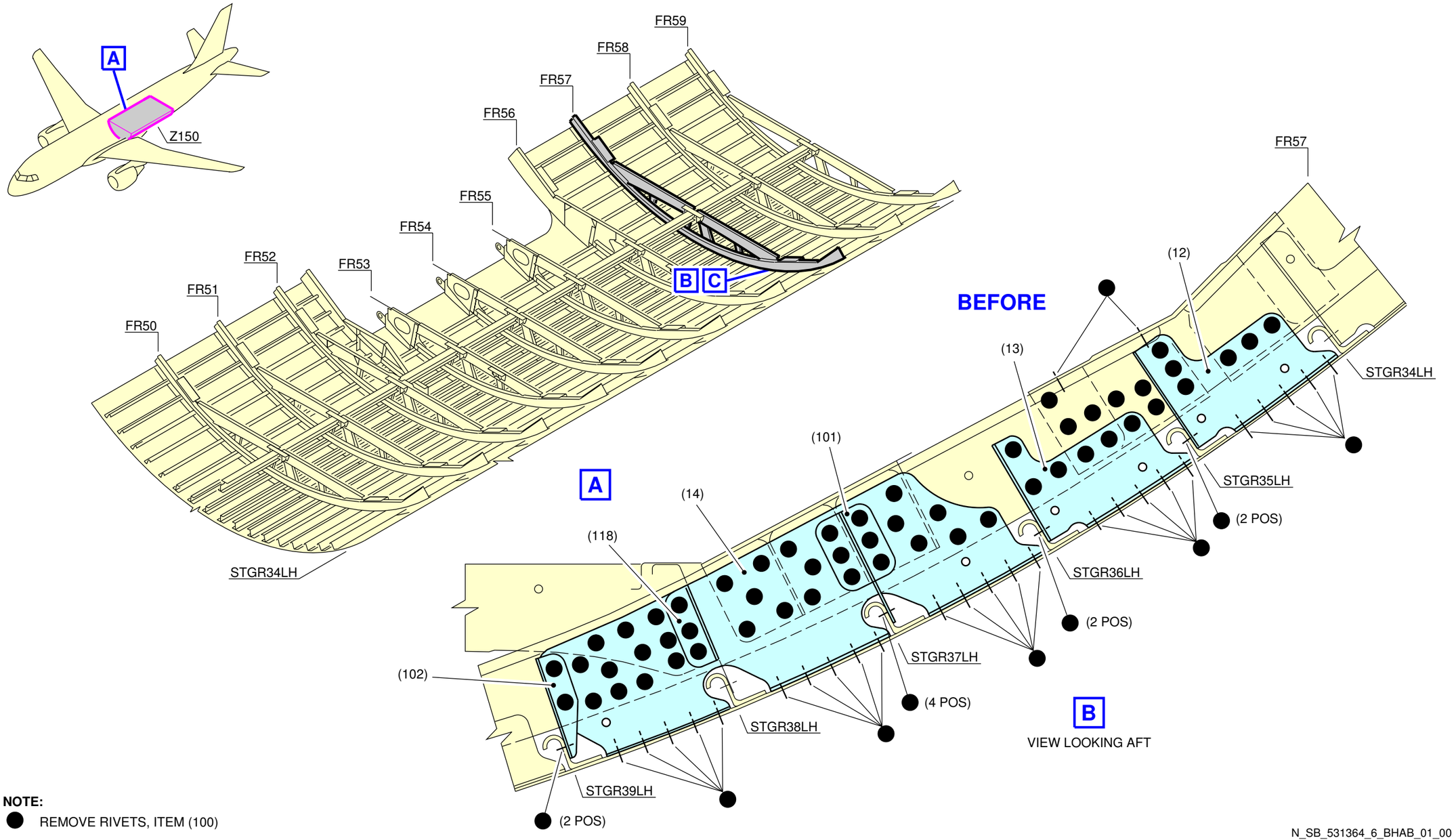
**CONF 002 thru 003



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BHAB_01_00

Figure A-GBHAB - Sheet 01
Replacement of Webs and Angles at Frame 57

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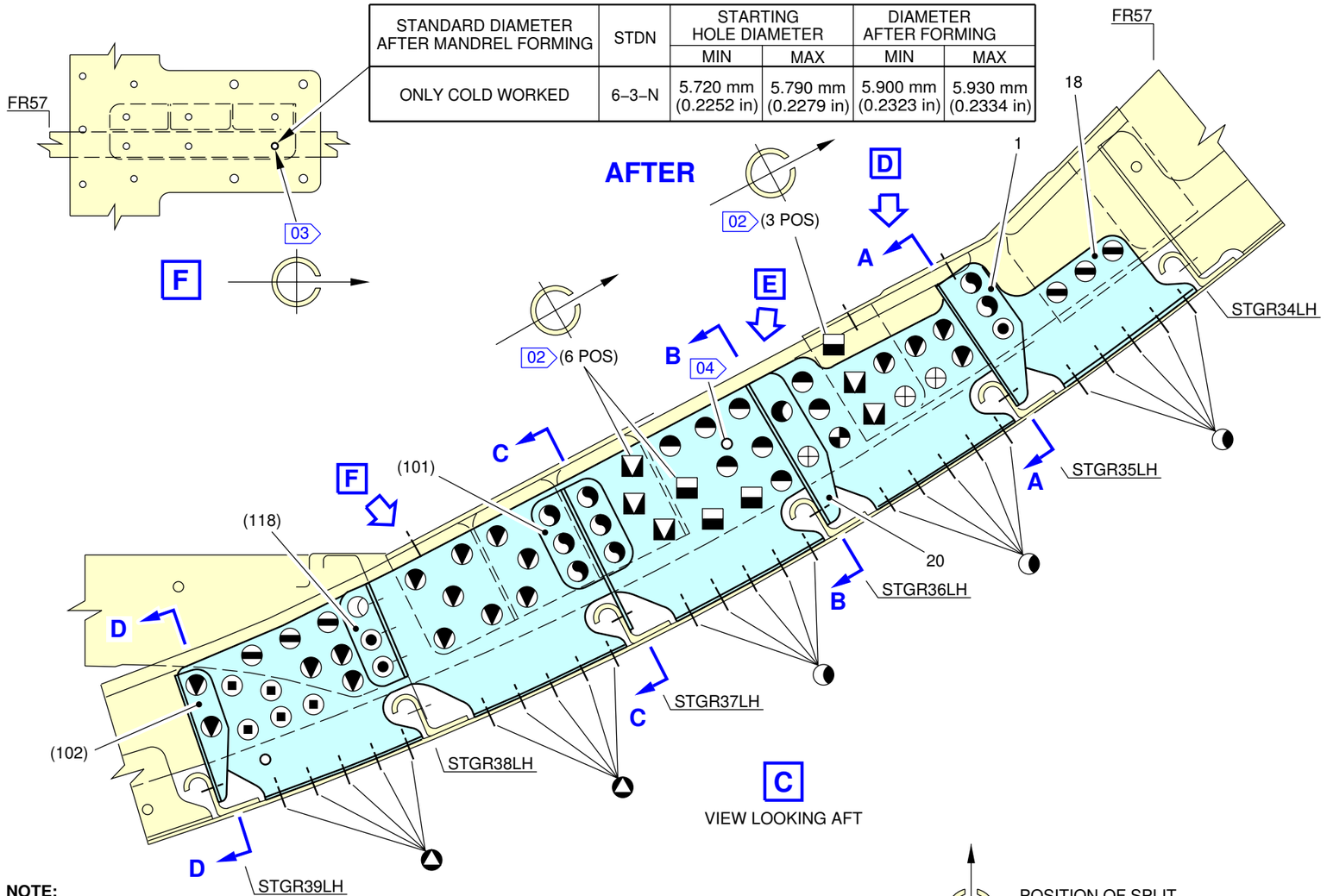
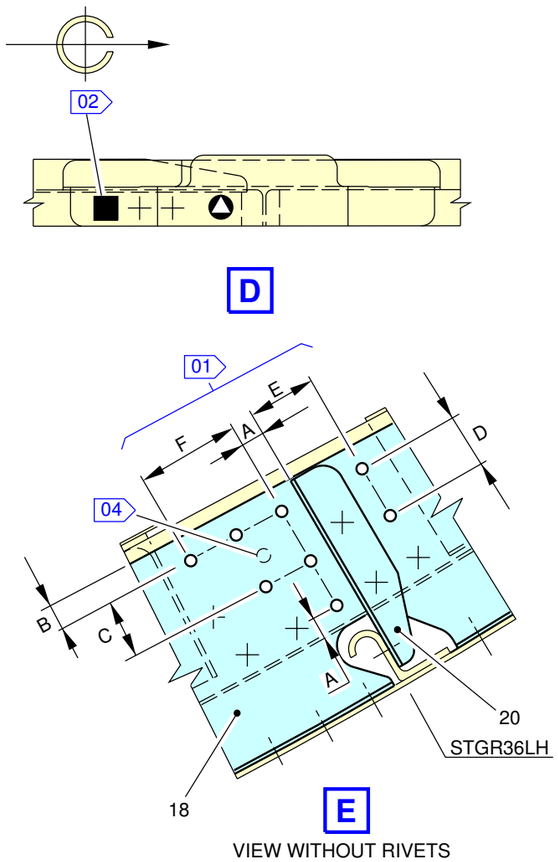
**CONF 002 thru 003

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)





NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	19.00	0.748
D	23.50	0.925
E	28.60	1.126
F	2 x 22.50	2 x 0.886

N_SB_531364_6_BHAB_02_01

Figure A-GBHAB - Sheet 02
Replacement of Webs and Angles at Frame 57

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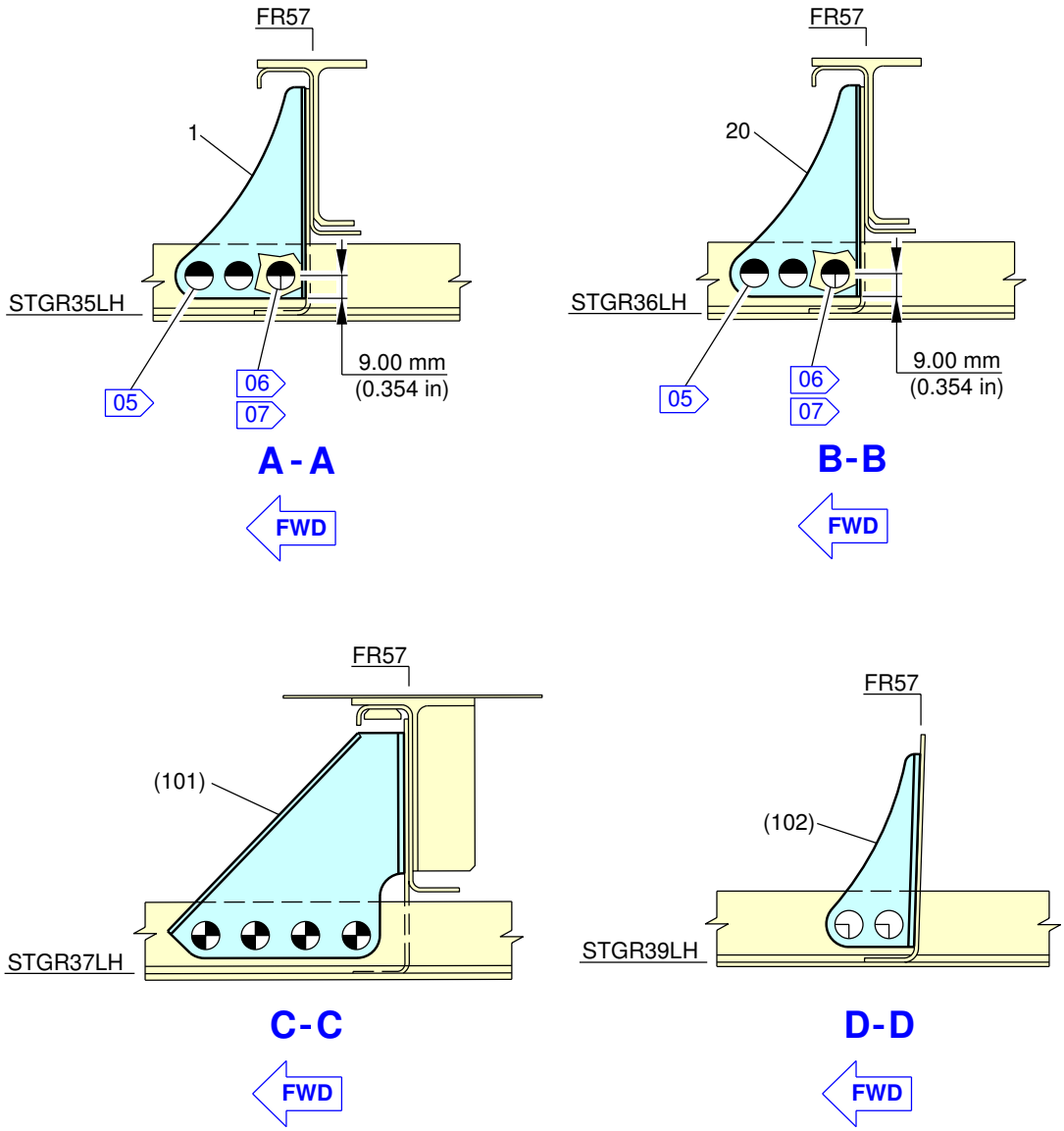
****CONF 002 thru 003**



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BHAB_03_01

Figure A-GBHAB - Sheet 03
Replacement of Webs and Angles at Frame 57

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**CONF 002 thru 003

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BHAB_04_01

Figure A-GBHAB - Sheet 04
Replacement of Webs and Angles at Frame 57

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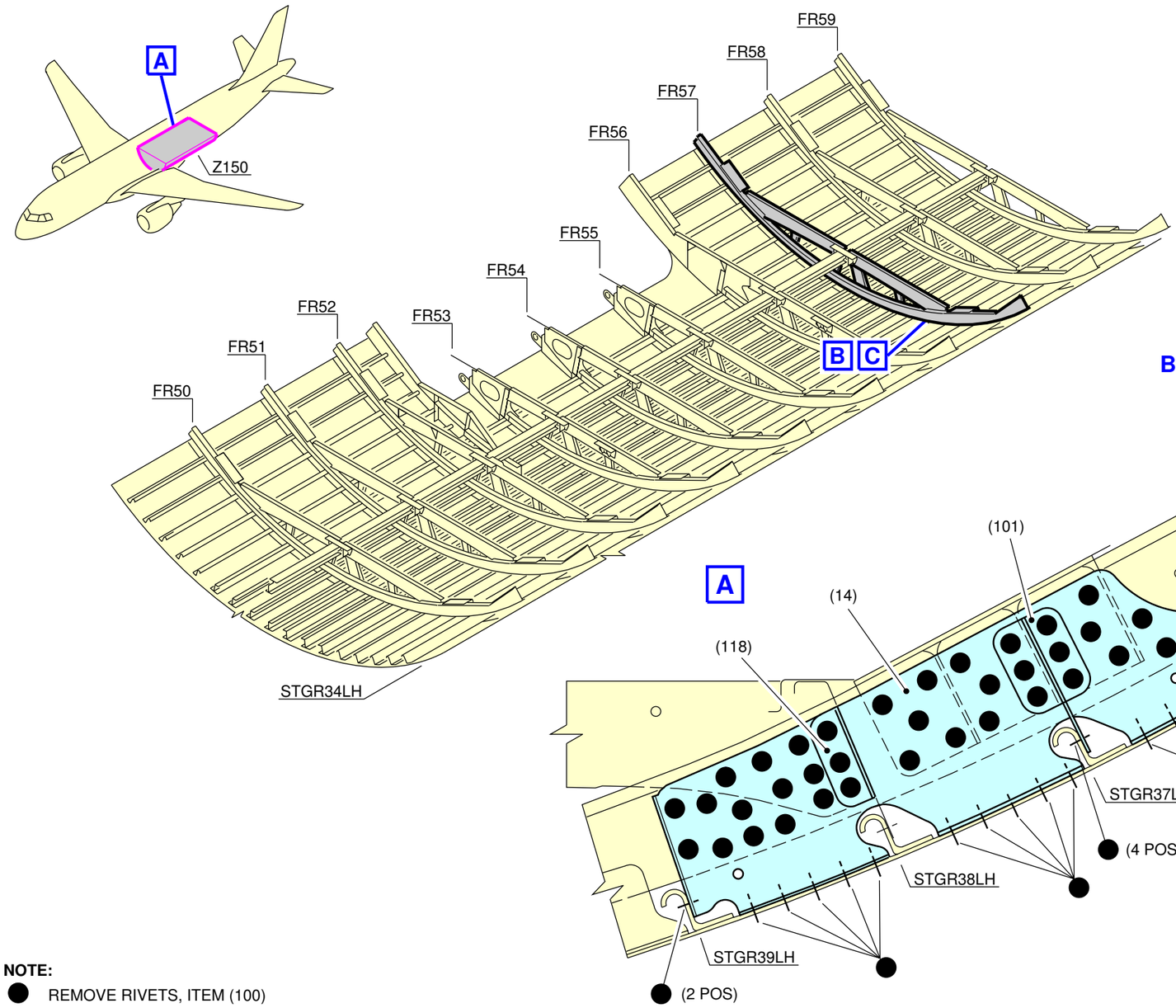
**CONF 004, 006



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BHAD_01_00

Figure A-GBHAD - Sheet 01
Replacement of Webs and Angles at Frame 57

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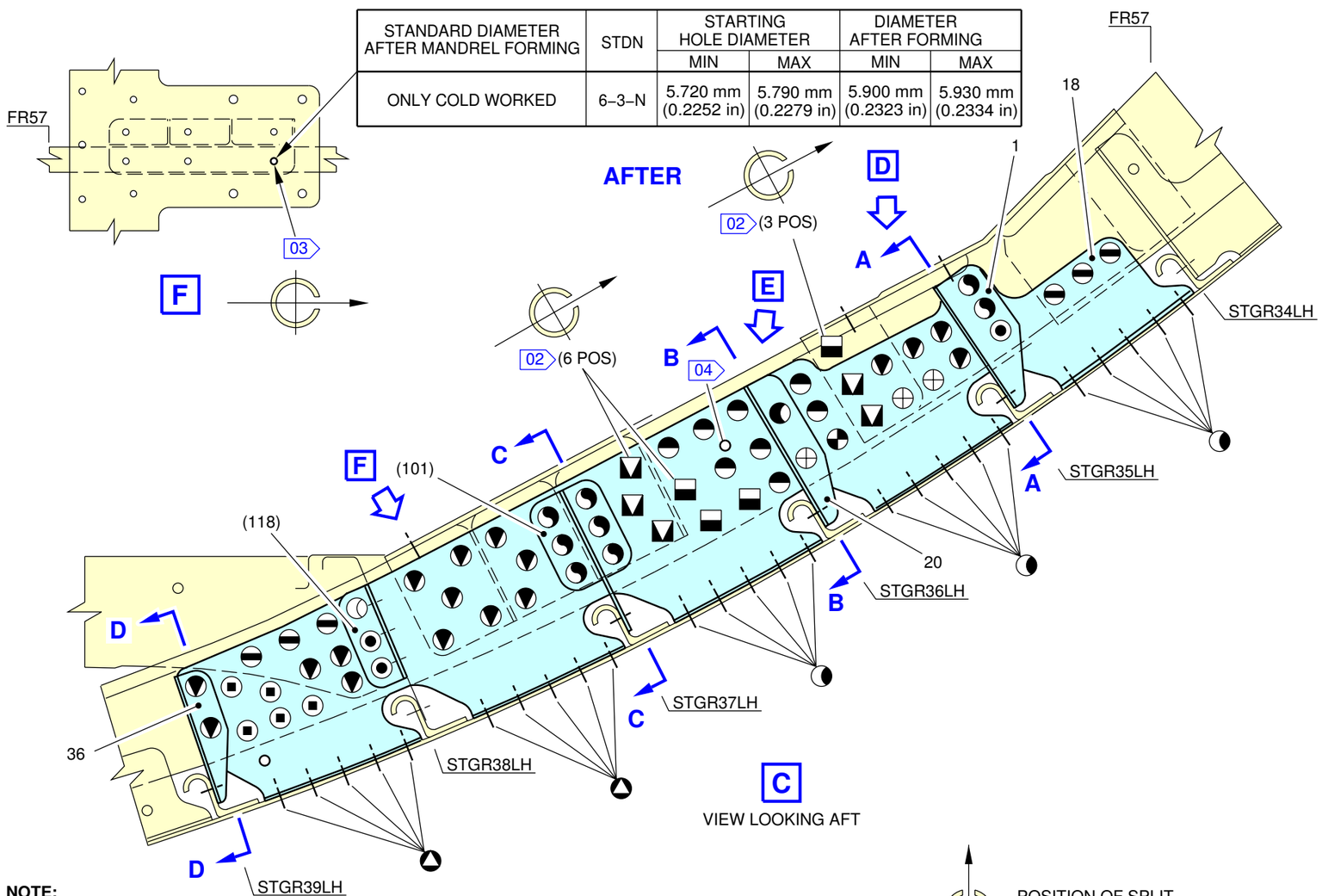
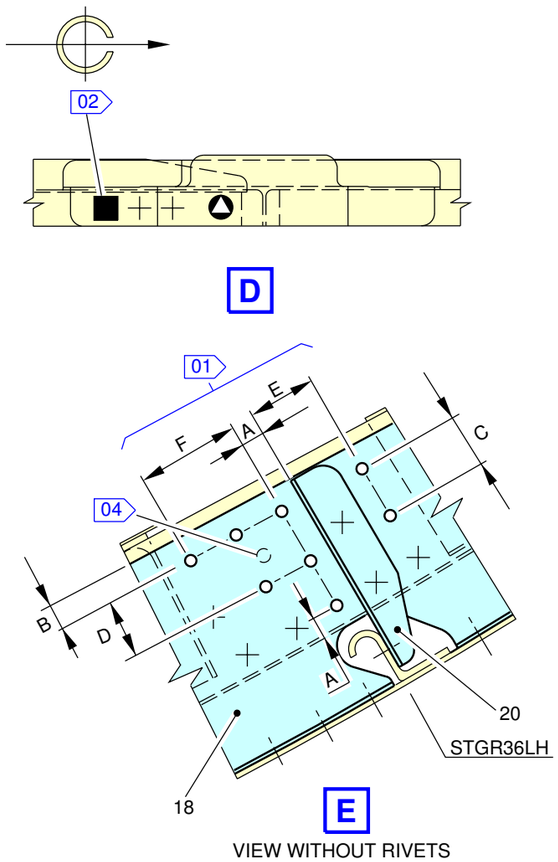
**CONF 004, 006

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)





DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	19.00	0.748
D	23.50	0.925
E	28.60	1.126
F	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BHAD_02_01

Figure A-GBHAD - Sheet 02
Replacement of Webs and Angles at Frame 57

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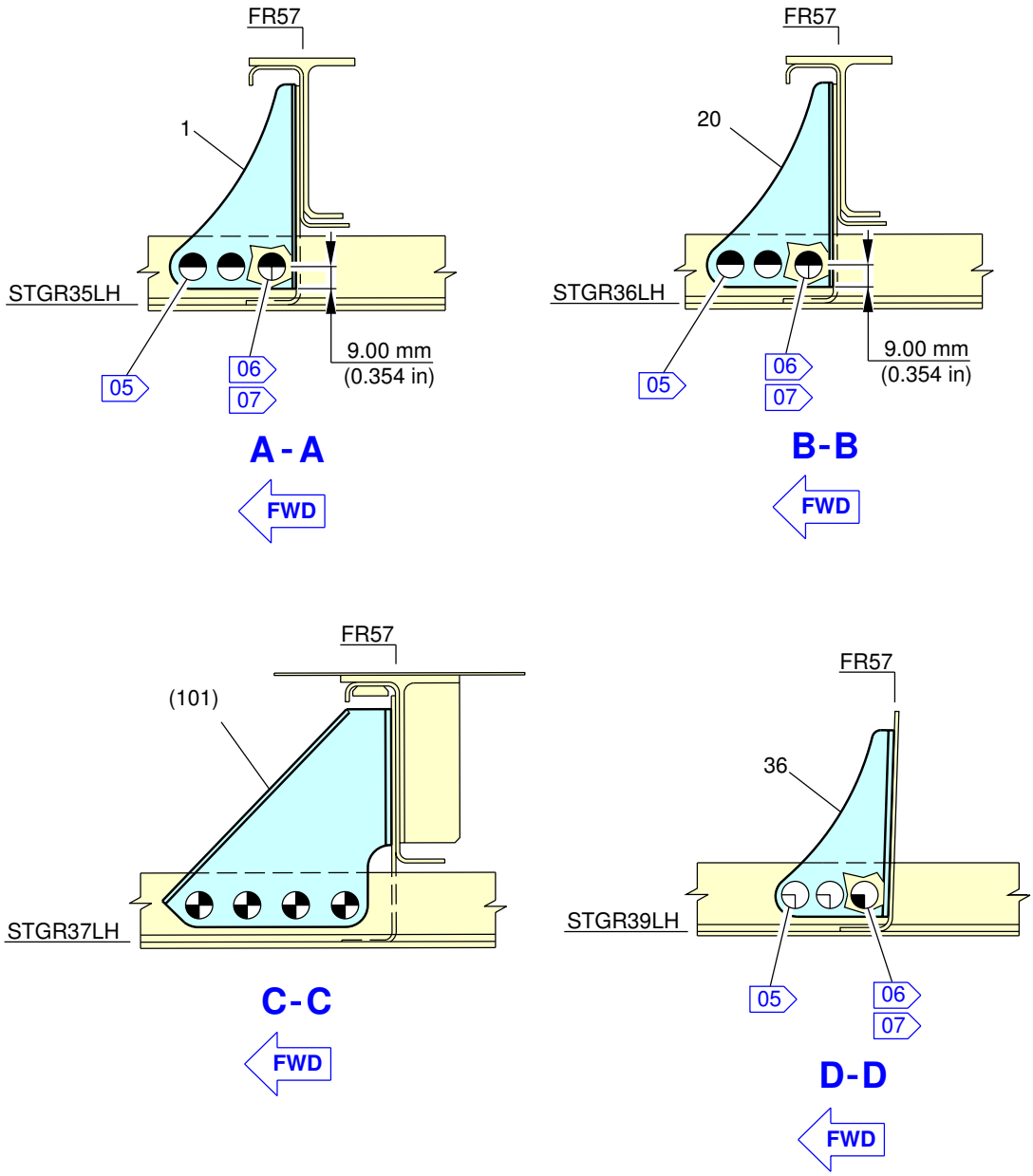
**CONF 004, 006



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BHAD_03_01

Figure A-GBHAD - Sheet 03
Replacement of Webs and Angles at Frame 57

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**CONF 004, 006

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BHAD_04_01

Figure A-GBHAD - Sheet 04
Replacement of Webs and Angles at Frame 57

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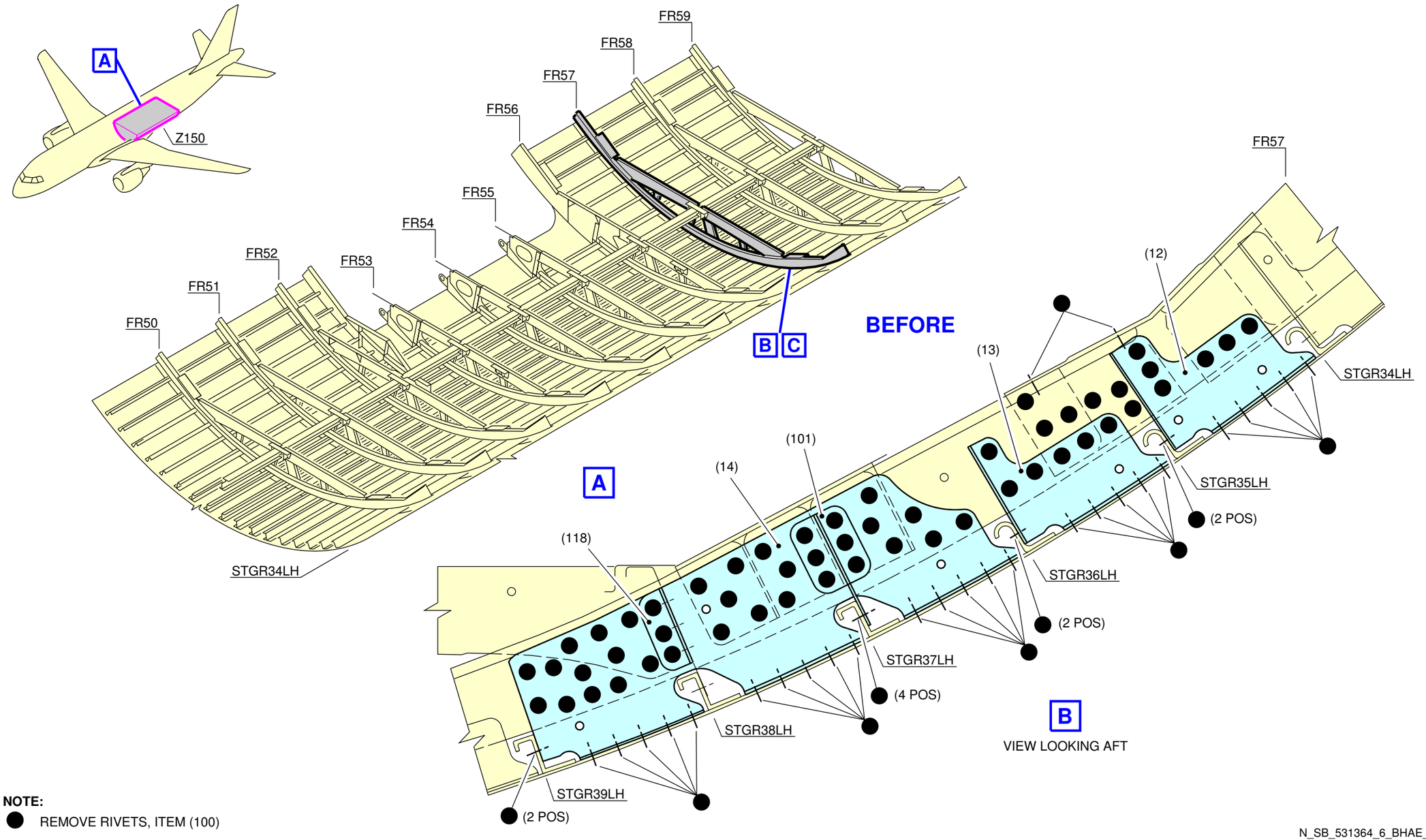
**CONF 005, 007



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BHAE_01_00

Figure A-GBHAE - Sheet 01
Replacement of Webs and Angles at Frame 57

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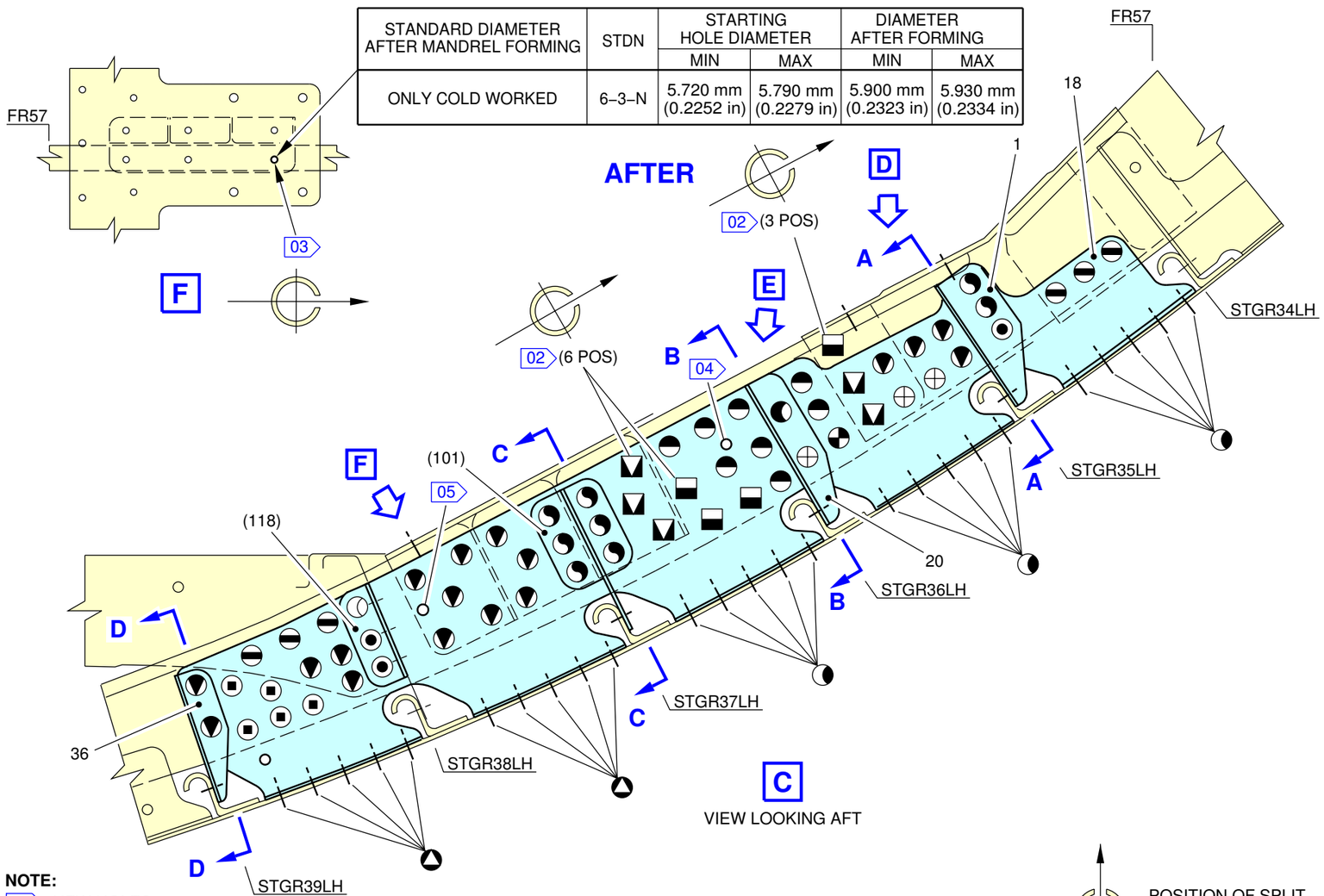
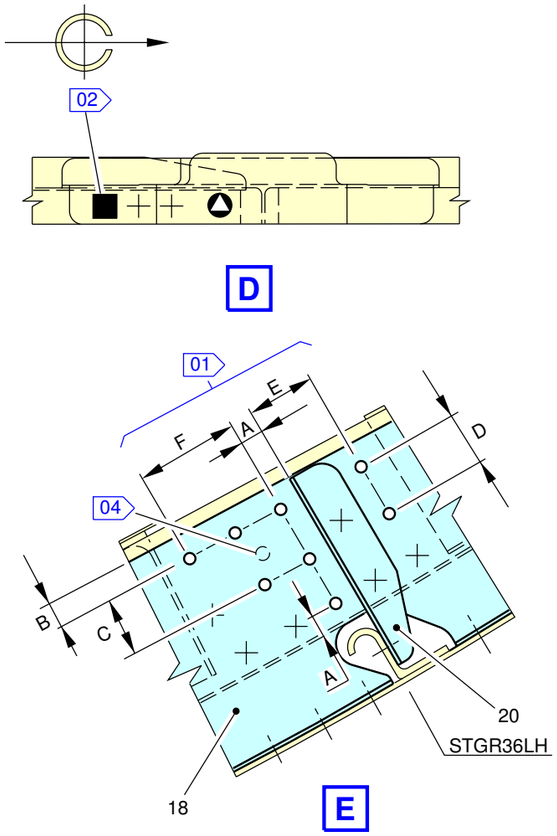
**CONF 005, 007

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



C
VIEW LOOKING AFT



E
VIEW WITHOUT RIVETS

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

05 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in). FOR MSN 3999 AND SUBSEQUENT.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

EXISTING HOLE POSITION MUST BE USED FOR FASTENER SYMBOLS, REFER TO SHEET 4.

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	19.00	0.748
D	23.50	0.925
E	28.60	1.126
F	2 x 22.50	2 x 0.886

N_SB_531364_6_BHAE_02_01

Figure A-GBHAE - Sheet 02
Replacement of Webs and Angles at Frame 57

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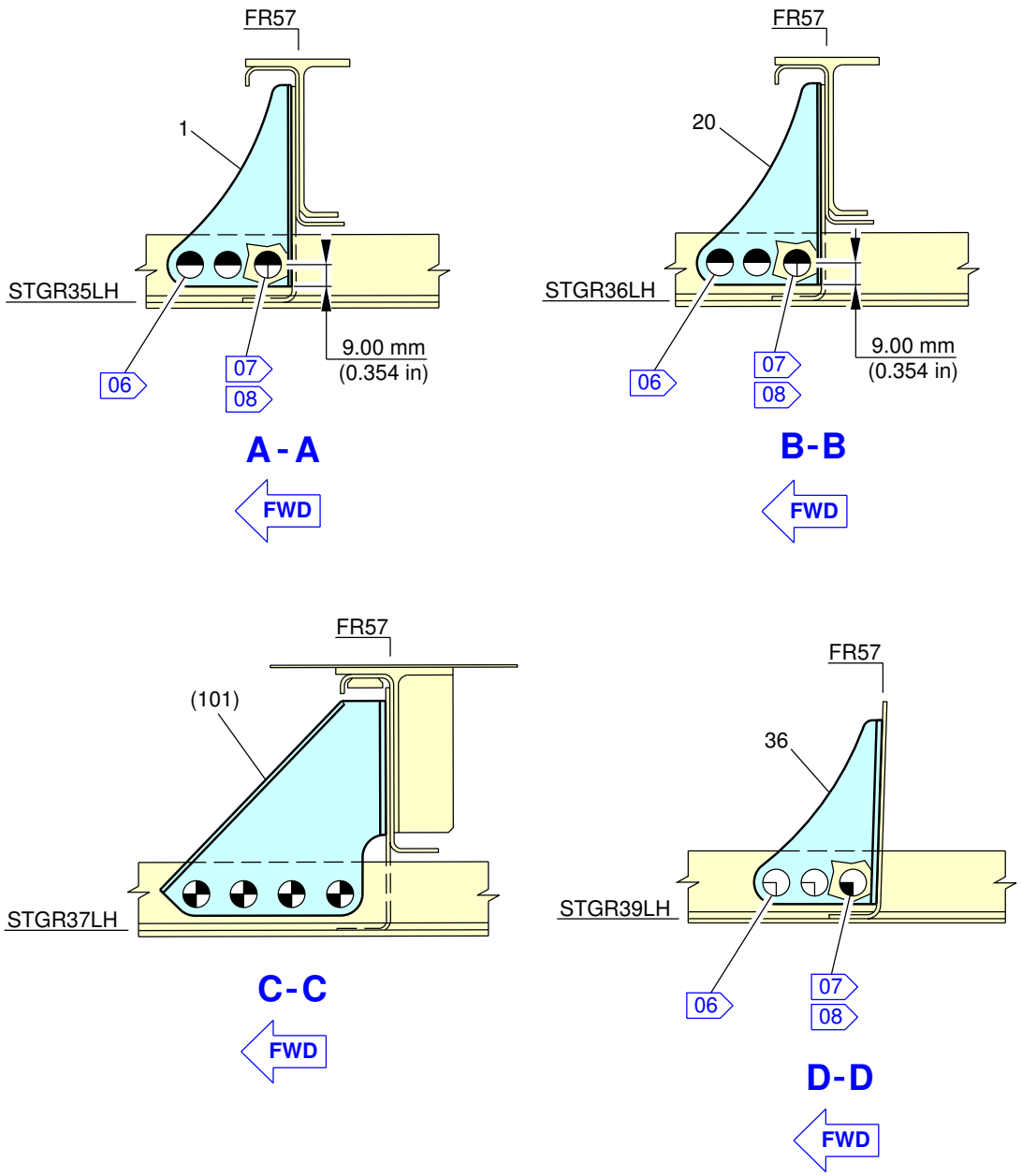
**CONF 005, 007



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BHAE_03_01

Figure A-GBHAE - Sheet 03
Replacement of Webs and Angles at Frame 57

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**CONF 005, 007

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BHAE_04_01

Figure A-GBHAE - Sheet 04
Replacement of Webs and Angles at Frame 57

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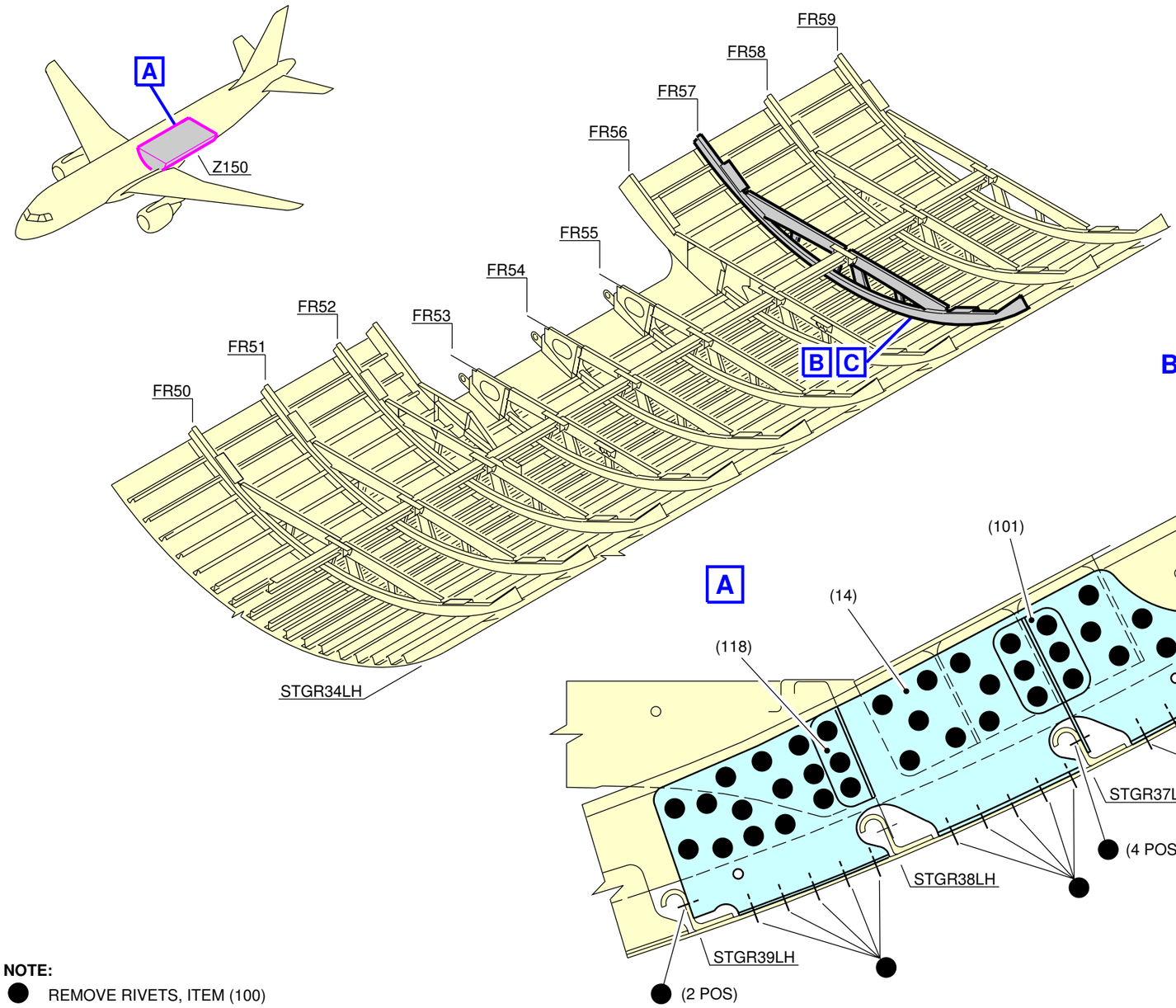
**CONF 008



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BHAH_01_00

Figure A-GBHAH - Sheet 01
Replacement of Webs and Angles at Frame 57

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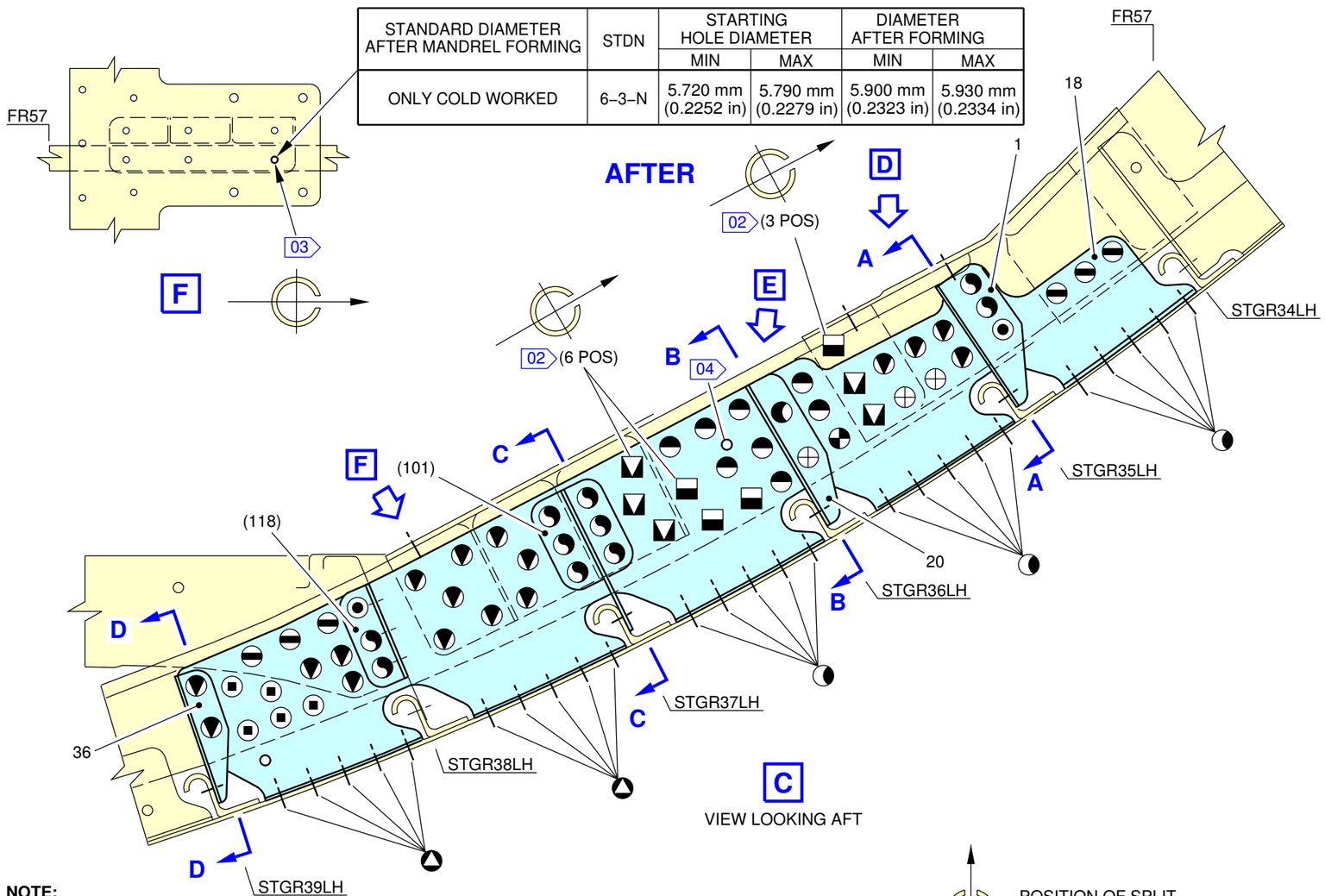
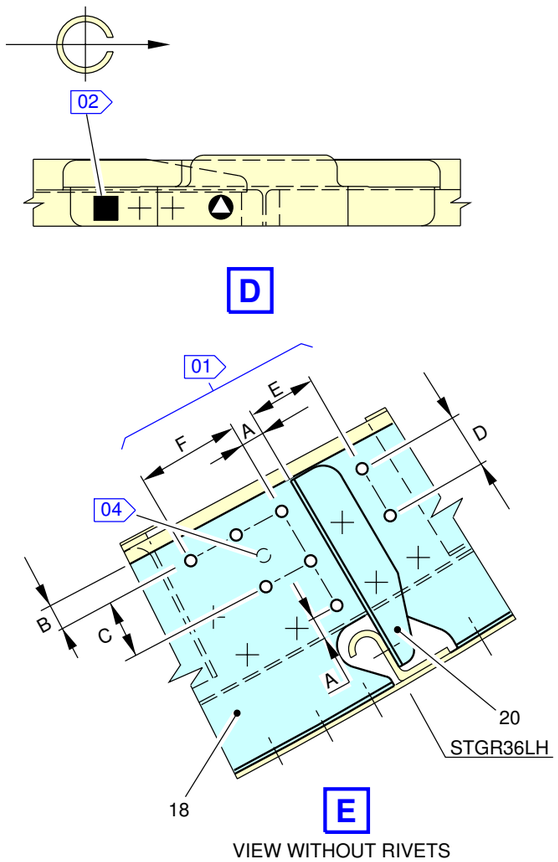
**CONF 008

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



C
VIEW LOOKING AFT



E
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	19.00	0.748
D	23.50	0.925
E	28.60	1.126
F	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BHAH_02_01

Figure A-GBHAH - Sheet 02
Replacement of Webs and Angles at Frame 57

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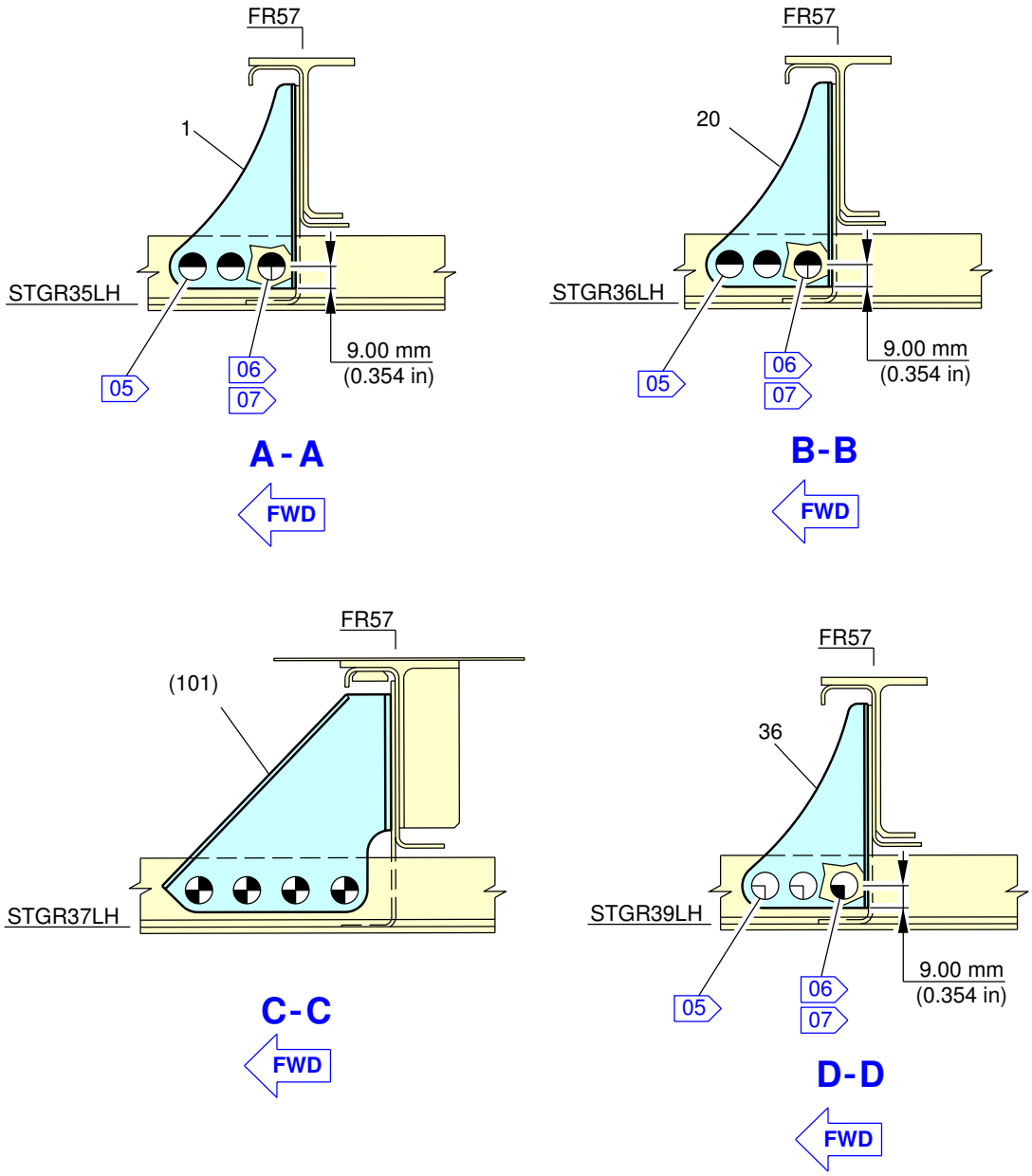
**CONF 008



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BHAH_03_01

Figure A-GBHAH - Sheet 03
Replacement of Webs and Angles at Frame 57

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**CONF 008

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BHAH_04_01

Figure A-GBHAH - Sheet 04
Replacement of Webs and Angles at Frame 57

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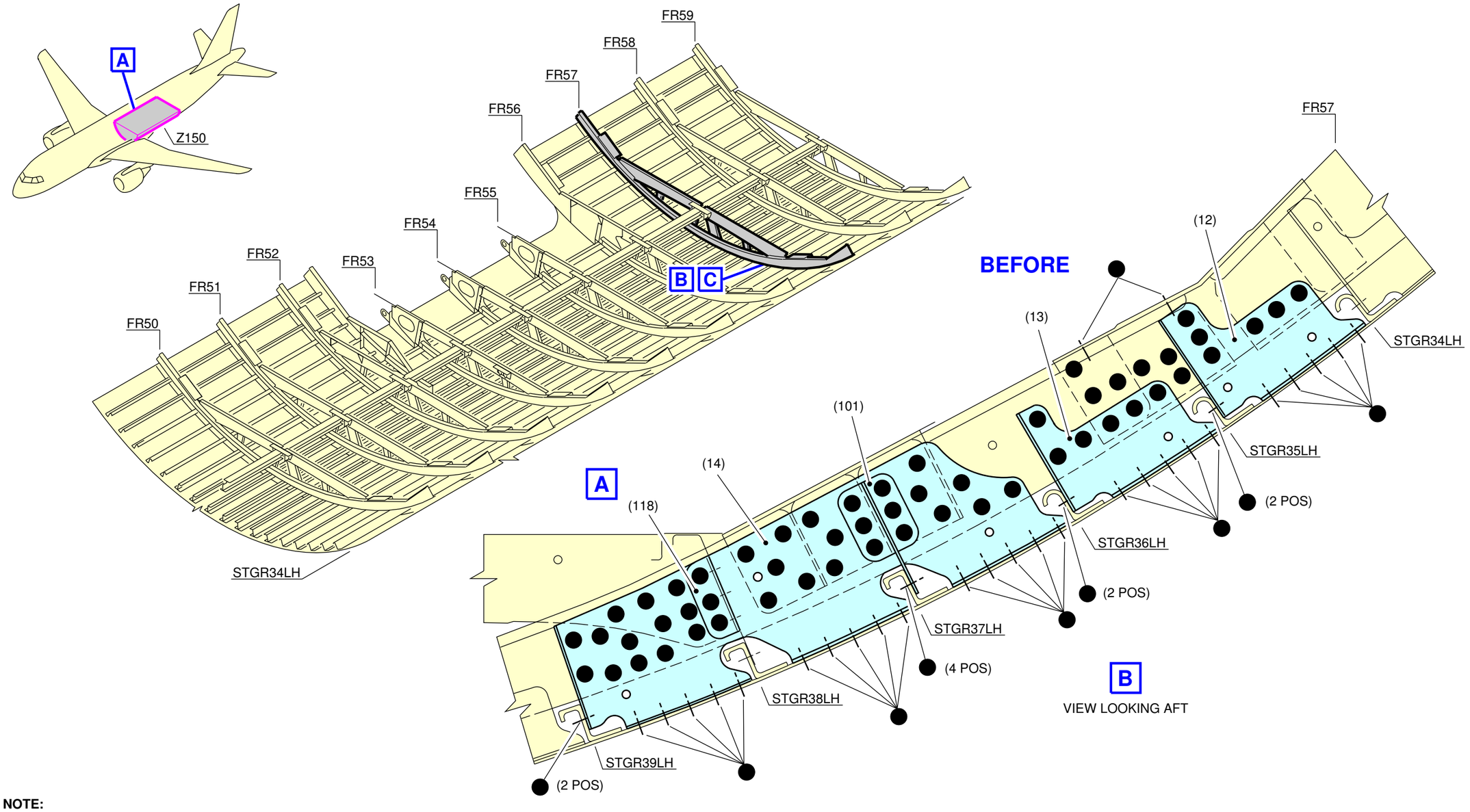
**CONF 009



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BHAJ_01_00

Figure A-GBHAJ - Sheet 01
Replacement of Webs and Angles at Frame 57

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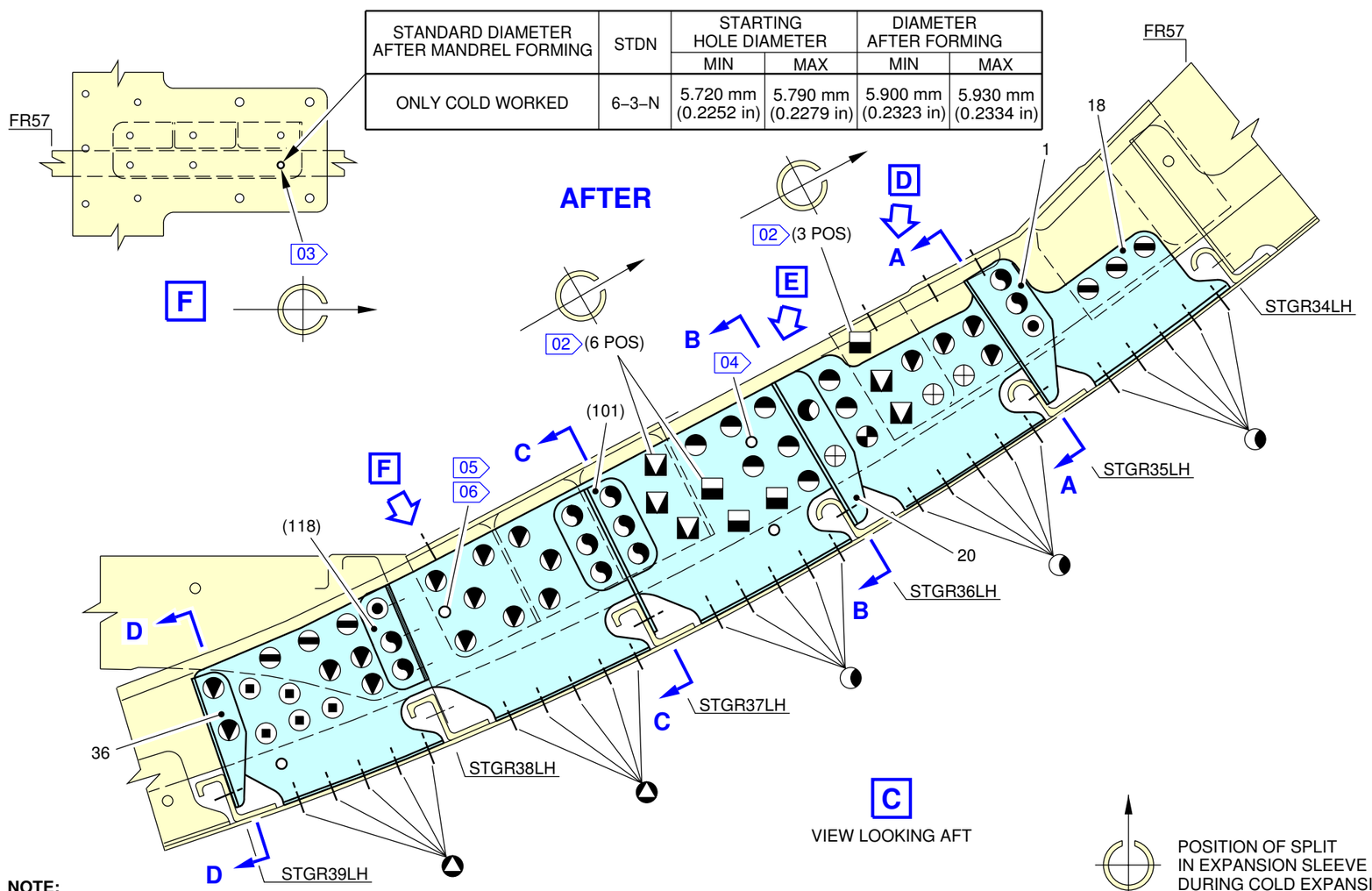
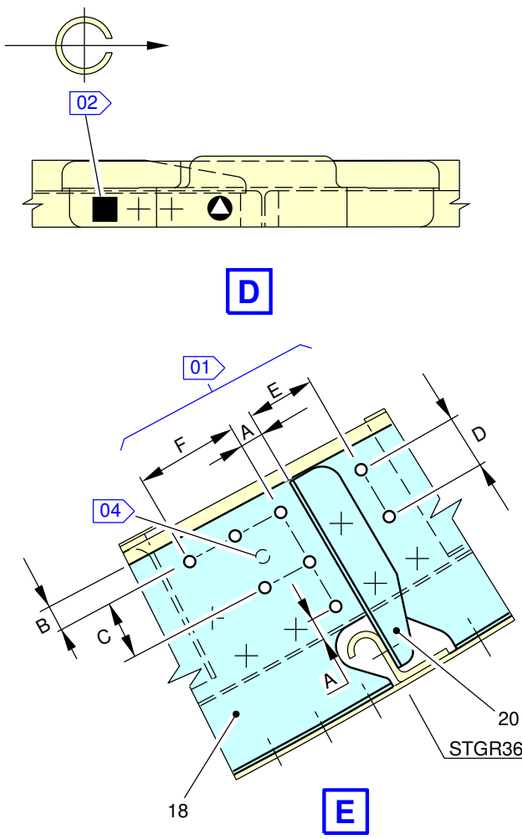
**CONF 009

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



C
VIEW LOOKING AFT



E
VIEW WITHOUT RIVETS

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

EXISTING HOLE POSITION MUST BE USED.
FOR FASTENER SYMBOLS, REFER TO SHEET 4

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	19.00	0.748
D	23.50	0.925
E	28.60	1.126
F	2 x 22.50	2 x 0.886

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

05 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in).

06 VALID FOR MSN 4005 AND SUBSEQUENT.

N_SB_531364_6_BHAJ_02_01

Figure A-GBHAJ - Sheet 02
Replacement of Webs and Angles at Frame 57

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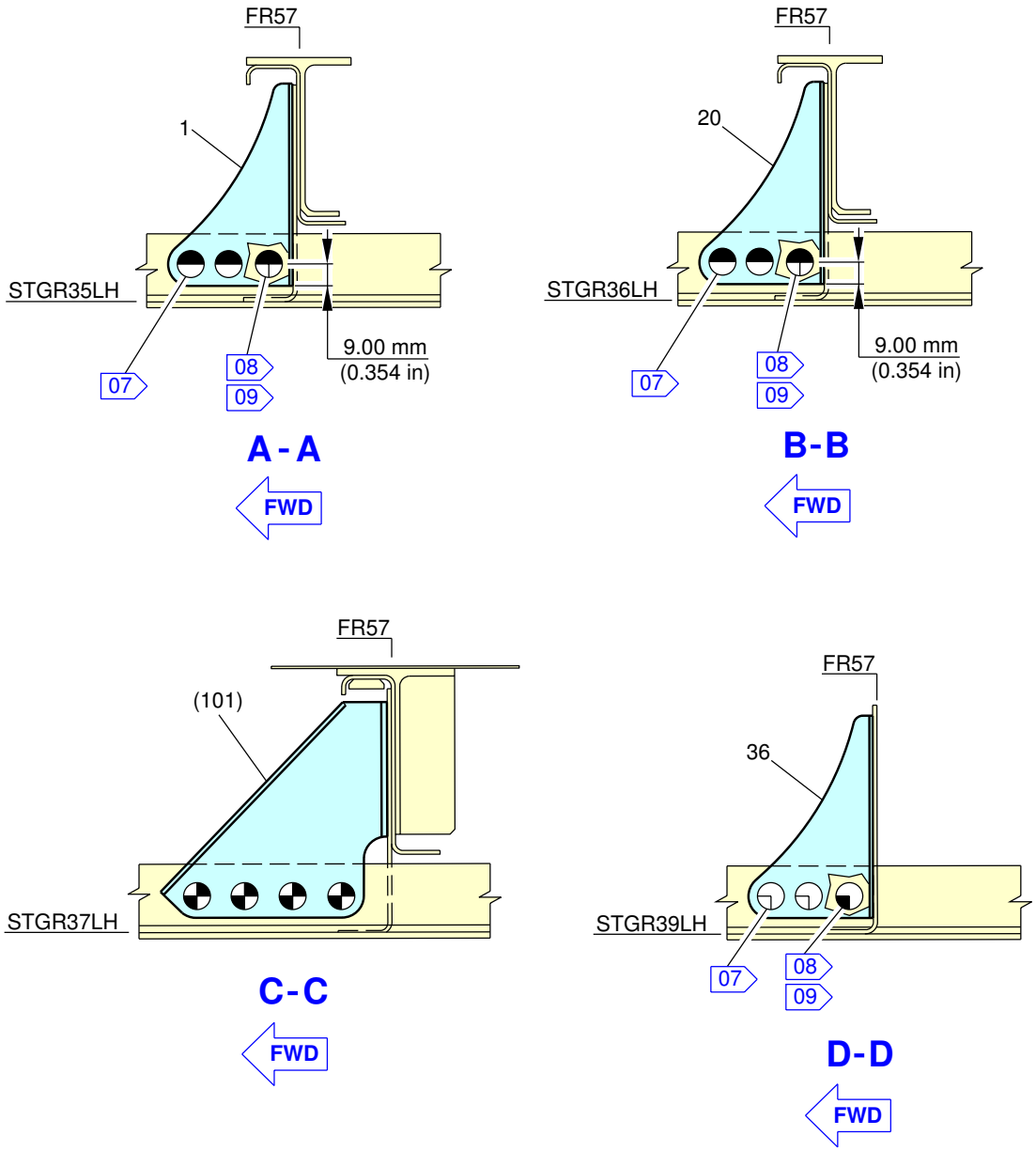
**CONF 009



NOTE:

07 EXISTING PILOT HOLES.

08 COUNTERSINK EXISTING HOLE IN THE STRINGER.

09 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BHAJ_03_01

Figure A-GBHAJ - Sheet 03
Replacement of Webs and Angles at Frame 57

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**CONF 009

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BHAJ_04_01

Figure A-GBHAJ - Sheet 04
Replacement of Webs and Angles at Frame 57

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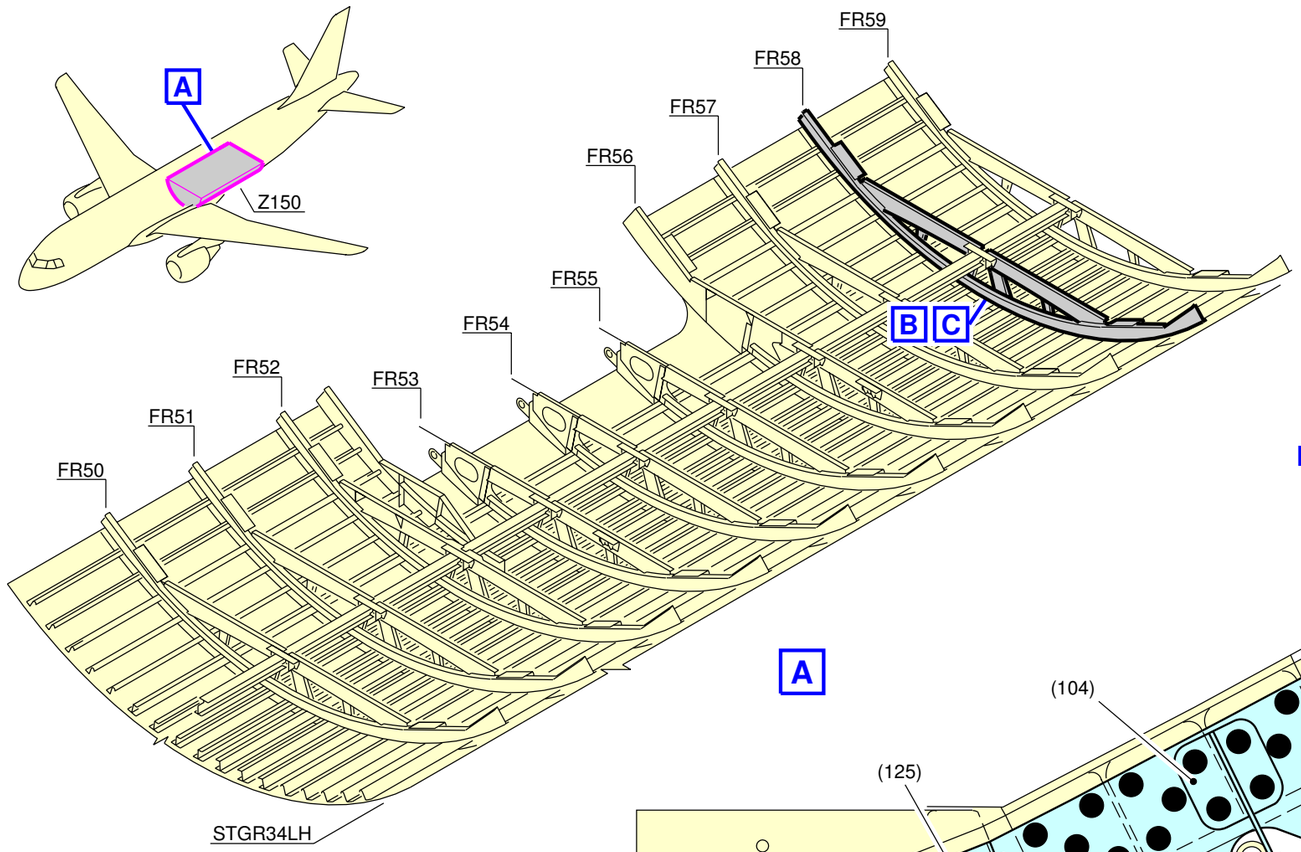
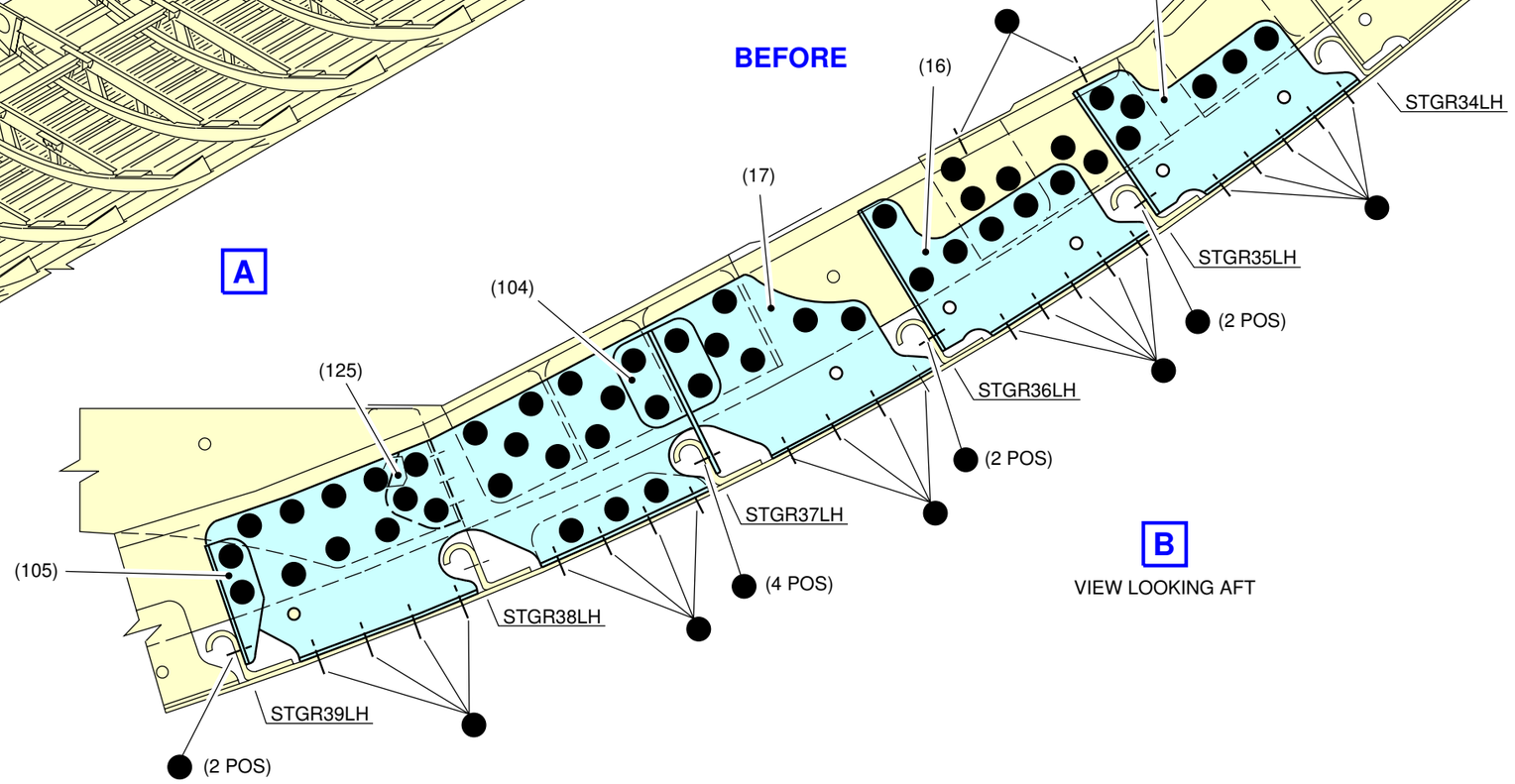
**CONF 001





NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BJAA_01_00

Figure A-GBJAA - Sheet 01
Replacement of Webs and Angles at Frame 58

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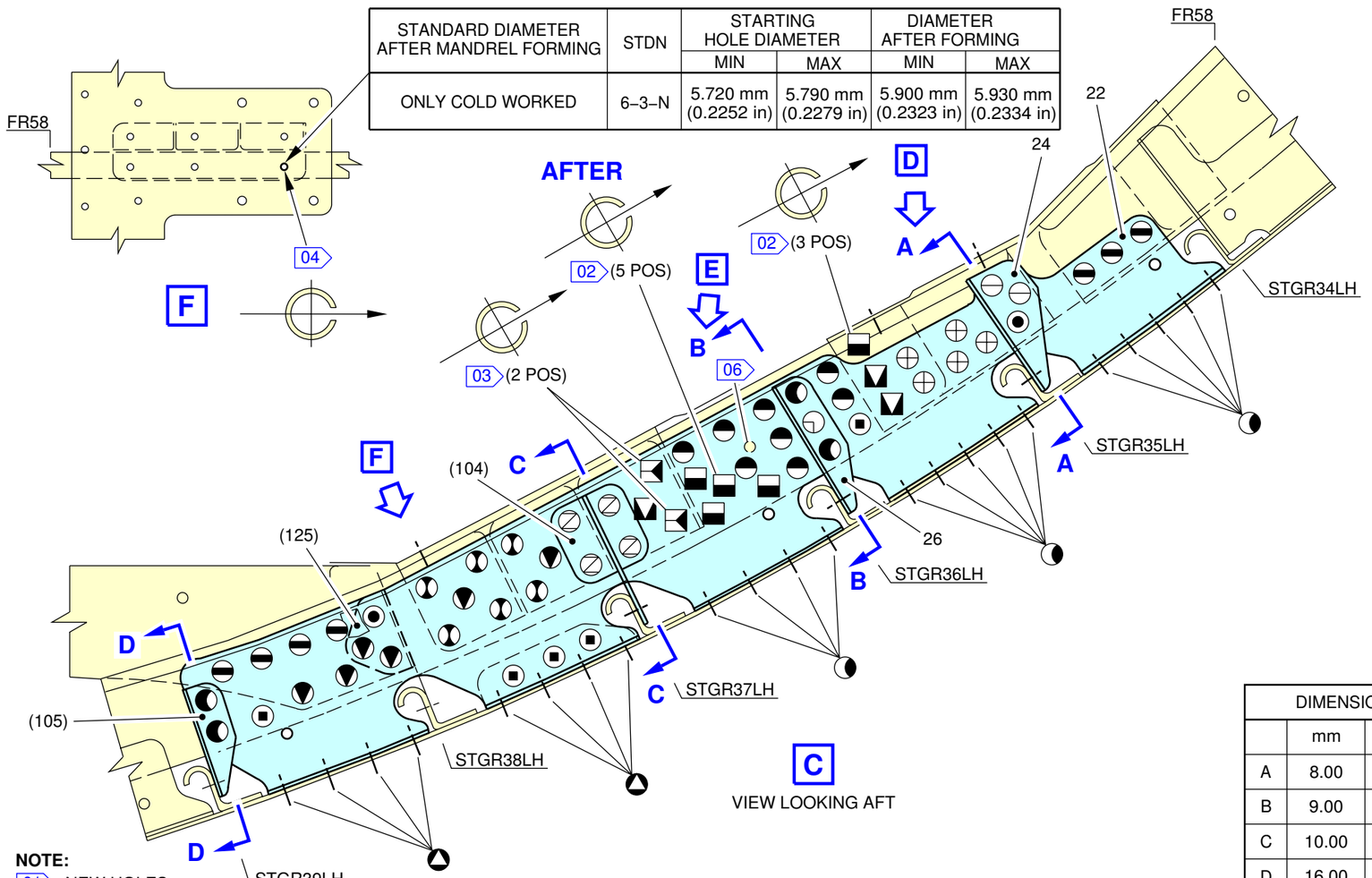
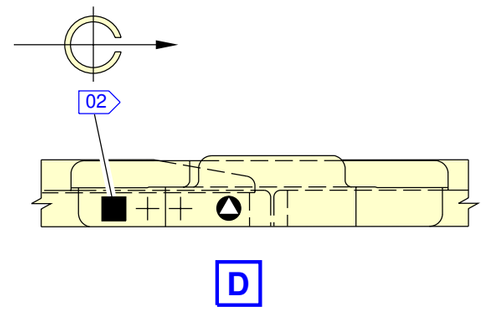
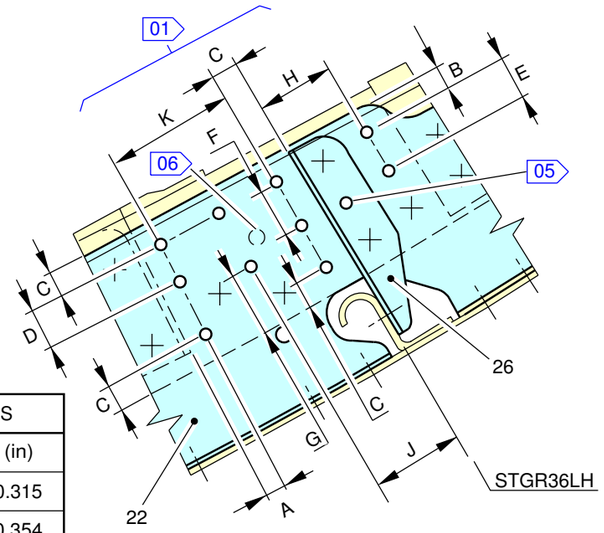
**CONF 001

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



C
VIEW LOOKING AFT





E
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	8.00	0.315
B	9.00	0.354
C	10.00	0.394
D	16.00	0.630
E	16.50	0.650
F	19.00	0.748
G	24.40	0.961
H	30.00	1.181
J	34.30	1.350
K	2 x 24.80	2 x 0.976

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00

04 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

05 EXISTING PILOT HOLES

06 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BJAA_02_01

Figure A-GBJAA - Sheet 02
Replacement of Webs and Angles at Frame 58

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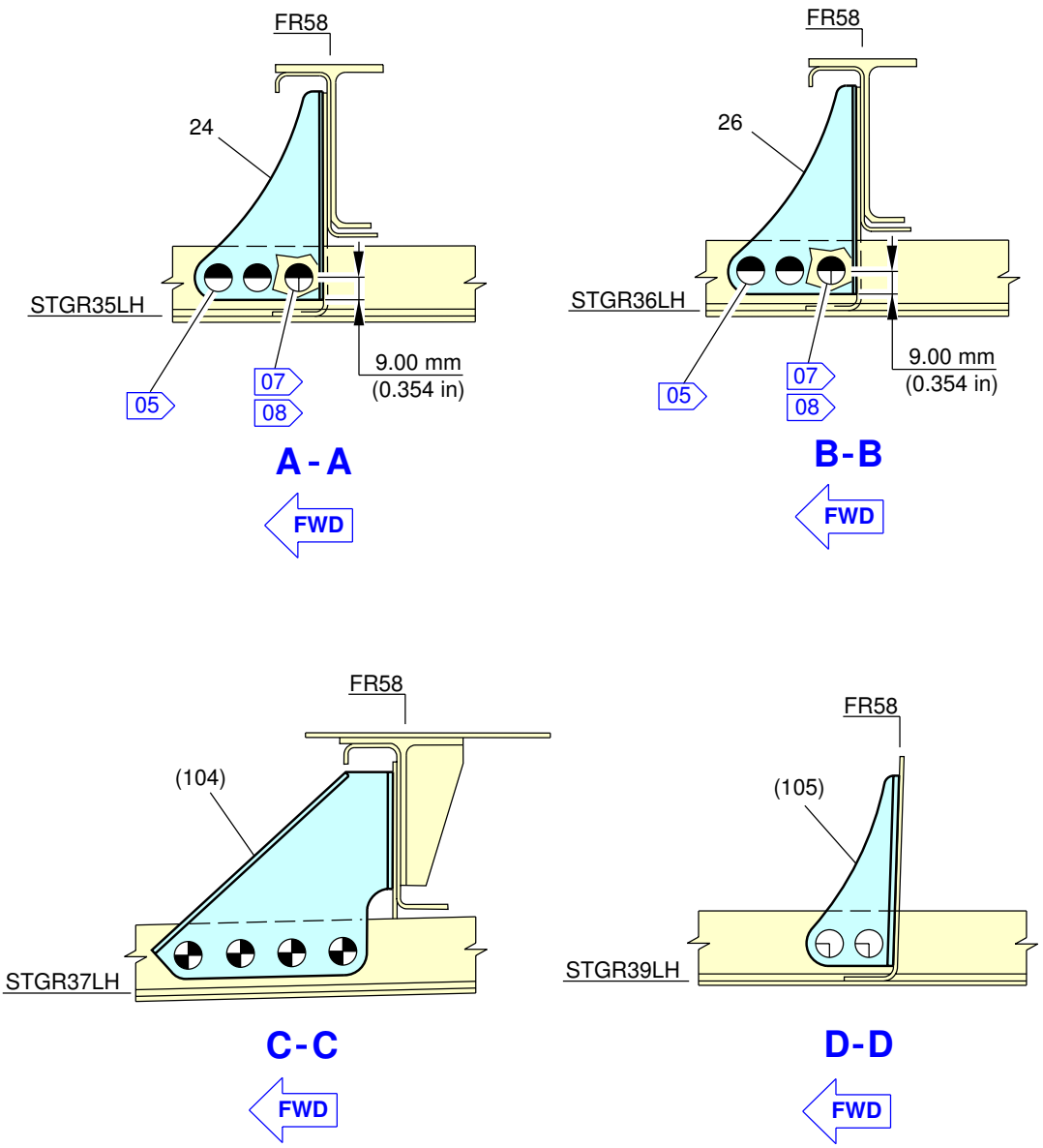
**CONF 001



NOTE:

05 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BJAA_03_01

Figure A-GBJAA - Sheet 03
Replacement of Webs and Angles at Frame 58

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**CONF 001

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	670	EN6081D7–10	RIVET	5.660 mm (0.2229 in)	5.770 mm (0.2271 in)	NOMINAL SIZE
	678	EN6081D7–08	RIVET	5.660 mm (0.2229 in)	5.770 mm (0.2271 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BJAA_04_01

Figure A-GBJAA - Sheet 04
Replacement of Webs and Angles at Frame 58

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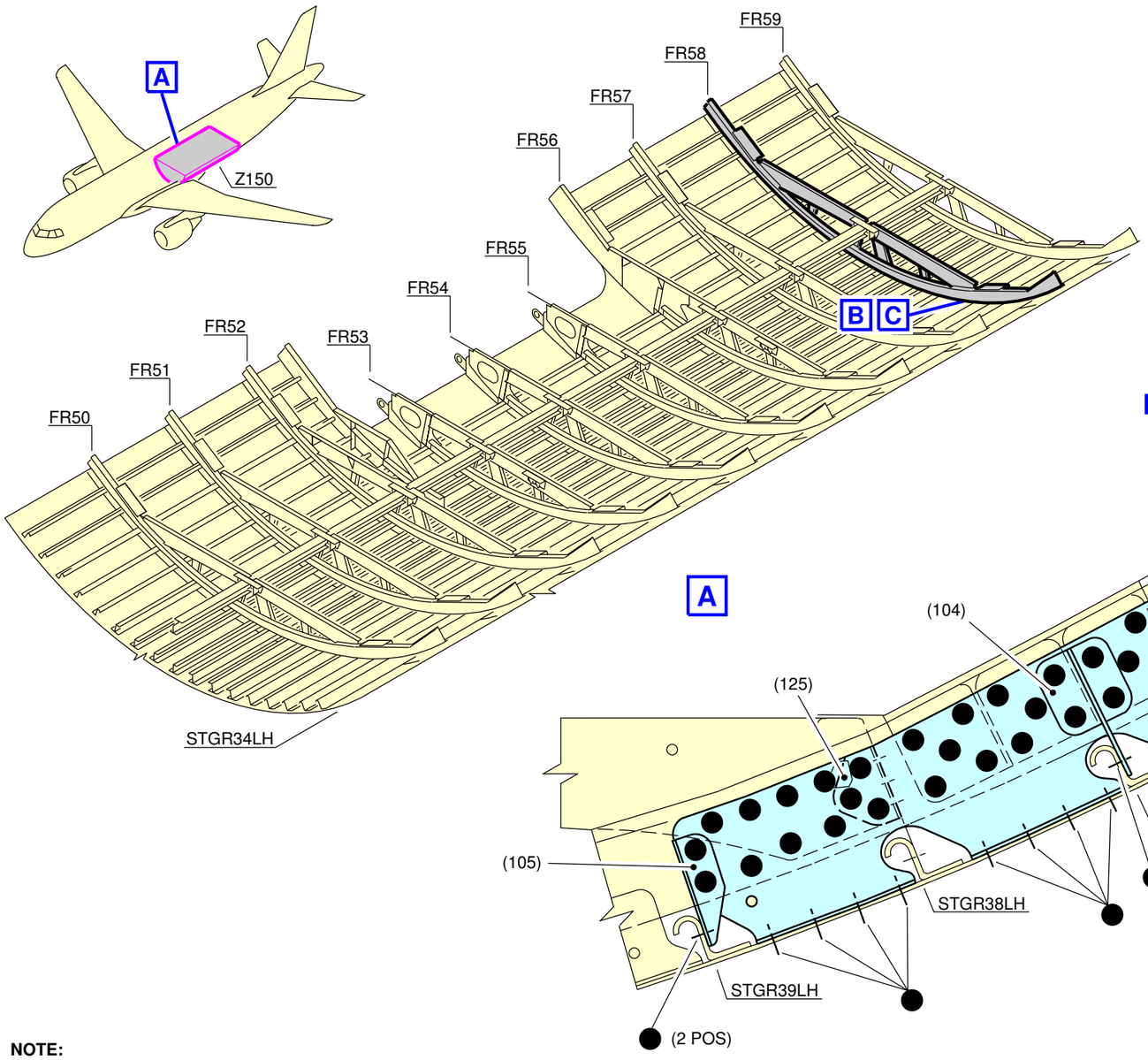
**CONF 002 thru 003



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BJAB_01_00

Figure A-GBJAB - Sheet 01
Replacement of Webs and Angles at Frame 58

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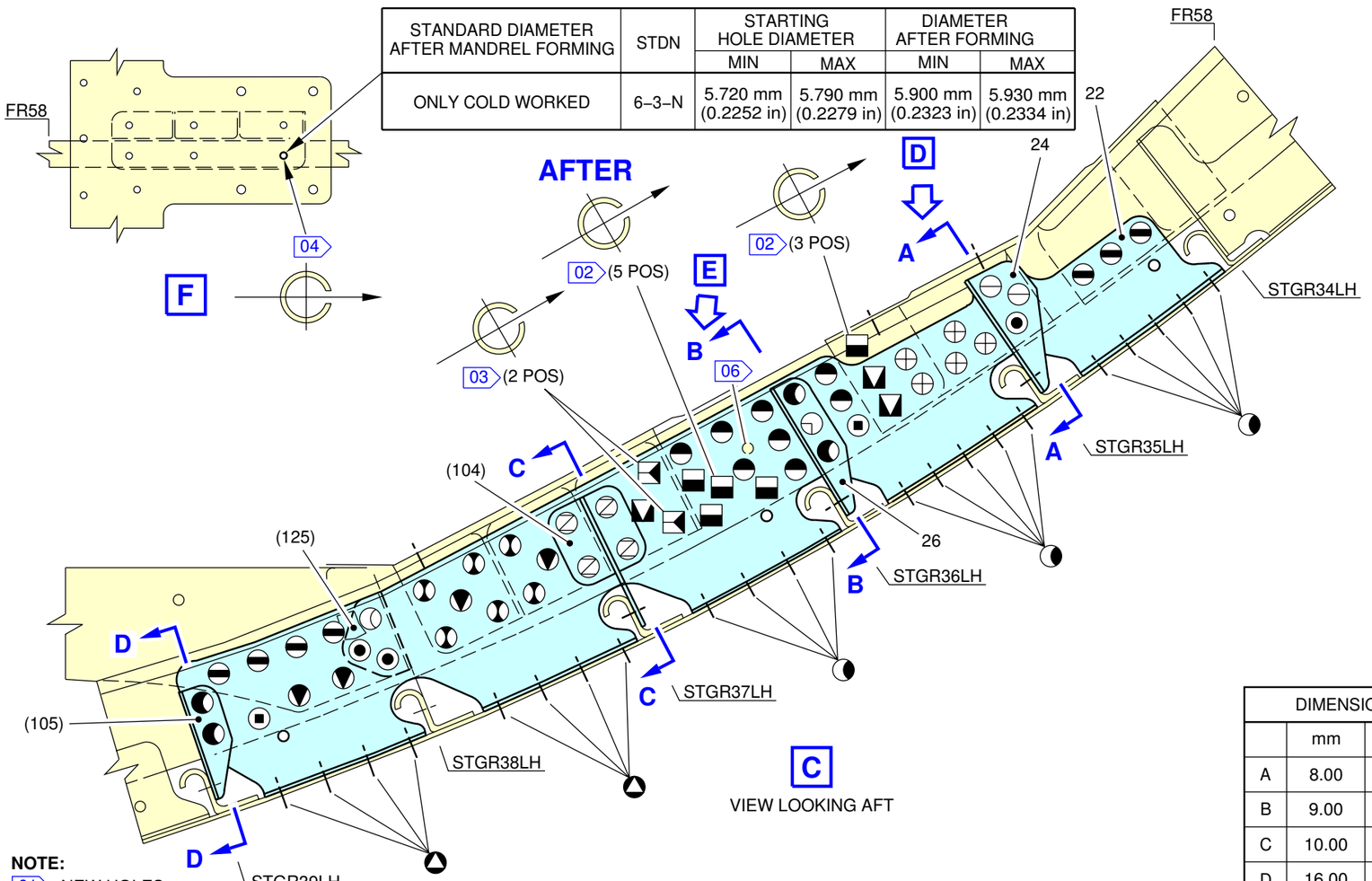
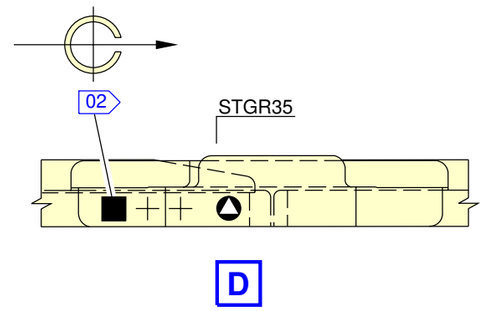
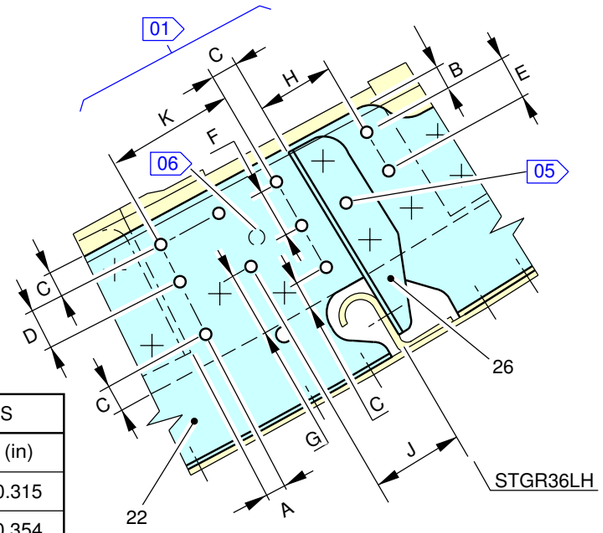
**CONF 002 thru 003

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



C
VIEW LOOKING AFT





E
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	8.00	0.315
B	9.00	0.354
C	10.00	0.394
D	16.00	0.630
E	16.50	0.650
F	19.00	0.748
G	24.40	0.961
H	30.00	1.181
J	34.30	1.350
K	2 x 24.80	2 x 0.976

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

04 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

05 EXISTING PILOT HOLES.

06 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BJAB_02_02

Figure A-GBJAB - Sheet 02
Replacement of Webs and Angles at Frame 58

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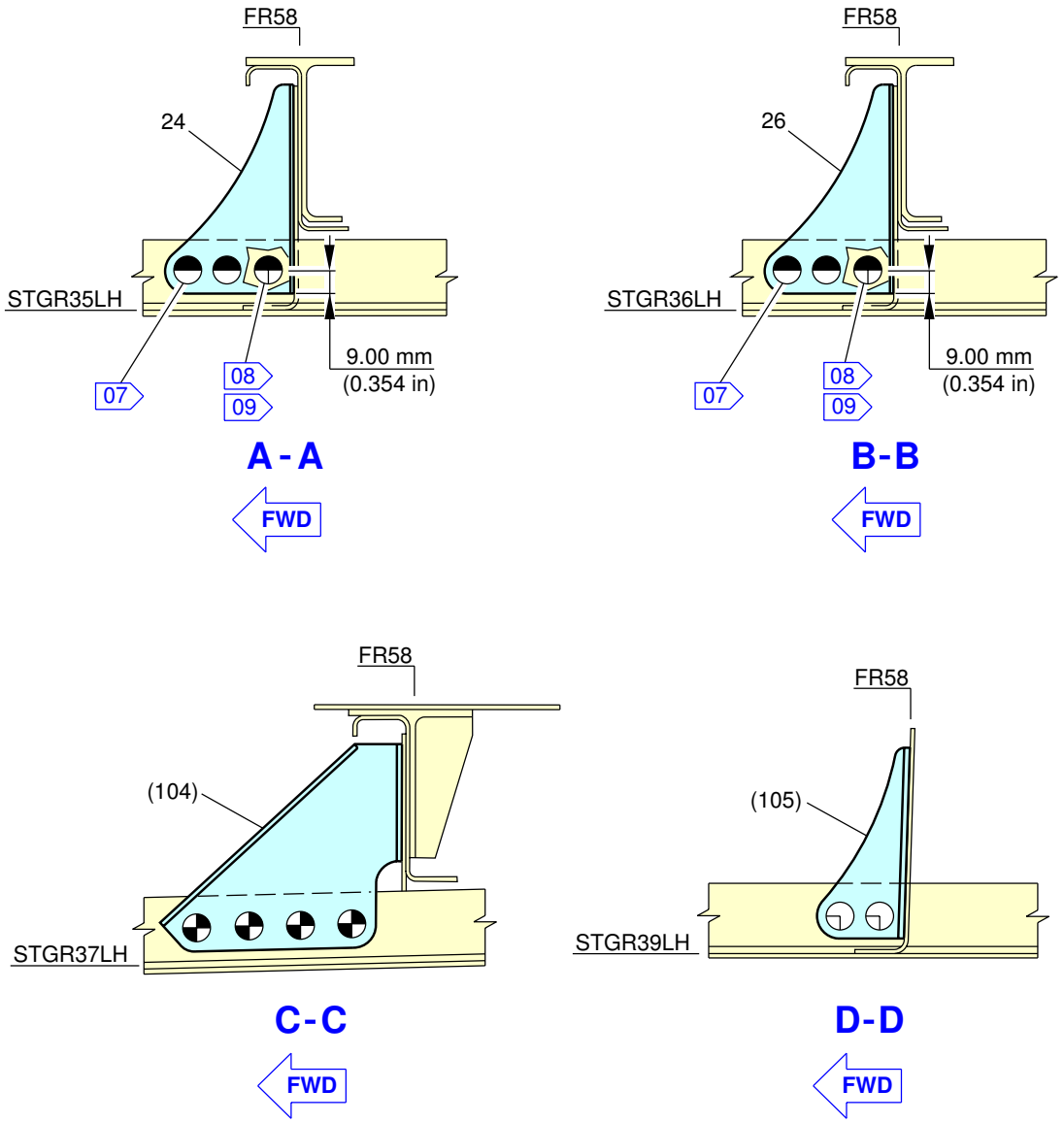
**CONF 002 thru 003



NOTE:

07 EXISTING PILOT HOLES.

08 COUNTERSINK EXISTING HOLE IN THE STRINGER.

09 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BJAB_03_01

Figure A-GBJAB - Sheet 03
Replacement of Webs and Angles at Frame 58

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**CONF 002 thru 003

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	670	EN6081D7–10	RIVET	5.660 mm (0.2229 in)	5.770 mm (0.2271 in)	NOMINAL SIZE

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	678	EN6081D7–08	RIVET	5.660 mm (0.2229 in)	5.770 mm (0.2271 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BJAB_04_02

Figure A-GBJAB - Sheet 04
Replacement of Webs and Angles at Frame 58

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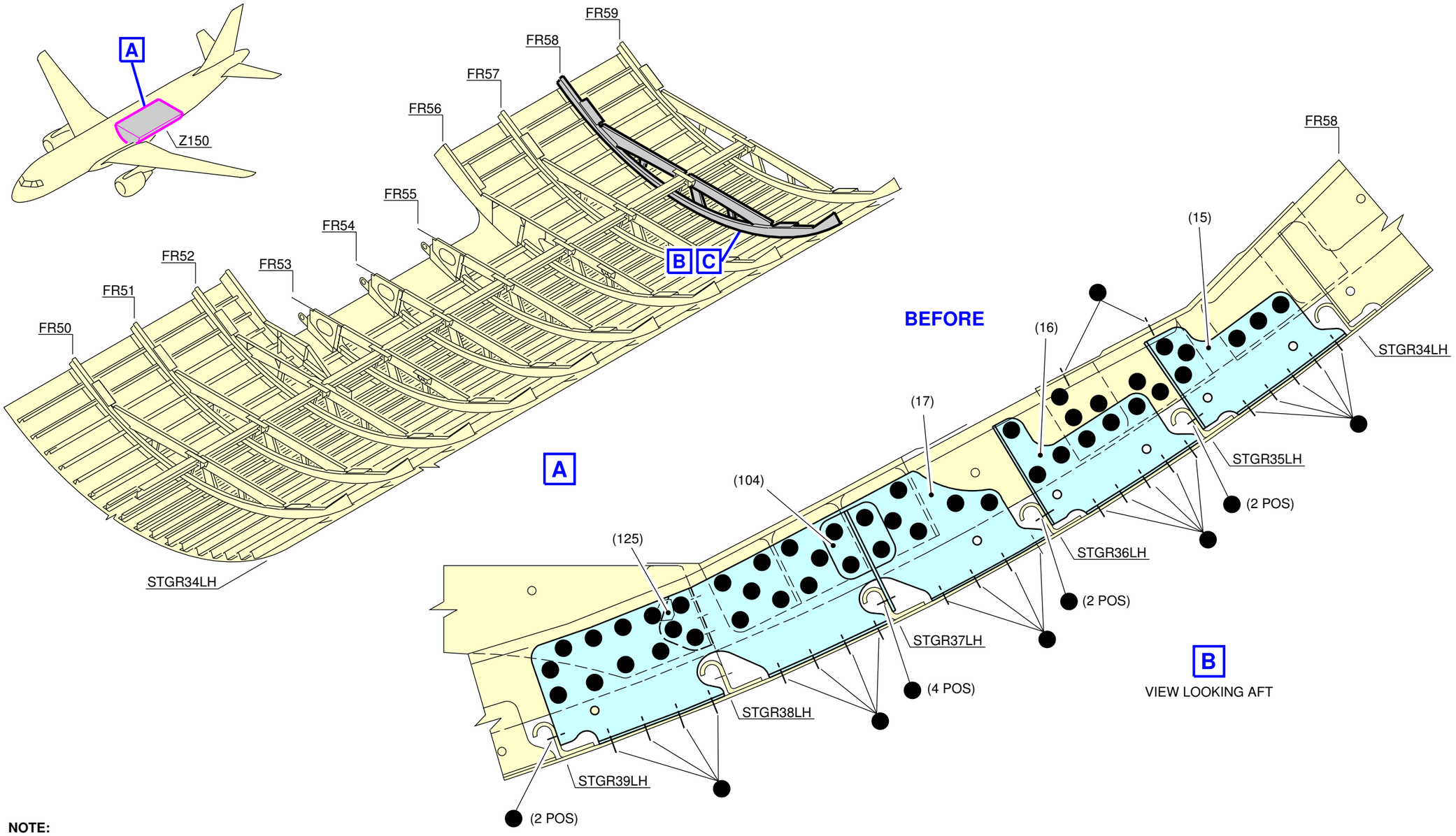
**CONF 004, 006



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BJAD_01_00

Figure A-GBJAD - Sheet 01
Replacement of Webs and Angles at Frame 58

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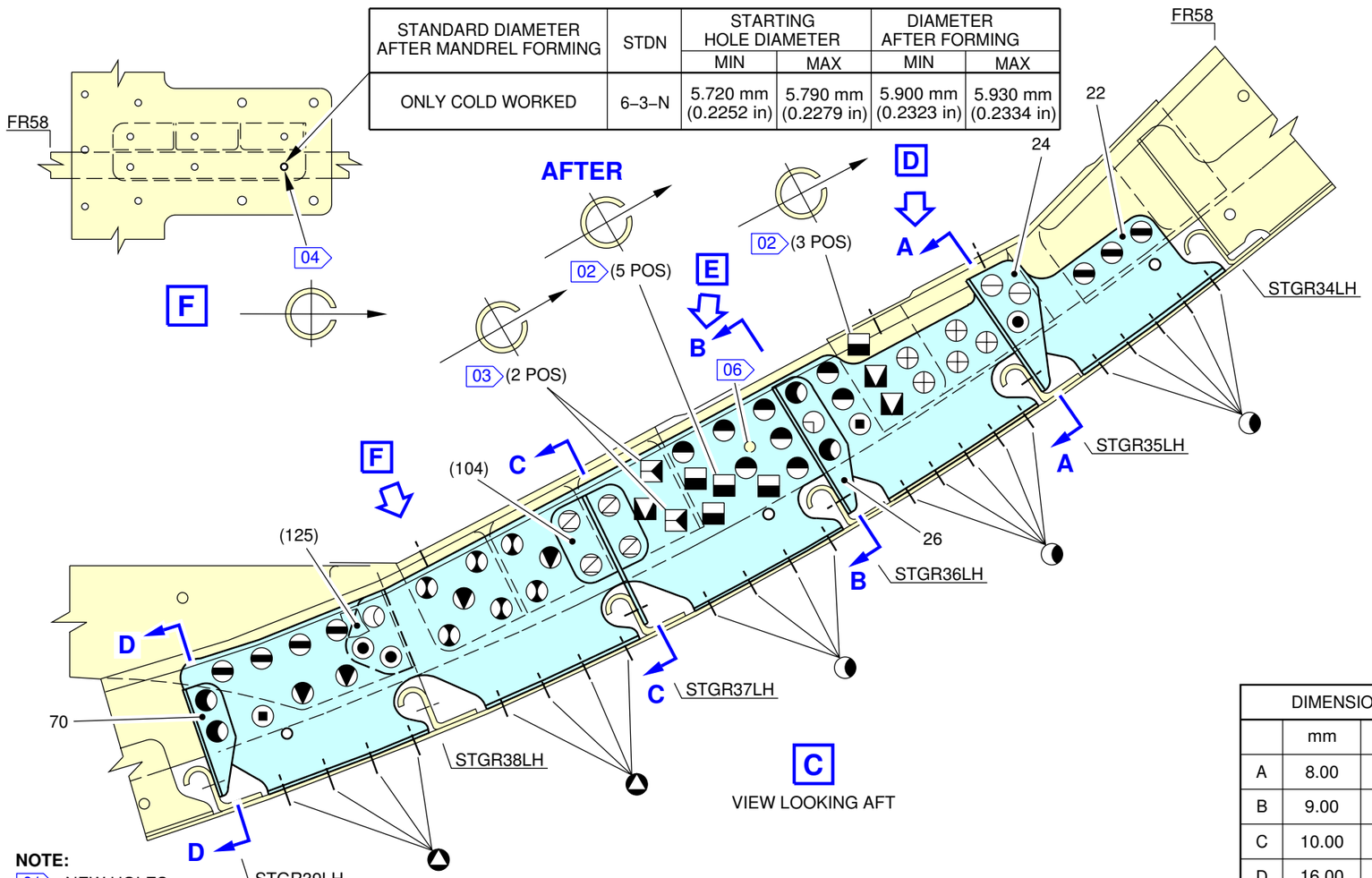
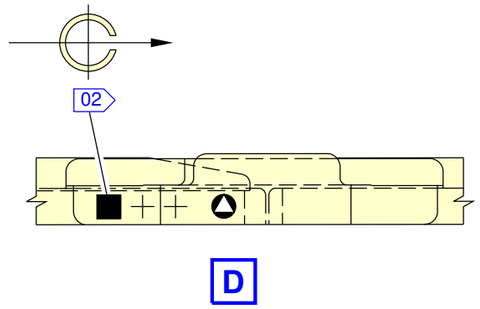
**CONF 004, 006

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)

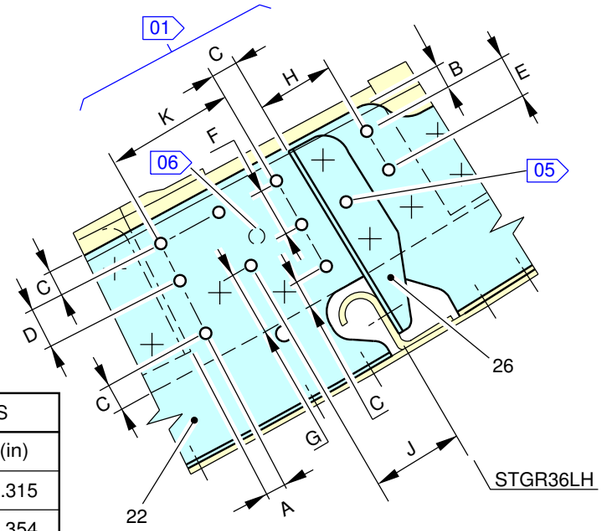


C

VIEW LOOKING AFT



D



E

VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	8.00	0.315
B	9.00	0.354
C	10.00	0.394
D	16.00	0.630
E	16.50	0.650
F	19.00	0.748
G	24.40	0.961
H	30.00	1.181
J	34.30	1.350
K	2 x 24.80	2 x 0.976

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

04 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

05 EXISTING PILOT HOLES.

06 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BJAD_02_01

Figure A-GBJAD - Sheet 02
Replacement of Webs and Angles at Frame 58

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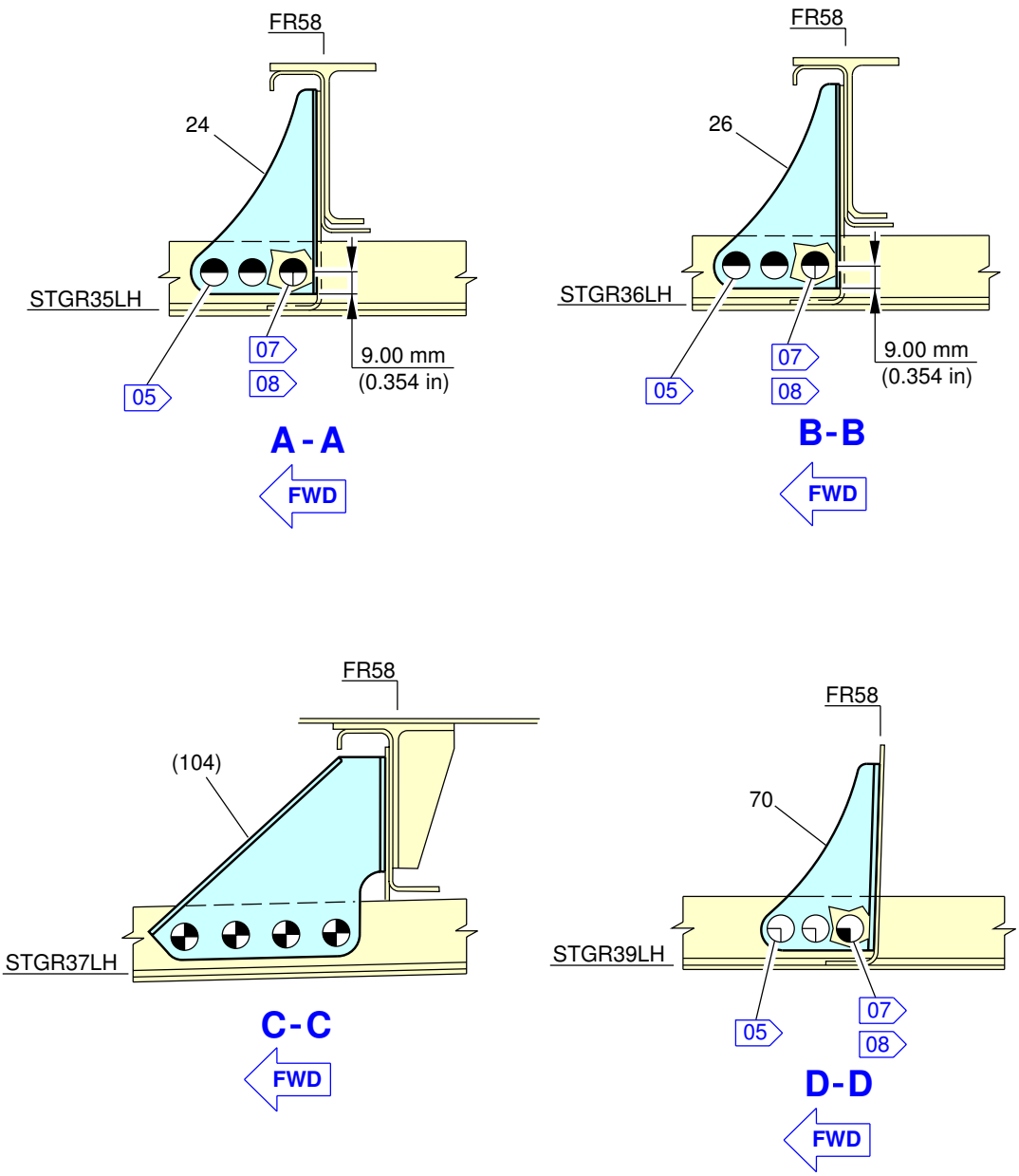
**CONF 004, 006



NOTE:

05 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BJAD_03_01

Figure A-GBJAD - Sheet 03
Replacement of Webs and Angles at Frame 58

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**CONF 004, 006

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	670	EN6081D7–10	RIVET	5.660 mm (0.2229 in)	5.770 mm (0.2271 in)	NOMINAL SIZE

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	678	EN6081D7–08	RIVET	5.660 mm (0.2229 in)	5.770 mm (0.2271 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BJAD_04_01

Figure A-GBJAD - Sheet 04
Replacement of Webs and Angles at Frame 58

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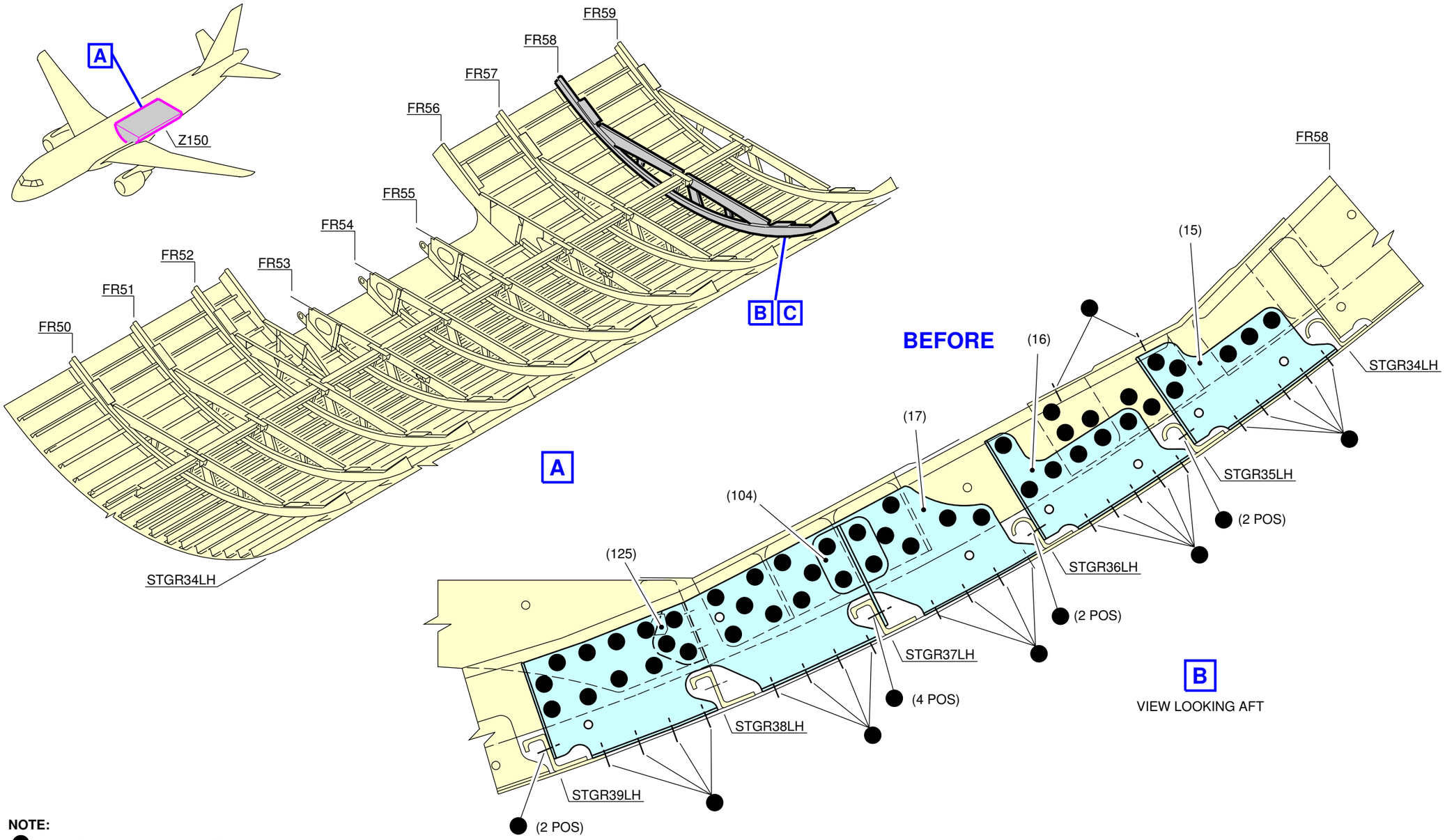
**CONF 005, 007



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BJAE_01_00

Figure A-GBJAE - Sheet 01
Replacement of Webs and Angles at Frame 58

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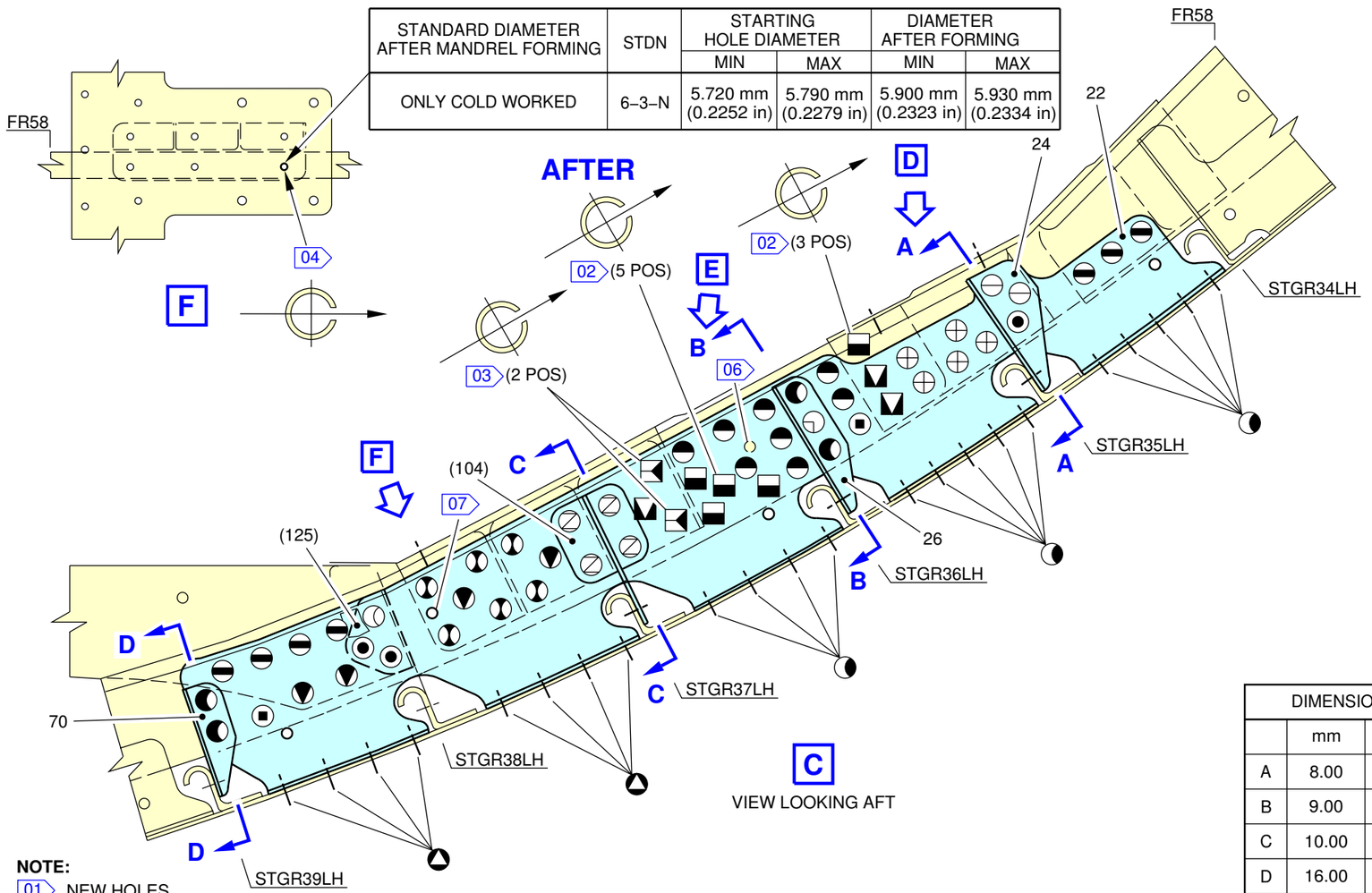
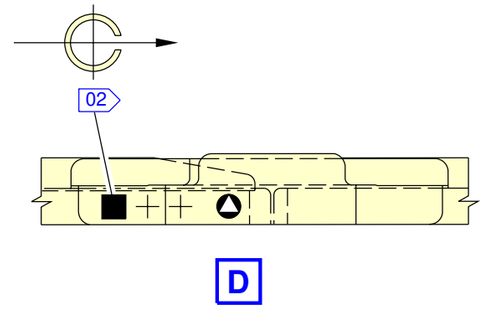
**CONF 005, 007

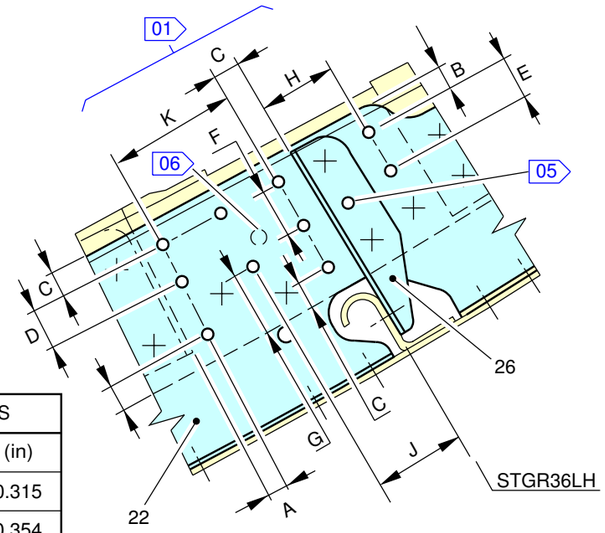
STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



C

VIEW LOOKING AFT





E

VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	8.00	0.315
B	9.00	0.354
C	10.00	0.394
D	16.00	0.630
E	16.50	0.650
F	19.00	0.748
G	24.40	0.961
H	30.00	1.181
J	34.30	1.350
K	2 x 24.80	2 x 0.976

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

04 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

05 EXISTING PILOT HOLES.

06 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

07 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in). FOR MSN 3999 AND SUBSEQUENT.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BJAE_02_02

Figure A-GBJAE - Sheet 02
Replacement of Webs and Angles at Frame 58

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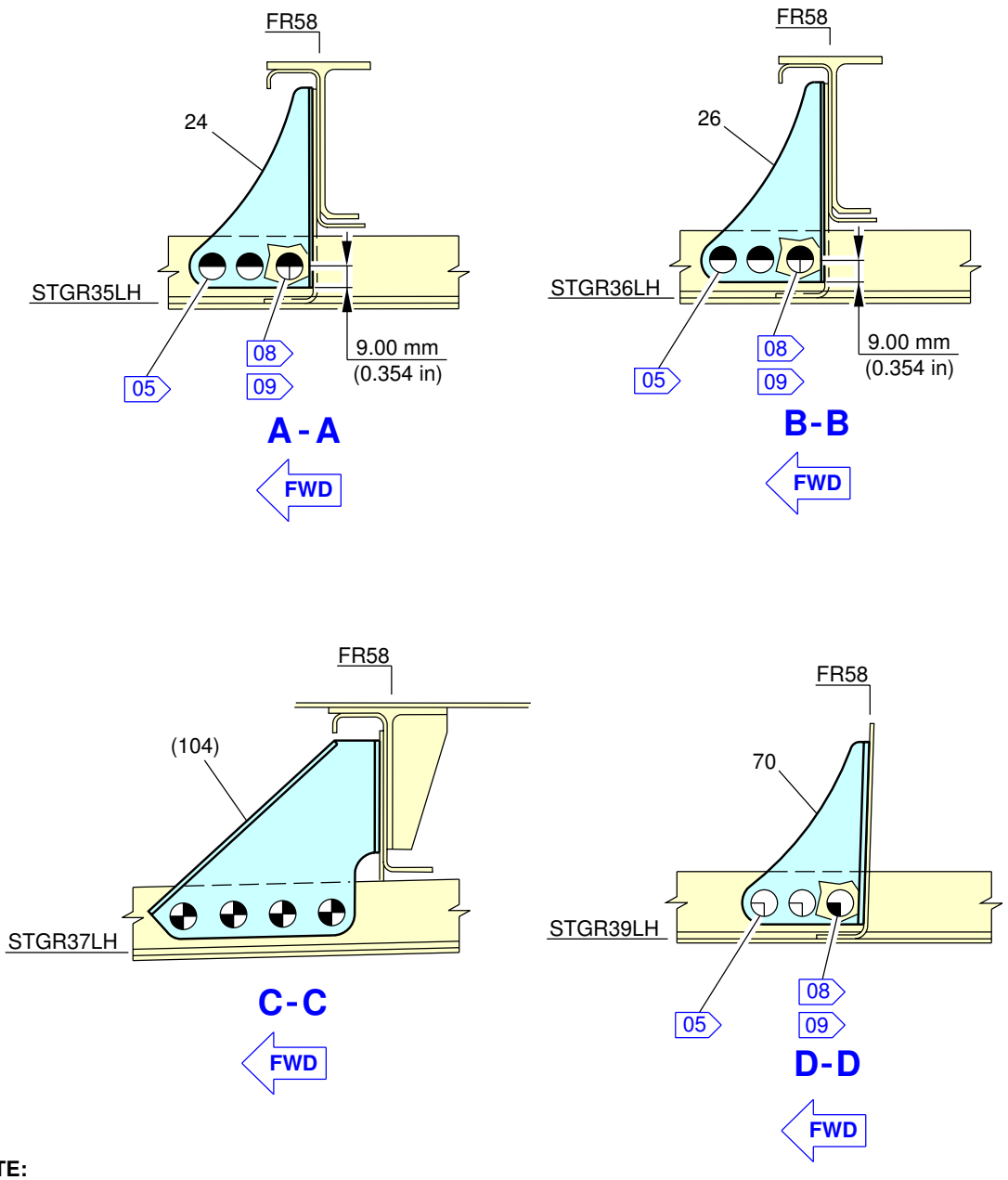
****CONF 005, 007**



NOTE:

05 EXISTING PILOT HOLES.

08 COUNTERSINK EXISTING HOLE IN THE STRINGER.

09 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BJAE_03_01

Figure A-GBJAE - Sheet 03
Replacement of Webs and Angles at Frame 58

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**CONF 005, 007

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	670	EN6081D7–10	RIVET	5.660 mm (0.2229 in)	5.770 mm (0.2271 in)	NOMINAL SIZE

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	678	EN6081D7–08	RIVET	5.660 mm (0.2229 in)	5.770 mm (0.2271 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BJAE_04_02

Figure A-GBJAE - Sheet 04
Replacement of Webs and Angles at Frame 58

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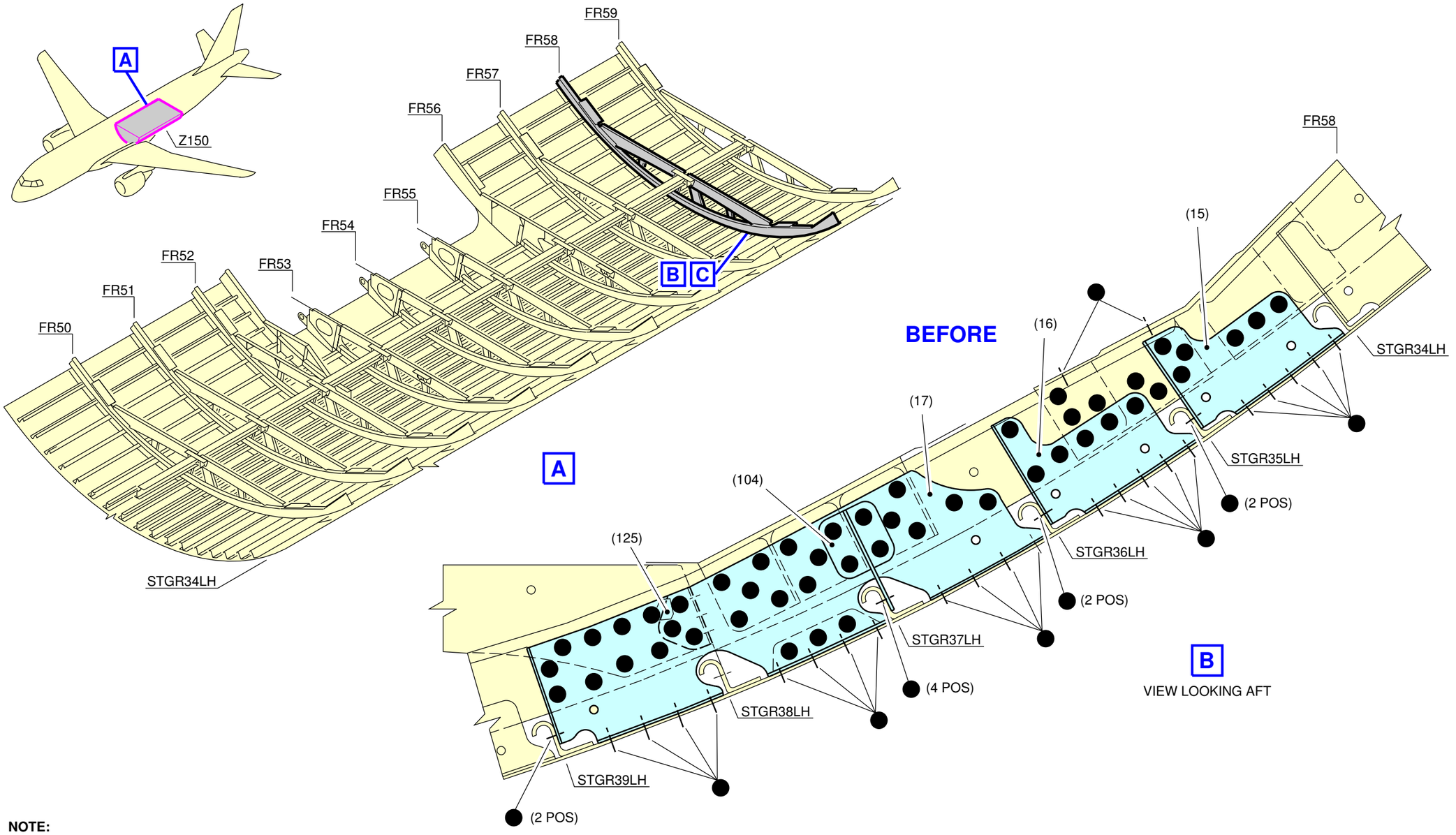
**CONF 008



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BJAH_01_00

Figure A-GBJAH - Sheet 01
Replacement of Webs and Angles at Frame 58

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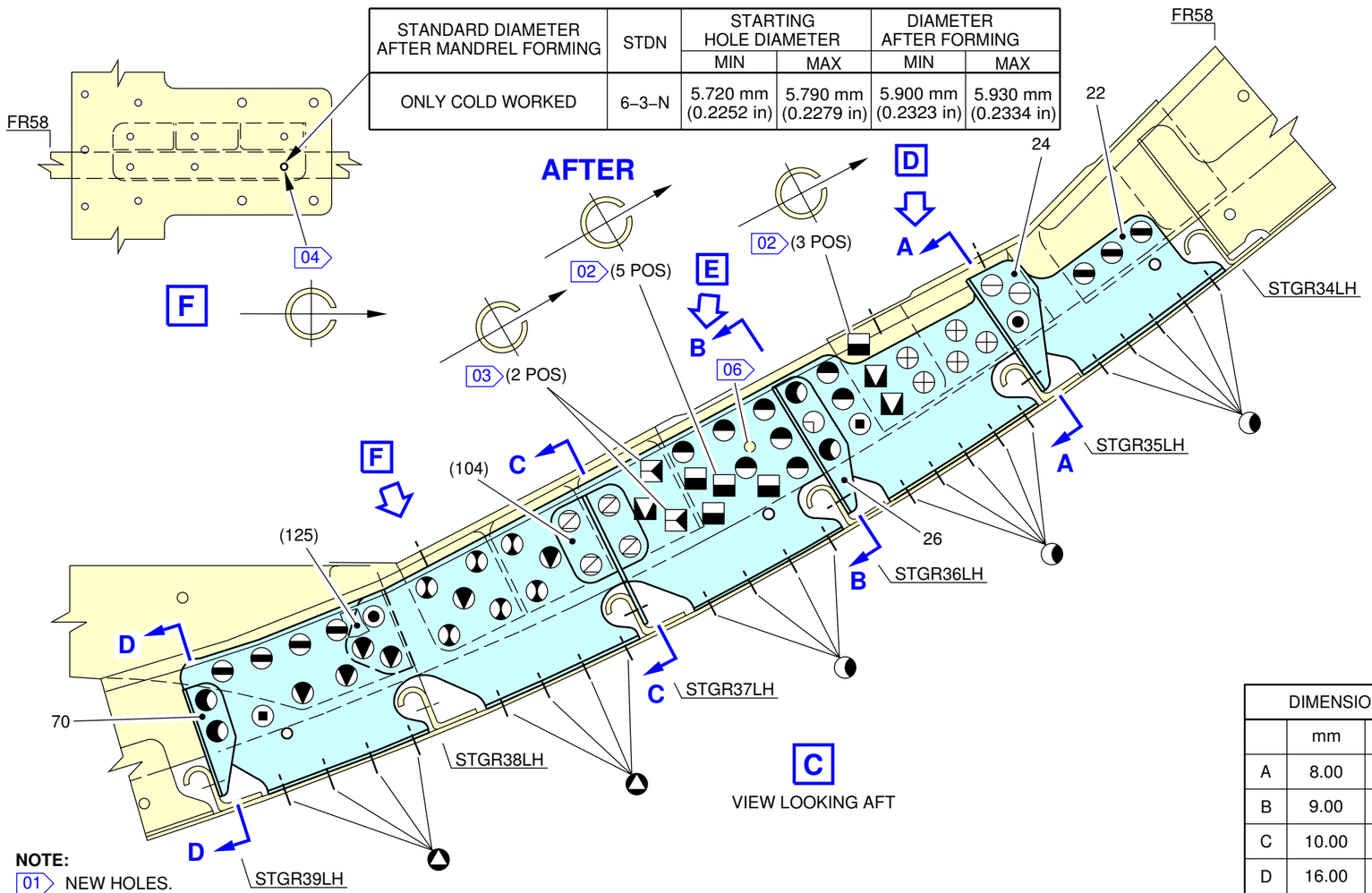
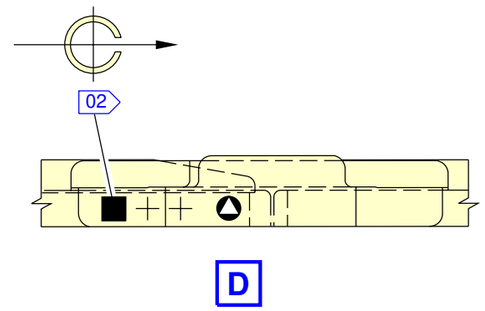
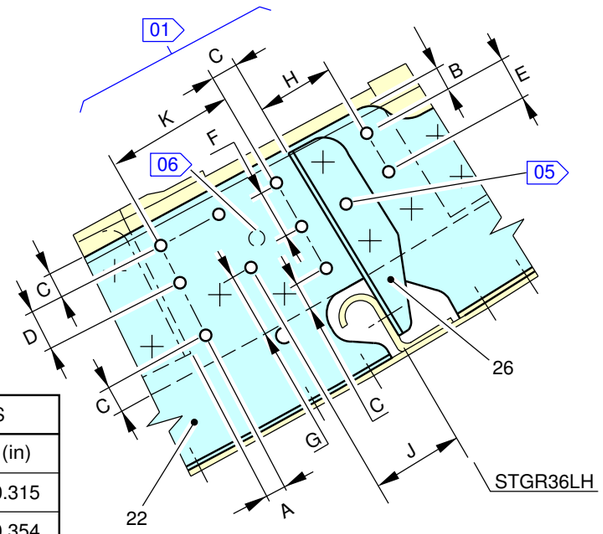
**CONF 008

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)







DIMENSIONS		
	mm	(in)
A	8.00	0.315
B	9.00	0.354
C	10.00	0.394
D	16.00	0.630
E	16.50	0.650
F	19.00	0.748
G	24.40	0.961
H	30.00	1.181
J	34.30	1.350
K	2 x 24.80	2 x 0.976

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

04 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

05 EXISTING PILOT HOLES.

06 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

N_SB_531364_6_BJAH_02_02

Figure A-GBJAH - Sheet 02
Replacement of Webs and Angles at Frame 58

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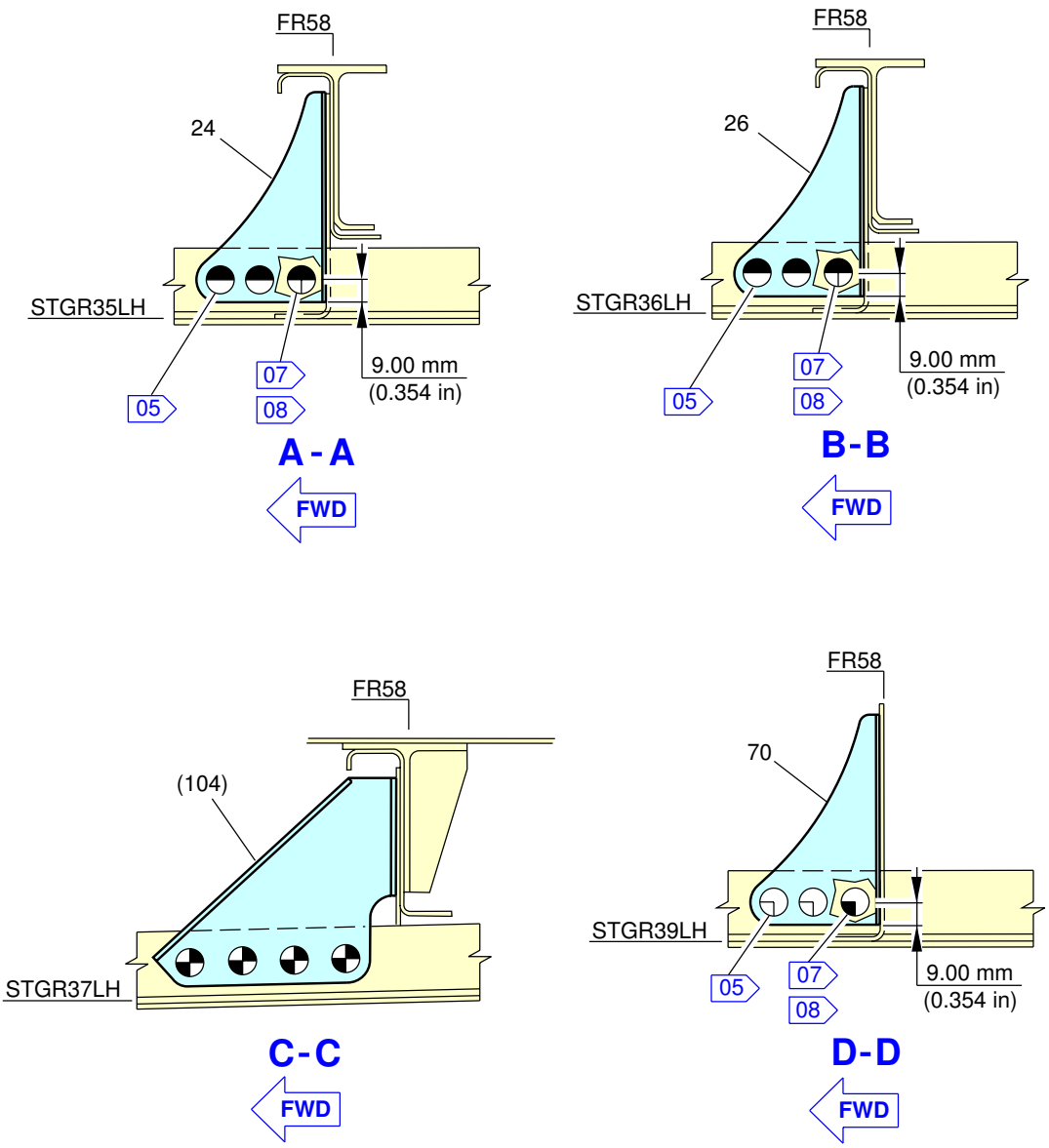
**CONF 008



NOTE:

05 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BJAH_03_01

Figure A-GBJAH - Sheet 03
Replacement of Webs and Angles at Frame 58

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**CONF 008

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	670	EN6081D7–10	RIVET	5.660 mm (0.2229 in)	5.770 mm (0.2271 in)	NOMINAL SIZE
	678	EN6081D7–08	RIVET	5.660 mm (0.2229 in)	5.770 mm (0.2271 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BJAH_04_02

Figure A-GBJAH - Sheet 04
Replacement of Webs and Angles at Frame 58

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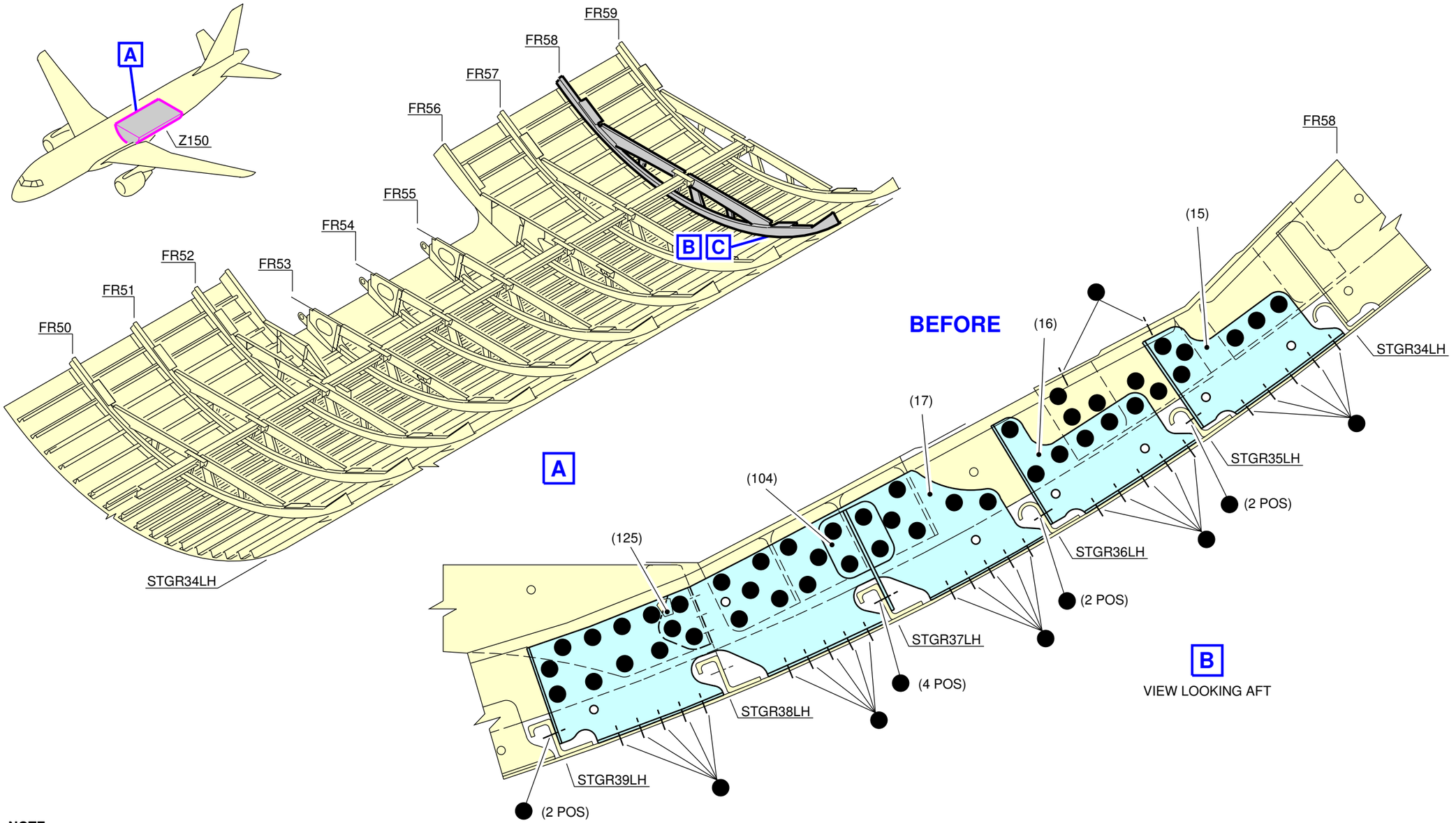
**CONF 009



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BJAJ_01_00

Figure A-GBJAJ - Sheet 01
Replacement of Webs and Angles at Frame 58

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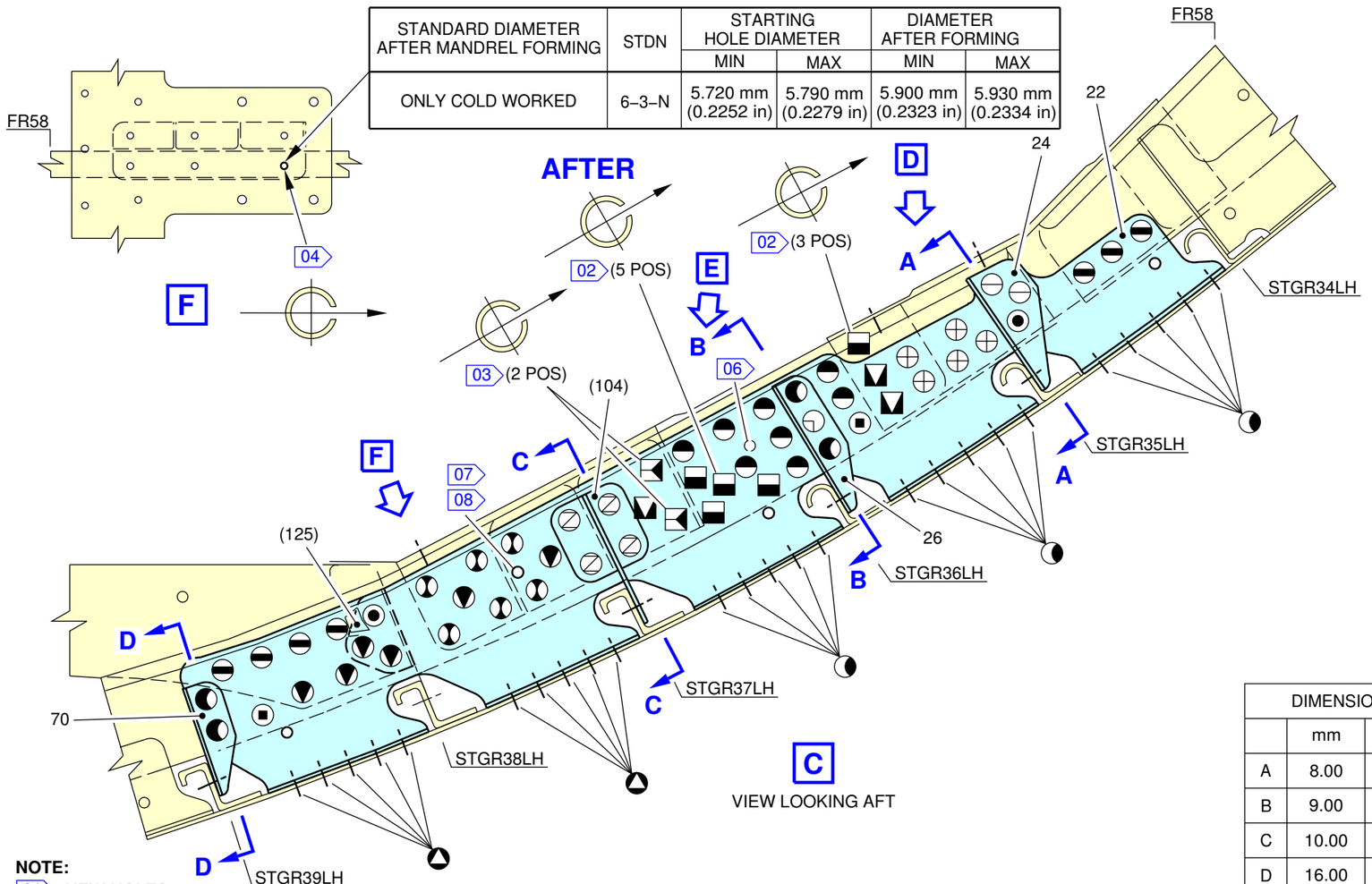
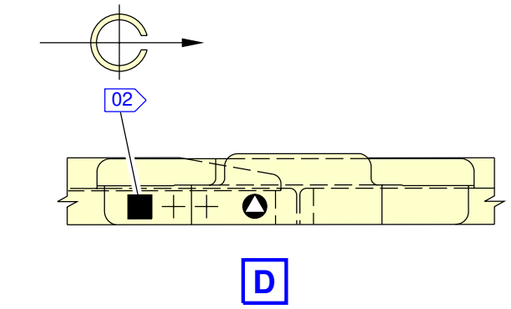
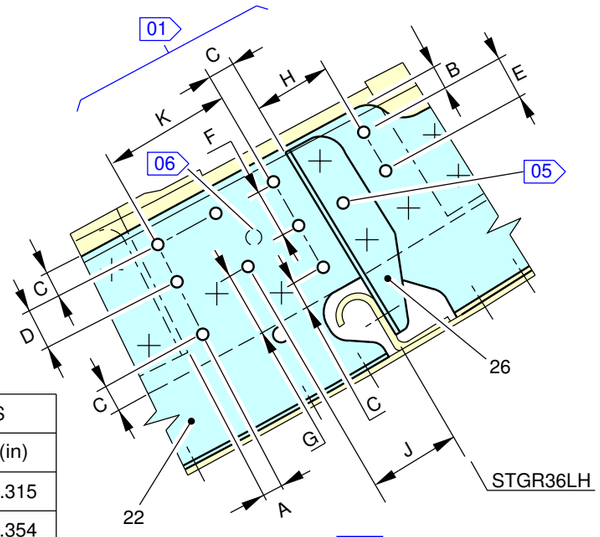
**CONF 009

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2279 in)	5.900 mm (0.2323 in)	5.930 mm (0.2334 in)



C
VIEW LOOKING AFT





E
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	8.00	0.315
B	9.00	0.354
C	10.00	0.394
D	16.00	0.630
E	16.50	0.650
F	19.00	0.748
G	24.40	0.961
H	30.00	1.181
J	34.30	1.350
K	2 x 24.80	2 x 0.976

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 COLD EXPANSION STDN 6–1–N I.A.W. SRM 51–48–00.

04 COLD EXPANSION STDN 6–3–N I.A.W. SRM 51–48–00. AFTER COLD WORKING OF THIS FASTENER HOLE, THE ORIGINAL BOLT WITH A DIAMETER OF 4.800 mm (0.1889 in) CAN BE USED TO INSTALL THE YZ–LATCH OF THE CARGO LOADING SYSTEM.

05 EXISTING PILOT HOLES.

06 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

07 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in).

08 VALID FOR MSN 4005 AND SUBSEQUENT.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BJAJ_02_01

Figure A-GBJAJ - Sheet 02
Replacement of Webs and Angles at Frame 58

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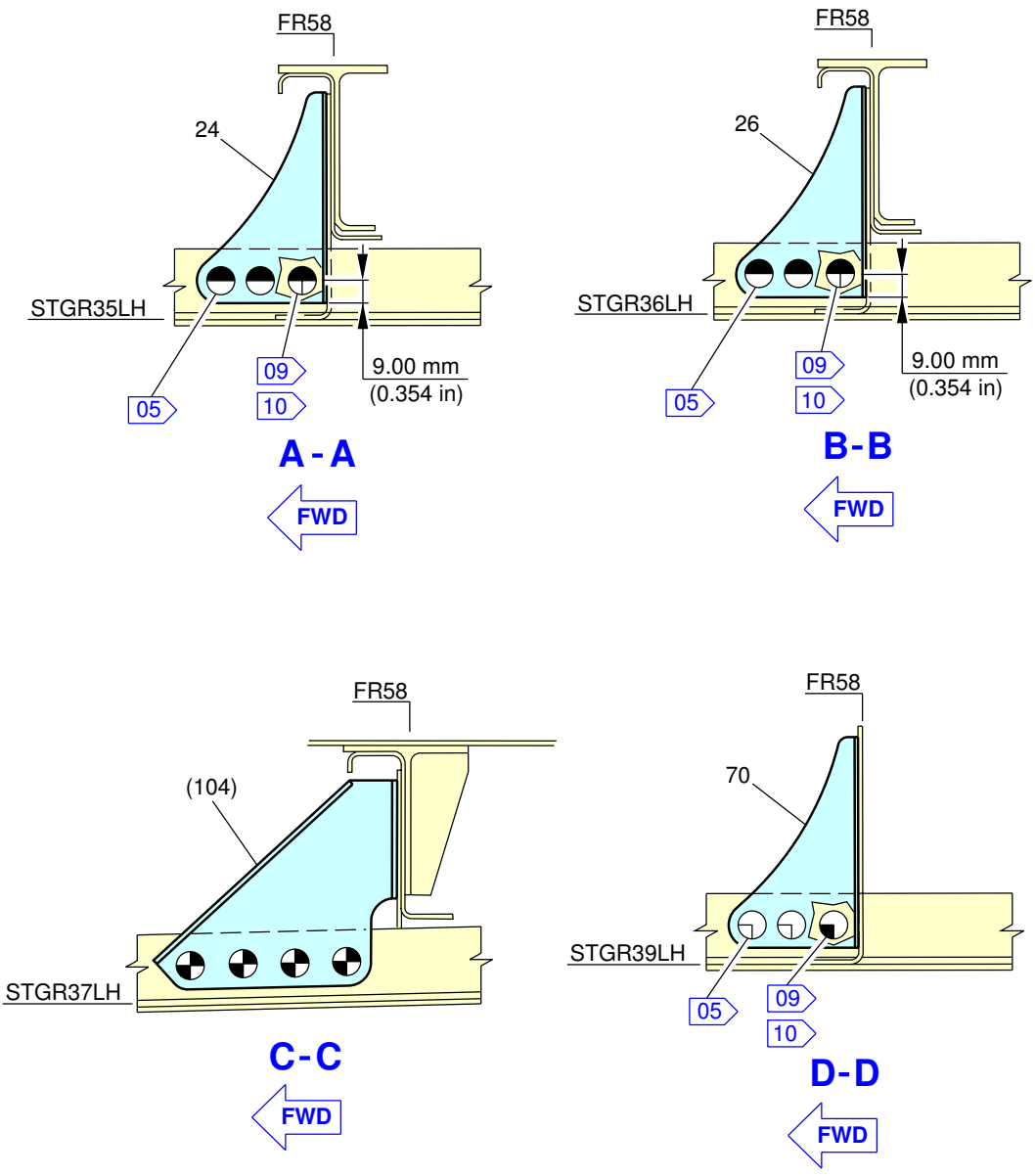
**CONF 009



NOTE:

05 EXISTING PILOT HOLES.

09 COUNTERSINK EXISTING HOLE IN THE STRINGER.

10 CLOSE EXISTING RIVET HOLE IN THE STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BJAJ_03_01

Figure A-GBJAJ - Sheet 03
Replacement of Webs and Angles at Frame 58

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**CONF 009

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	374	EN6115K3A4	PIN	6–1–N	4.880 mm (0.1922 in)	4.930 mm (0.1940 in)	5.452 mm (0.2147 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT
	908	ASNA2528–3A	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	670	EN6081D7–10	RIVET	5.660 mm (0.2229 in)	5.770 mm (0.2271 in)	NOMINAL SIZE
	678	EN6081D7–08	RIVET	5.660 mm (0.2229 in)	5.770 mm (0.2271 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BJAJ_04_01

Figure A-GBJAJ - Sheet 04
Replacement of Webs and Angles at Frame 58

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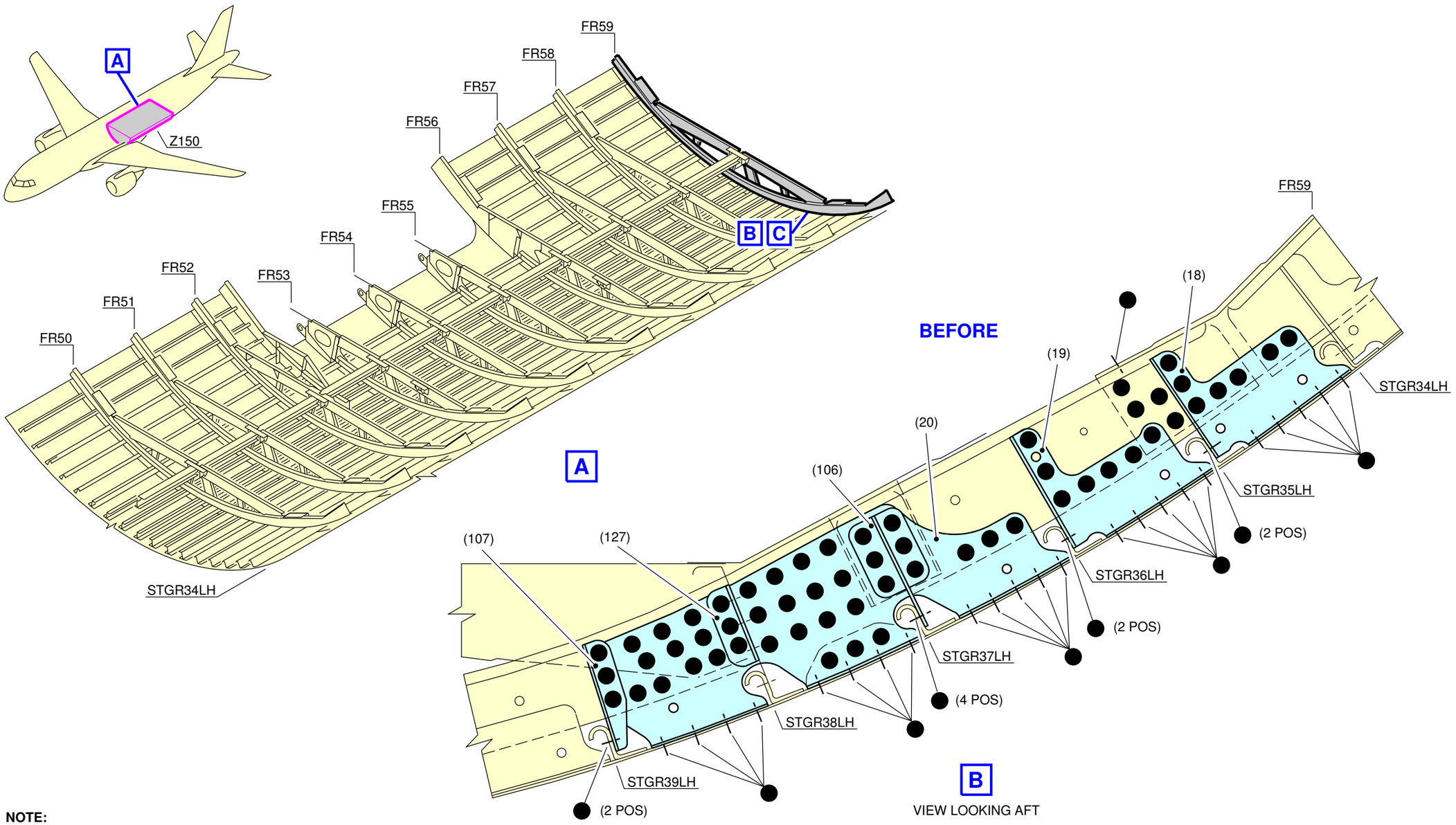
**CONF 001



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BKAA_01_00

Figure A-GBKAA - Sheet 01
Replacement of Webs and Angles at Frame 59

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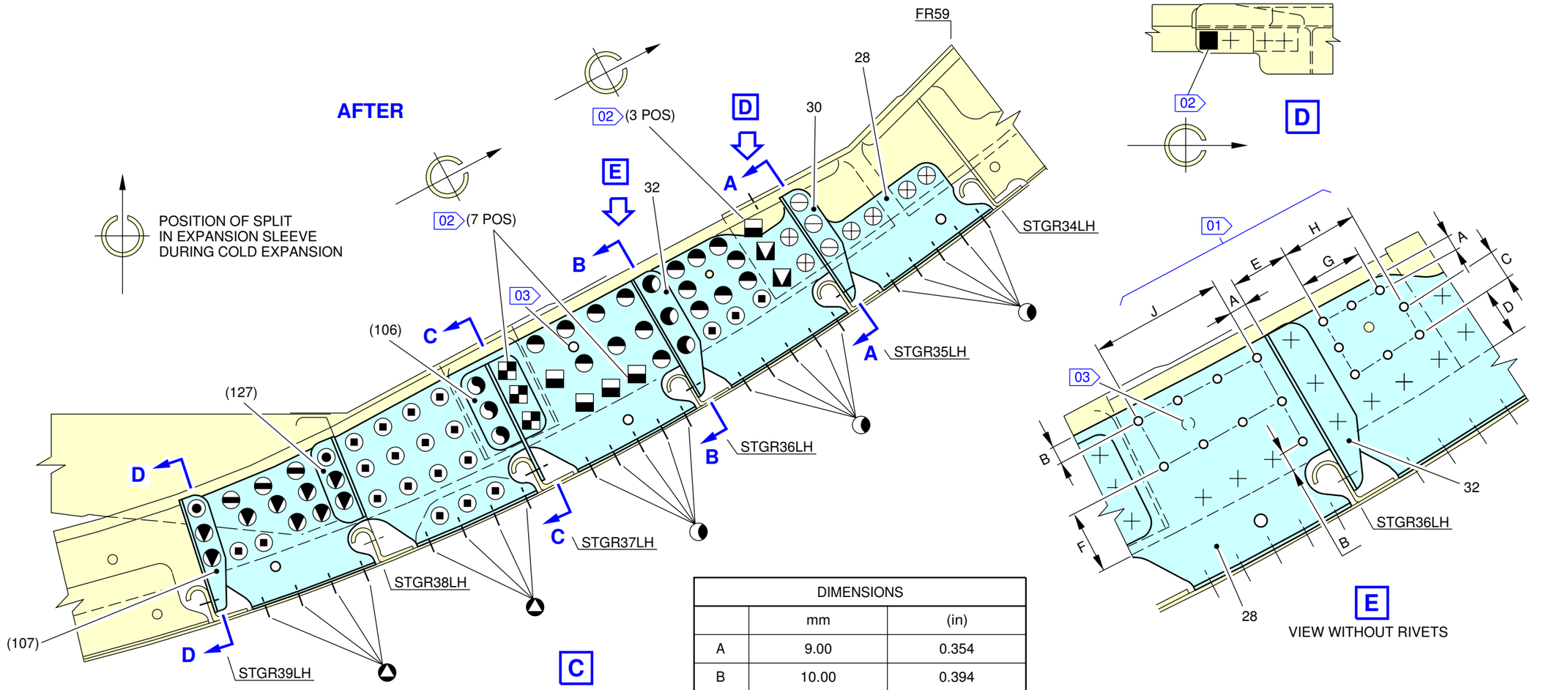
**CONF 001



DIMENSIONS		
	mm	(in)
A	9.00	0.354
B	10.00	0.394
C	16.50	0.650
D	26.00	1.024
E	31.00	1.220
F	33.40	1.315
G	2 x 16.90	2 x 0.665
H	2 x 20.00	2 x 0.787
J	3 x 23.40	3 x 0.921

NOTE:

01 NEW HOLES

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4

N_SB_531364_6_BKAA_02_01

Figure A-GBKAA - Sheet 02
Replacement of Webs and Angles at Frame 59

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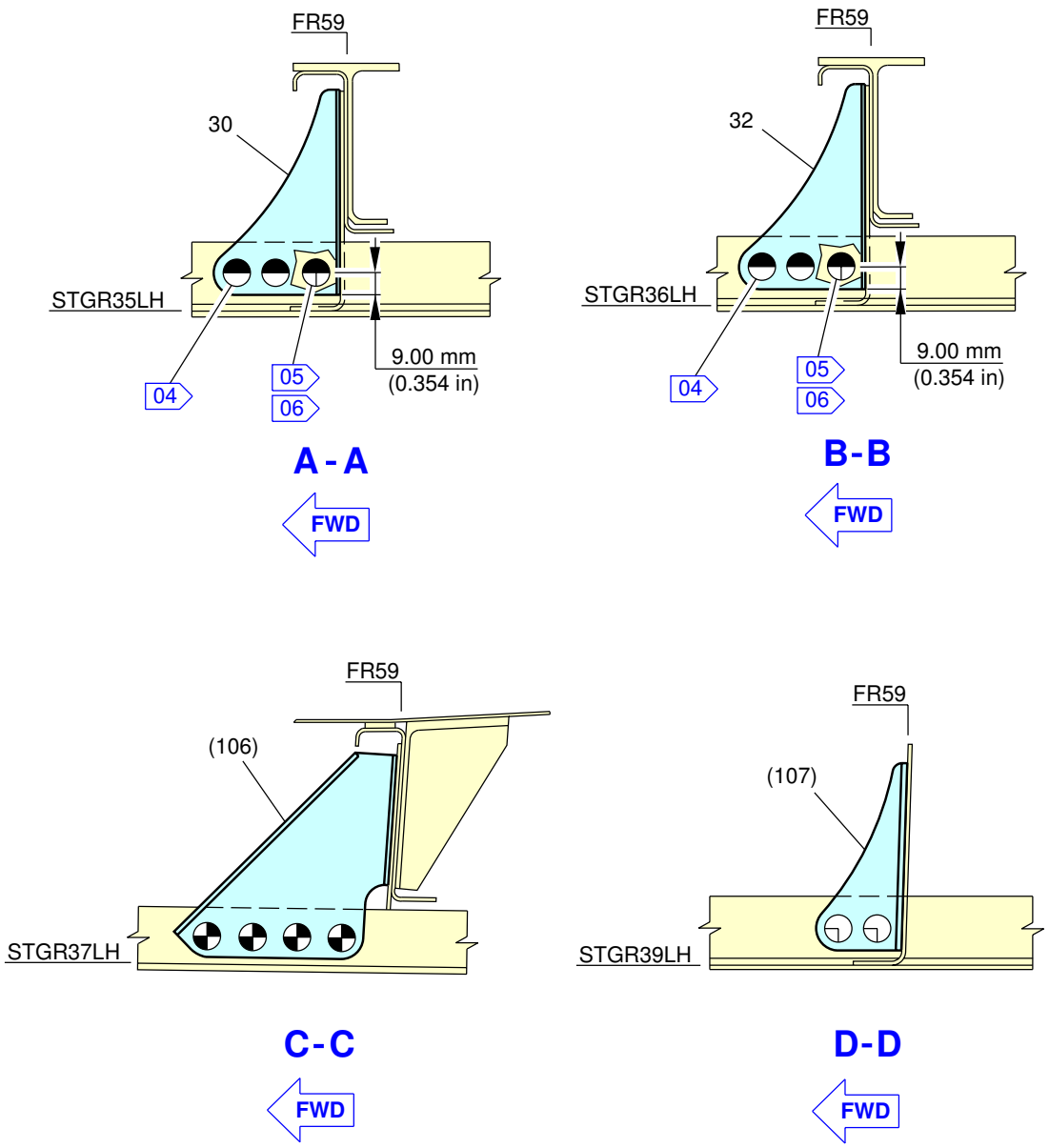
**CONF 001



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BKAA_03_01

Figure A-GBKAA - Sheet 03
Replacement of Webs and Angles at Frame 59

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**CONF 001

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
⬓	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
◪	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
⬔	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
■	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
◓	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◑	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◓	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◱	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
▣	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◐	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◒	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◔	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
⊖	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
⊙	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
▲	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
◓	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
⊕	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
⊖	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BKAA_04_01

Figure A-GBKAA - Sheet 04
Replacement of Webs and Angles at Frame 59

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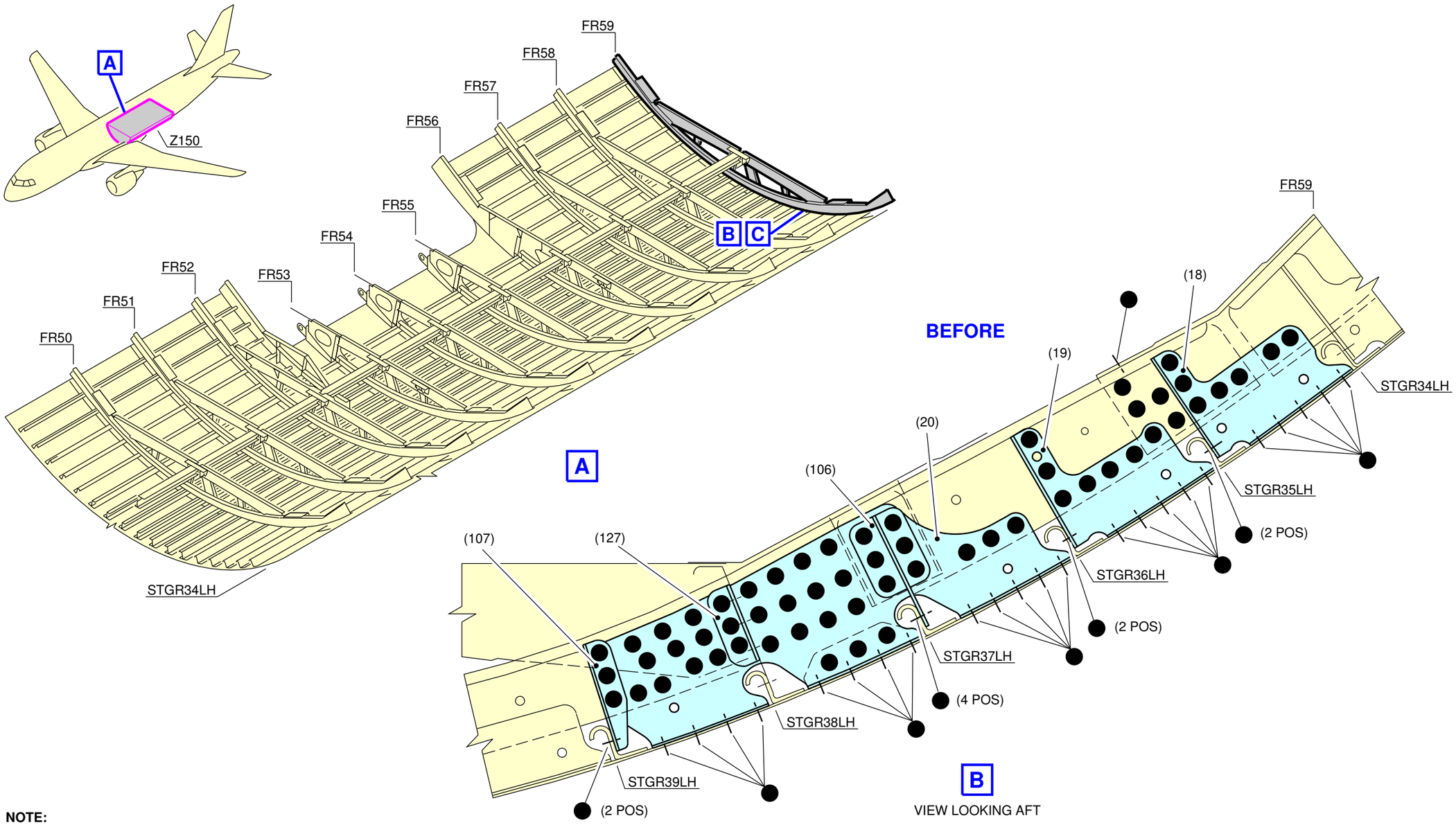
**CONF 002 thru 003



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BKAB_01_00

Figure A-GBKAB - Sheet 01
Replacement of Webs and Angles at Frame 59

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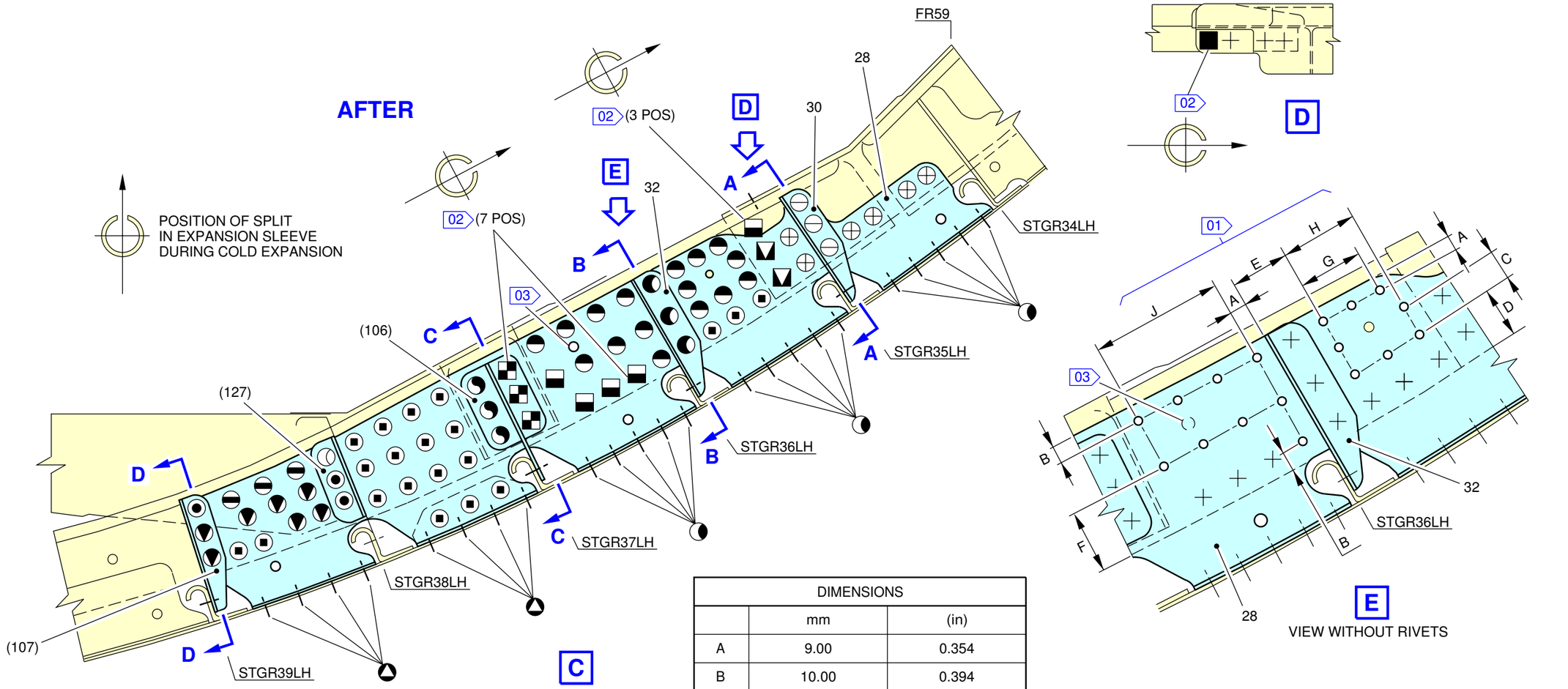
**CONF 002 thru 003



DIMENSIONS		
	mm	(in)
A	9.00	0.354
B	10.00	0.394
C	16.50	0.650
D	26.00	1.024
E	31.00	1.220
F	33.40	1.315
G	2 x 16.90	2 x 0.665
H	2 x 20.00	2 x 0.787
J	3 x 23.40	3 x 0.921

NOTE:

01 NEW HOLES

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4

N_SB_531364_6_BKAB_02_01

Figure A-GBKAB - Sheet 02
Replacement of Webs and Angles at Frame 59

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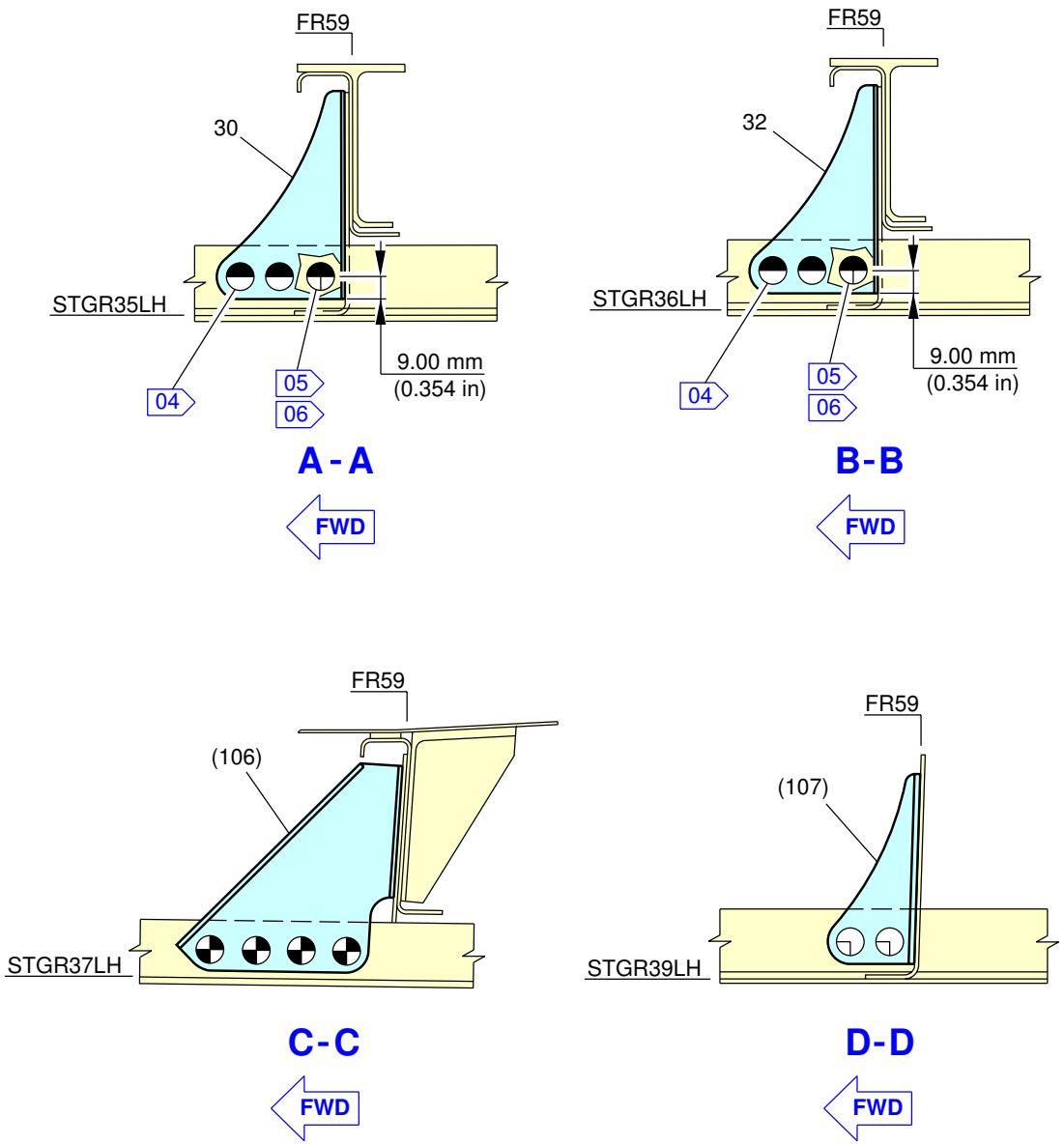
**CONF 002 thru 003



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BKAB_03_01

Figure A-GBKAB - Sheet 03
Replacement of Webs and Angles at Frame 59

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**CONF 002 thru 003

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BKAB_04_01

Figure A-GBKAB - Sheet 04
Replacement of Webs and Angles at Frame 59

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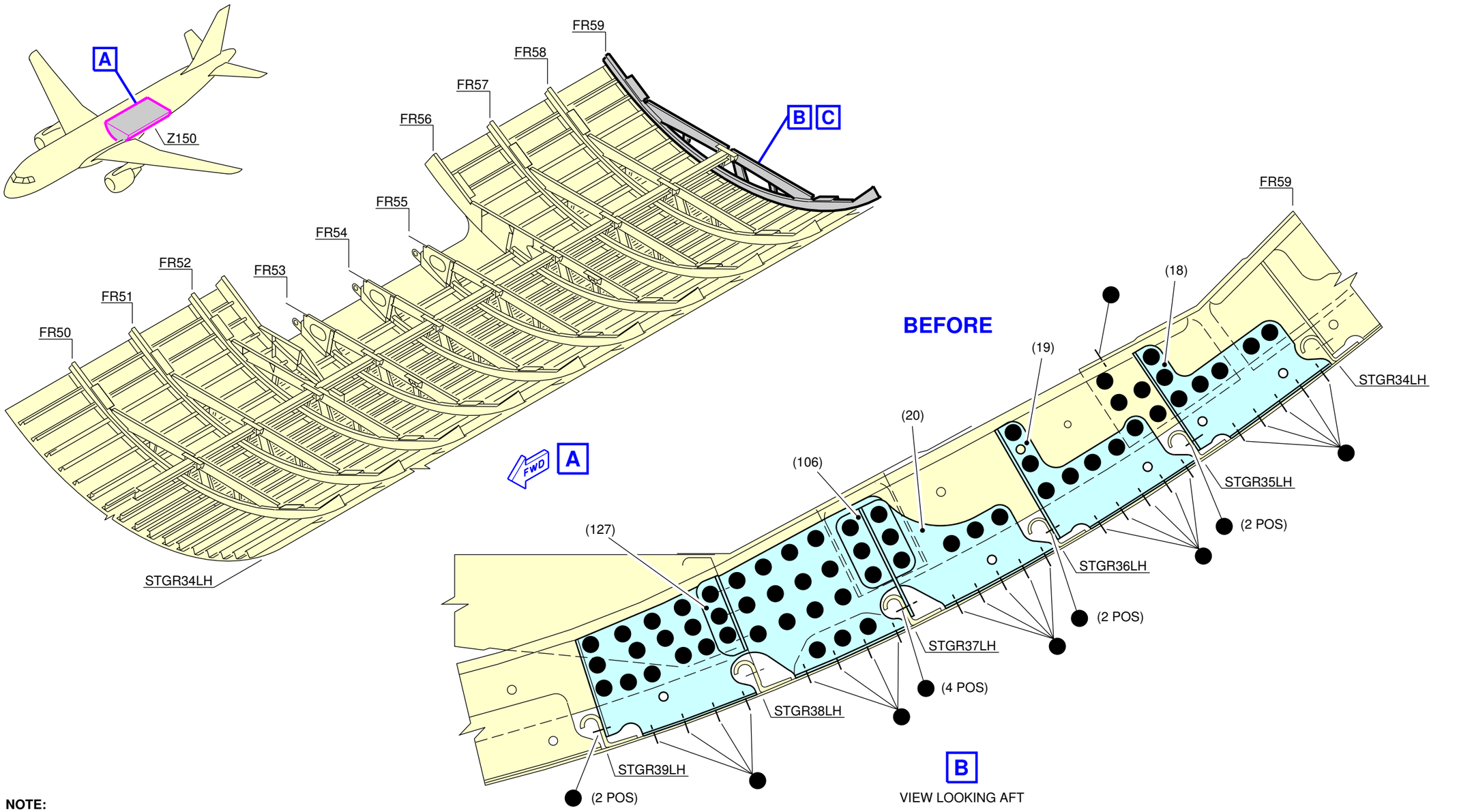
**CONF 004, 006



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BKAD_01_00

Figure A-GBKAD - Sheet 01
Replacement of Webs and Angles at Frame 59

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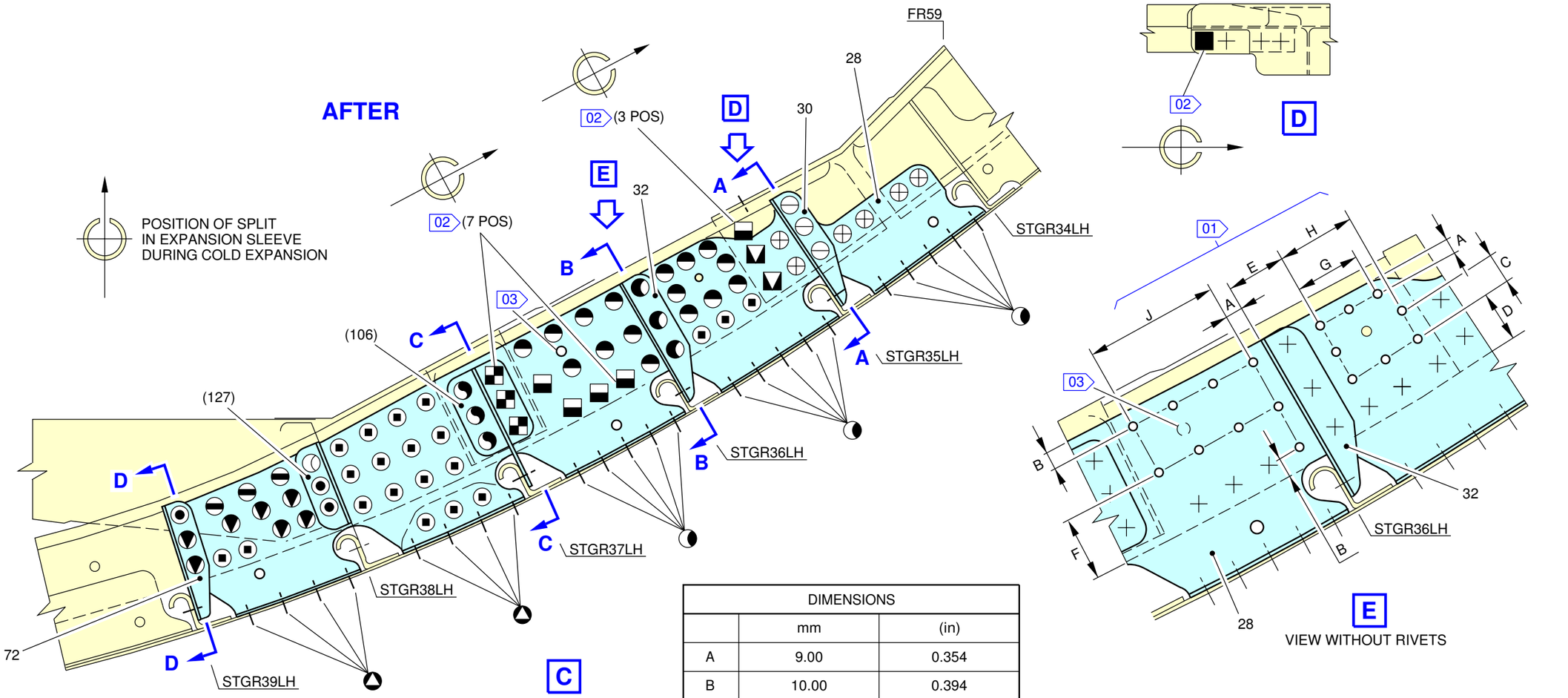
**CONF 004, 006



C
VIEW LOOKING AFT

E
VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	9.00	0.354
B	10.00	0.394
C	16.50	0.650
D	26.00	1.024
E	31.00	1.220
F	33.40	1.315
G	2 x 16.90	2 x 0.665
H	2 x 20.00	2 x 0.787
J	3 x 23.40	3 x 0.921

NOTE:

01 NEW HOLES

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4

N_SB_531364_6_BKAD_02_01

Figure A-GBKAD - Sheet 02
Replacement of Webs and Angles at Frame 59

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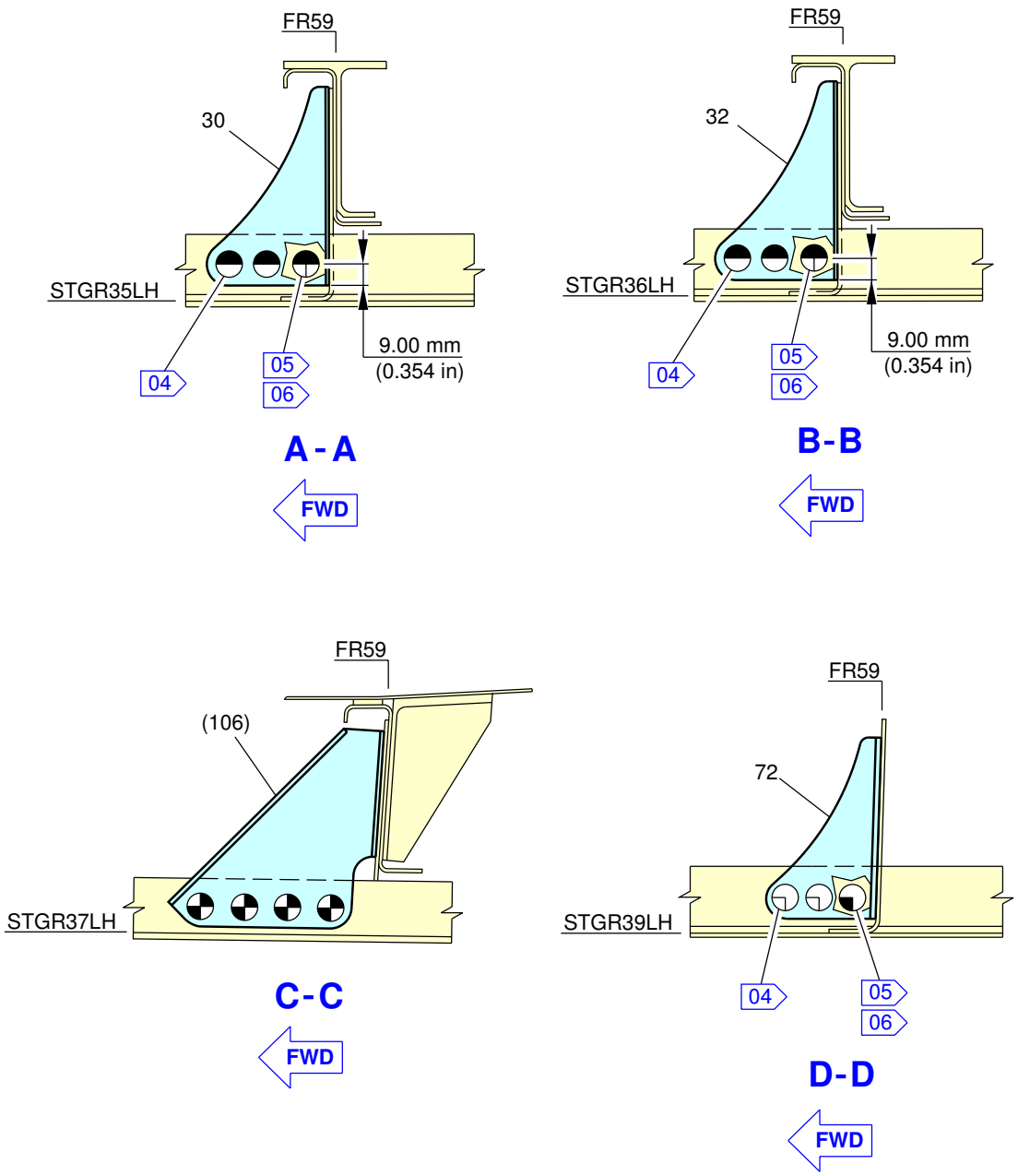
****CONF 004, 006**



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BKAD_03_01

Figure A-GBKAD - Sheet 03
Replacement of Webs and Angles at Frame 59

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**CONF 004, 006

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE

N_SB_531364_6_BKAD_04_01

Figure A-GBKAD - Sheet 04
Replacement of Webs and Angles at Frame 59

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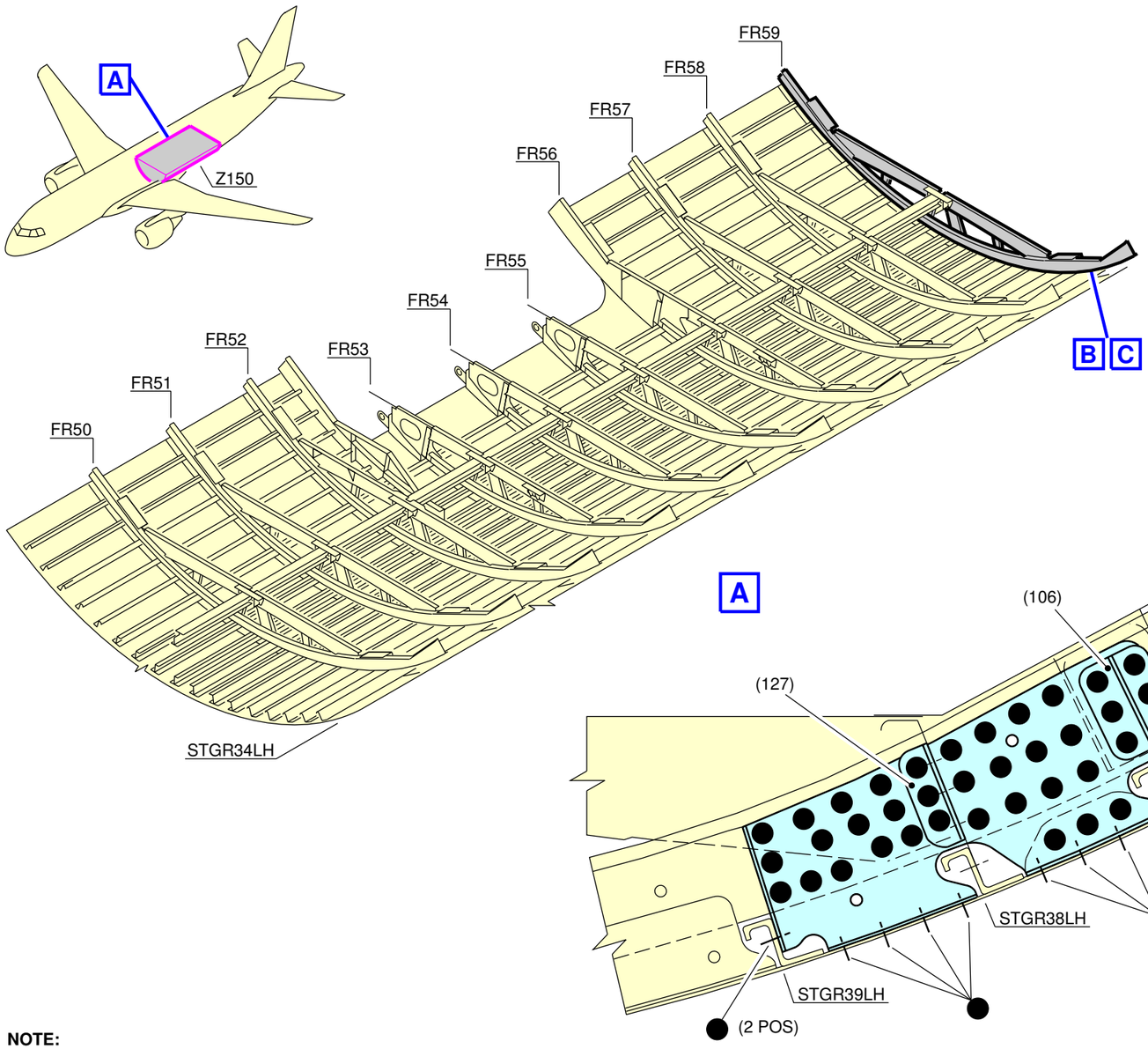
**CONF 005, 007



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BKAE_01_00

Figure A-GBKAE - Sheet 01
Replacement of Webs and Angles at Frame 59

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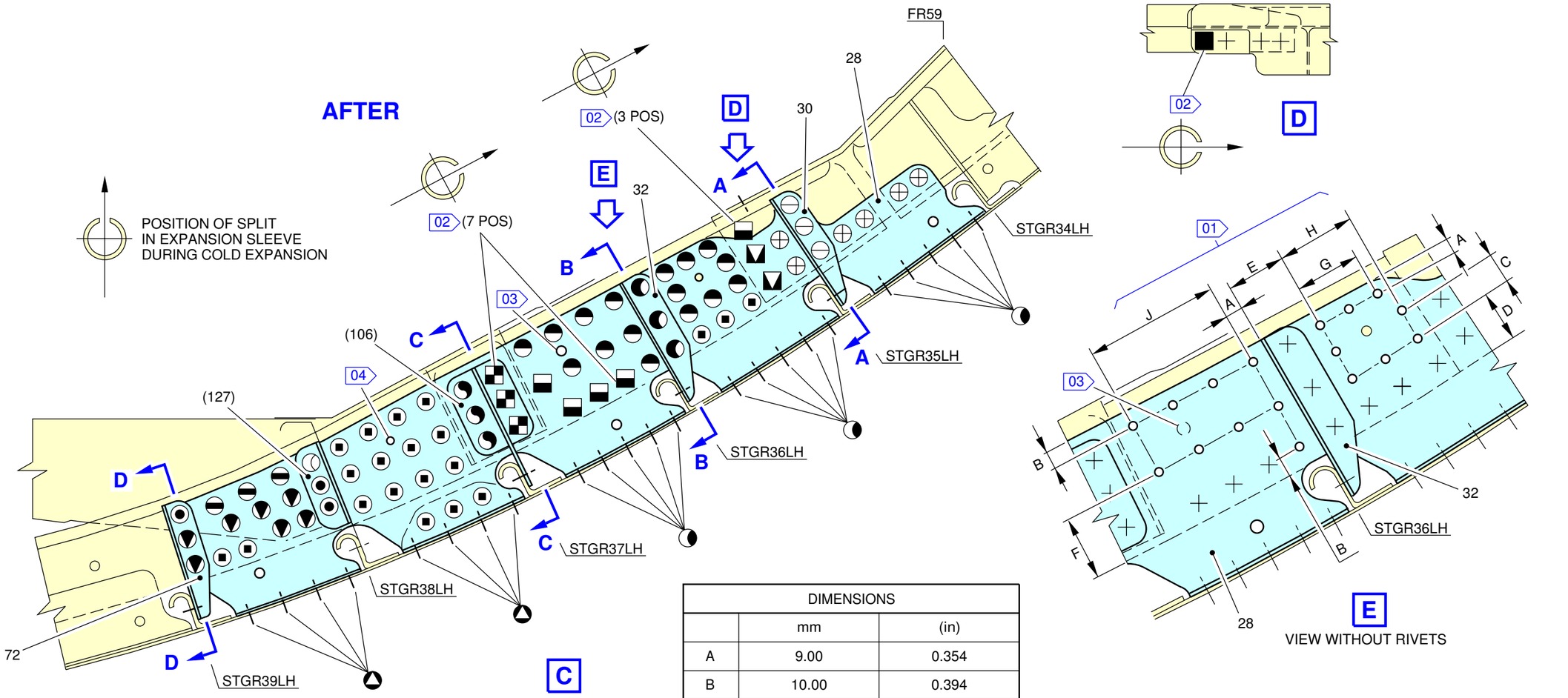
**CONF 005, 007



DIMENSIONS		
	mm	(in)
A	9.00	0.354
B	10.00	0.394
C	16.50	0.650
D	26.00	1.024
E	31.00	1.220
F	33.40	1.315
G	2 x 16.90	2 x 0.665
H	2 x 20.00	2 x 0.787
J	3 x 23.40	3 x 0.921

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in) FOR MSN 3999 AND SUBSEQUENT.

+ EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BKAE_02_01

Figure A-GBKAE - Sheet 02
Replacement of Webs and Angles at Frame 59

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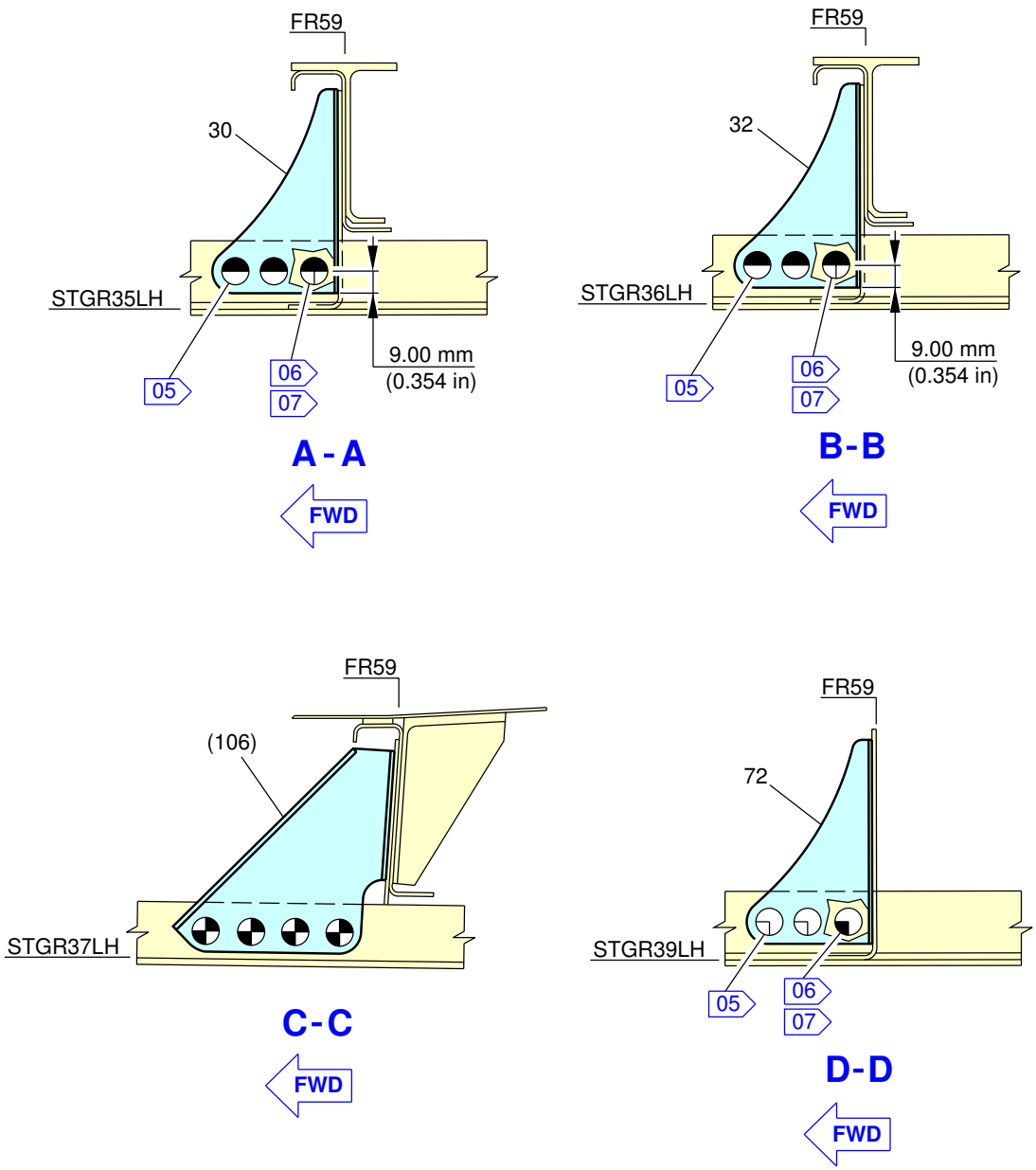
**CONF 005, 007



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BKAE_03_01

Figure A-GBKAE - Sheet 03
Replacement of Webs and Angles at Frame 59

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**CONF 005, 007

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	785	DAN5–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE

N_SB_531364_6_BKAE_04_01

Figure A-GBKAE - Sheet 04
Replacement of Webs and Angles at Frame 59

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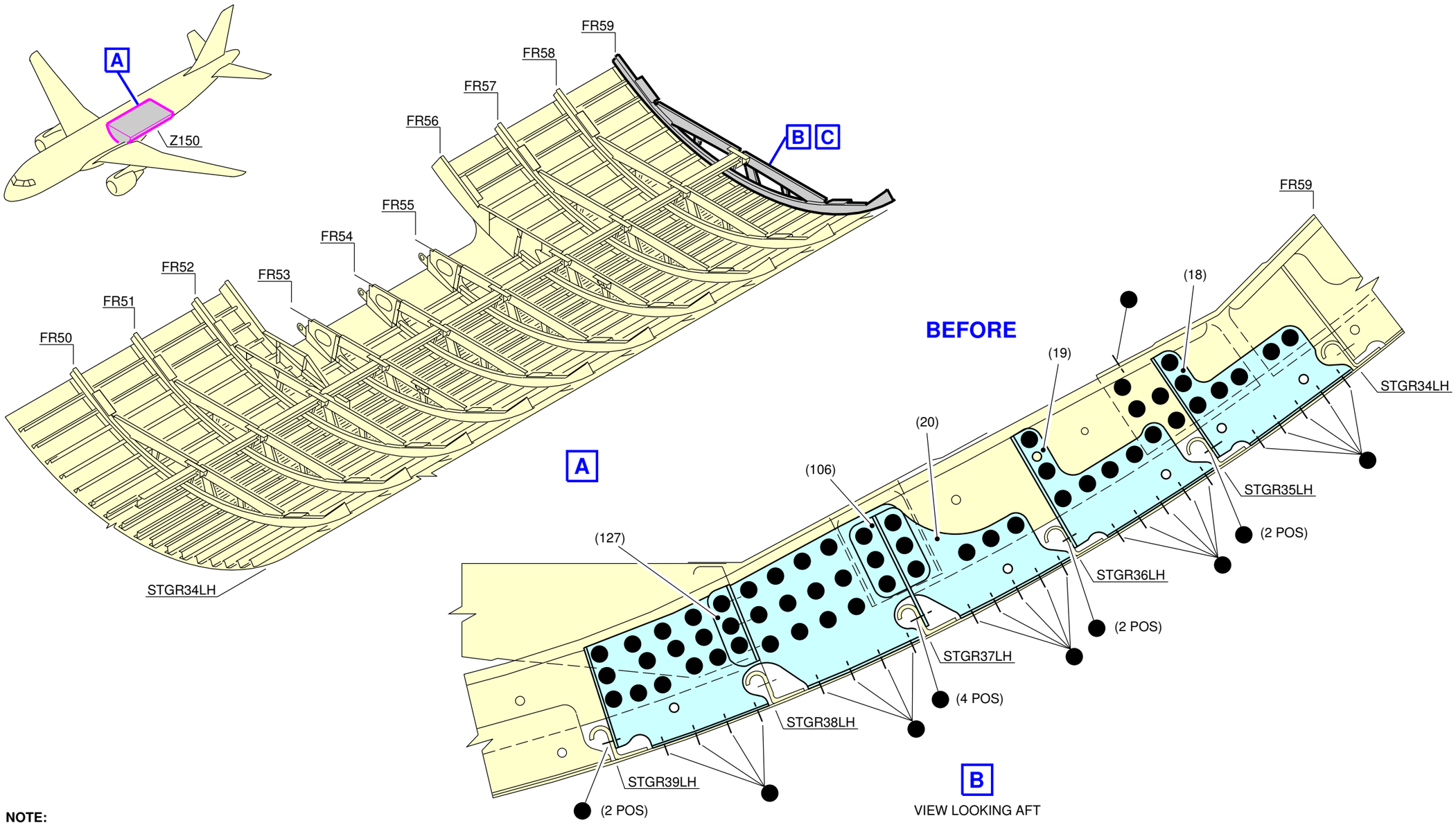
**CONF 008



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BKAH_01_00

Figure A-GBKAH - Sheet 01
Replacement of Webs and Angles at Frame 59

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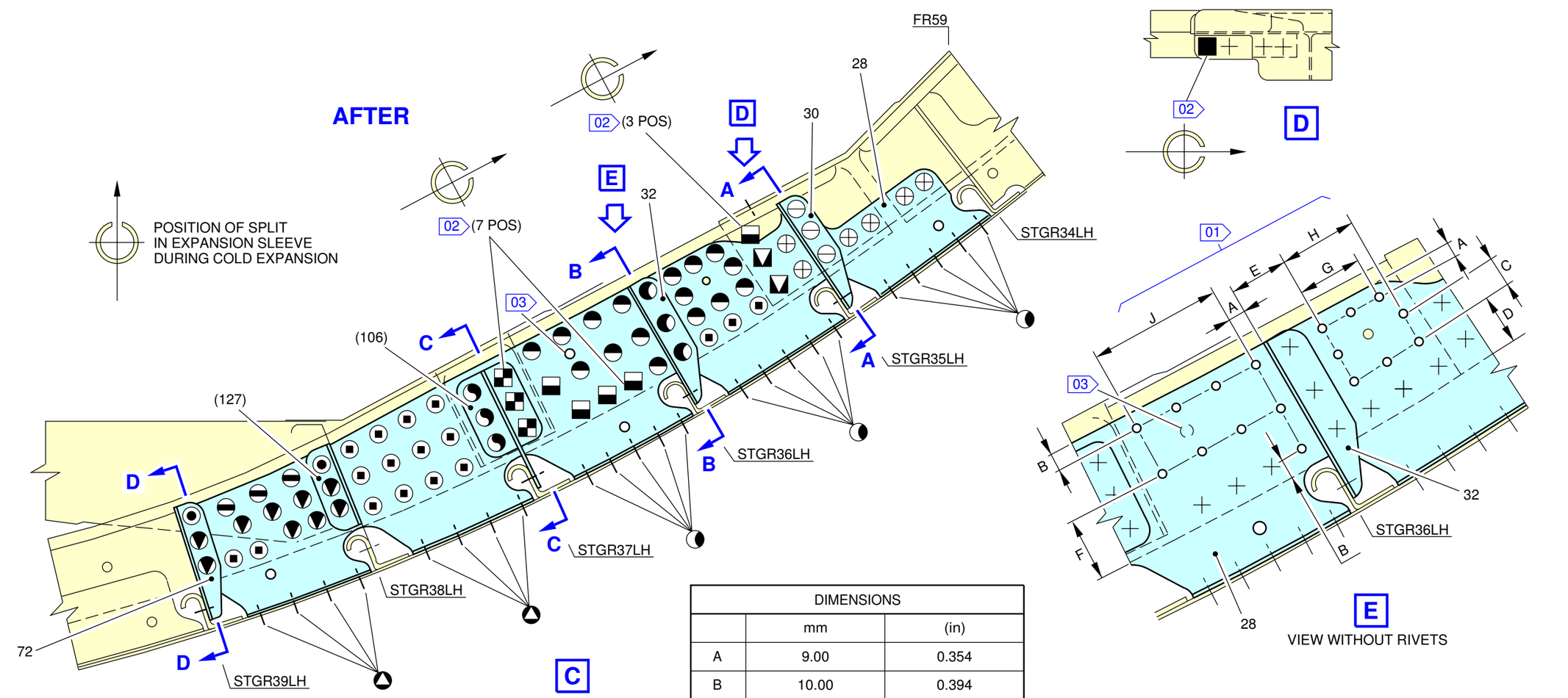
**CONF 008



DIMENSIONS		
	mm	(in)
A	9.00	0.354
B	10.00	0.394
C	16.50	0.650
D	26.00	1.024
E	31.00	1.220
F	33.40	1.315
G	2 x 16.90	2 x 0.665
H	2 x 20.00	2 x 0.787
J	3 x 23.40	3 x 0.921

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BKAH_02_01

Figure A-GBKAH - Sheet 02
Replacement of Webs and Angles at Frame 59

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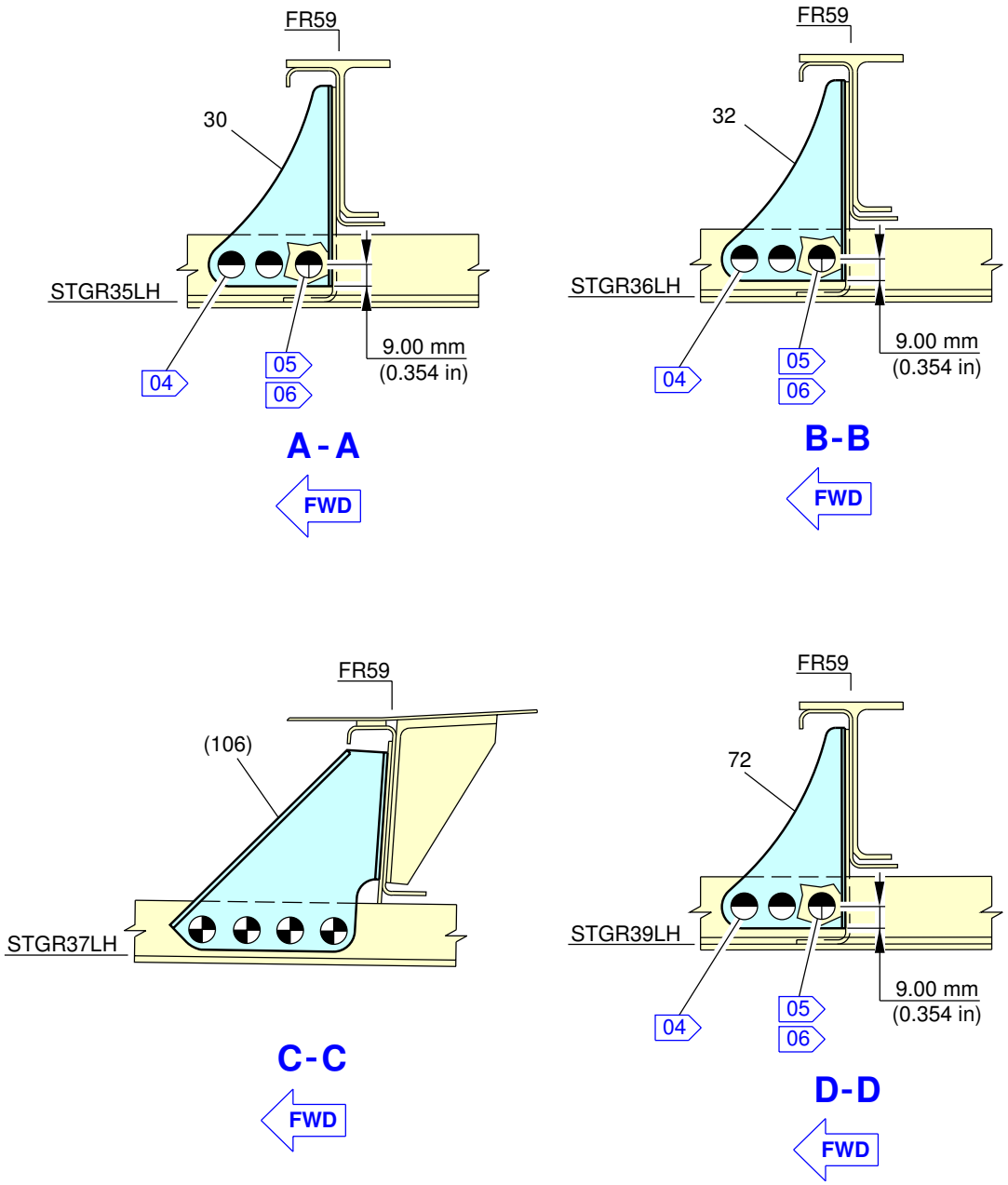
**CONF 008



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BKAH_03_01

Figure A-GBKAH - Sheet 03
Replacement of Webs and Angles at Frame 59

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**CONF 008

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BKAH_04_01

Figure A-GBKAH - Sheet 04
Replacement of Webs and Angles at Frame 59

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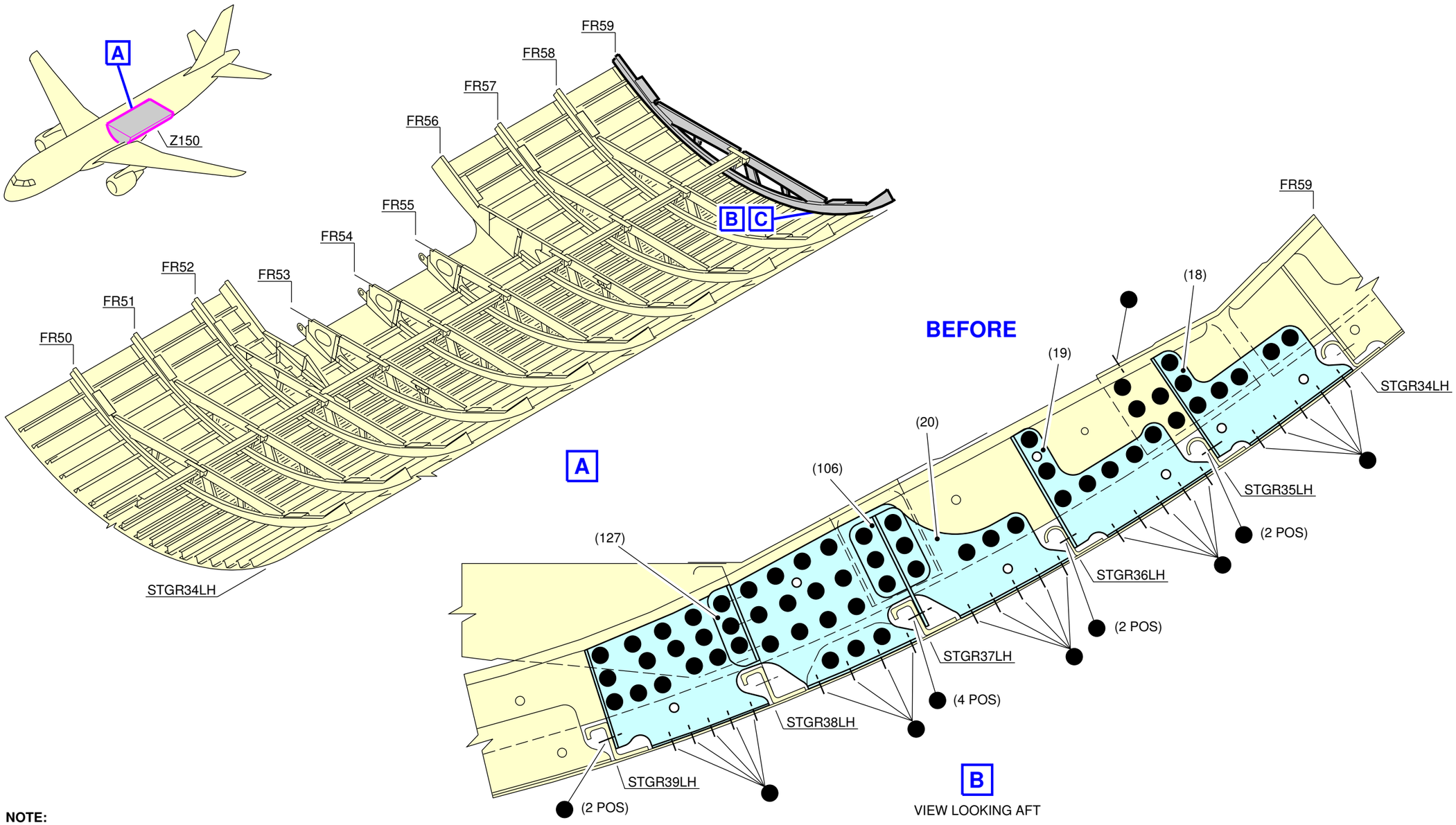
**CONF 009



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BKAJ_01_00

Figure A-GBKAJ - Sheet 01
Replacement of Webs and Angles at Frame 59

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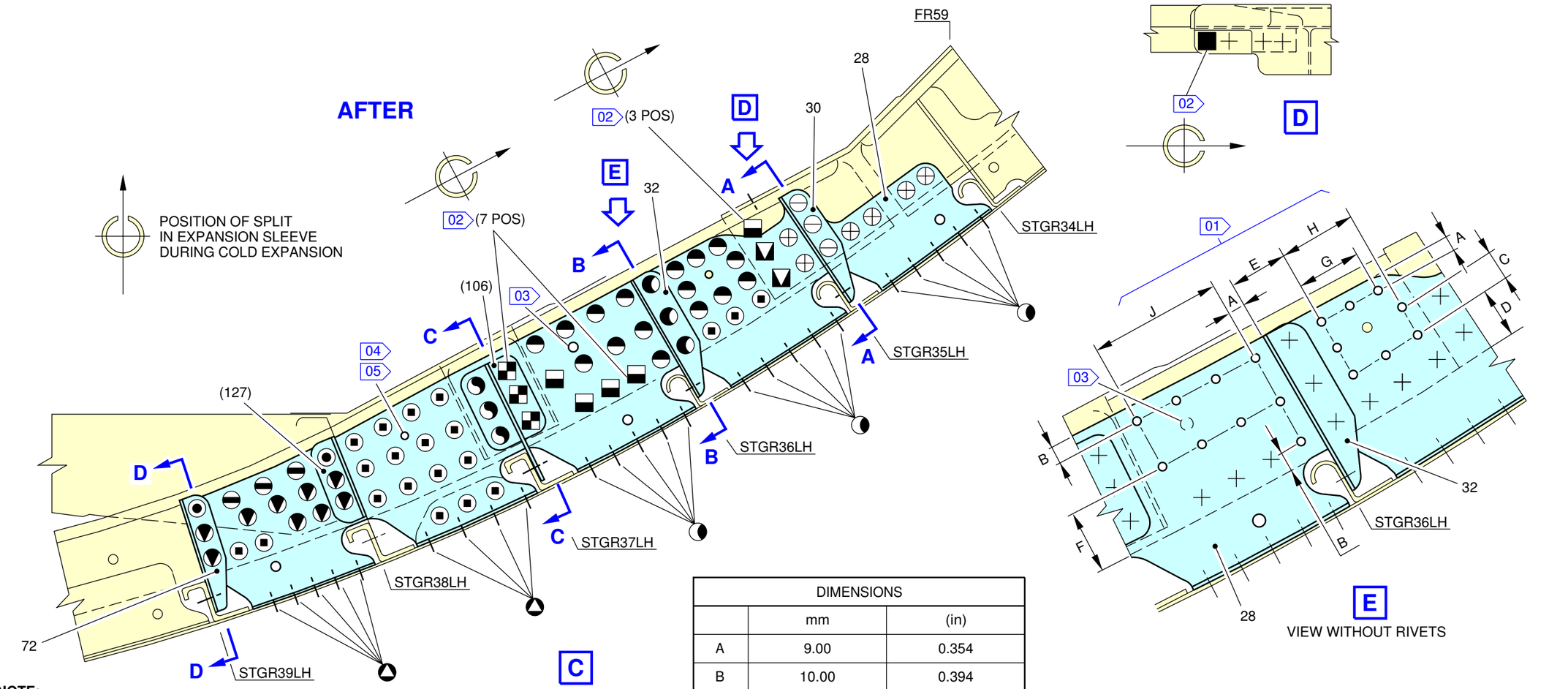
**CONF 009



DIMENSIONS		
	mm	(in)
A	9.00	0.354
B	10.00	0.394
C	16.50	0.650
D	26.00	1.024
E	31.00	1.220
F	33.40	1.315
G	2 x 16.90	2 x 0.665
H	2 x 20.00	2 x 0.787
J	3 x 23.40	3 x 0.921

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in).

05 VALID FOR MSN 4005 AND SUBSEQUENT.

EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BKAJ_02_01

Figure A-GBKAJ - Sheet 02
Replacement of Webs and Angles at Frame 59

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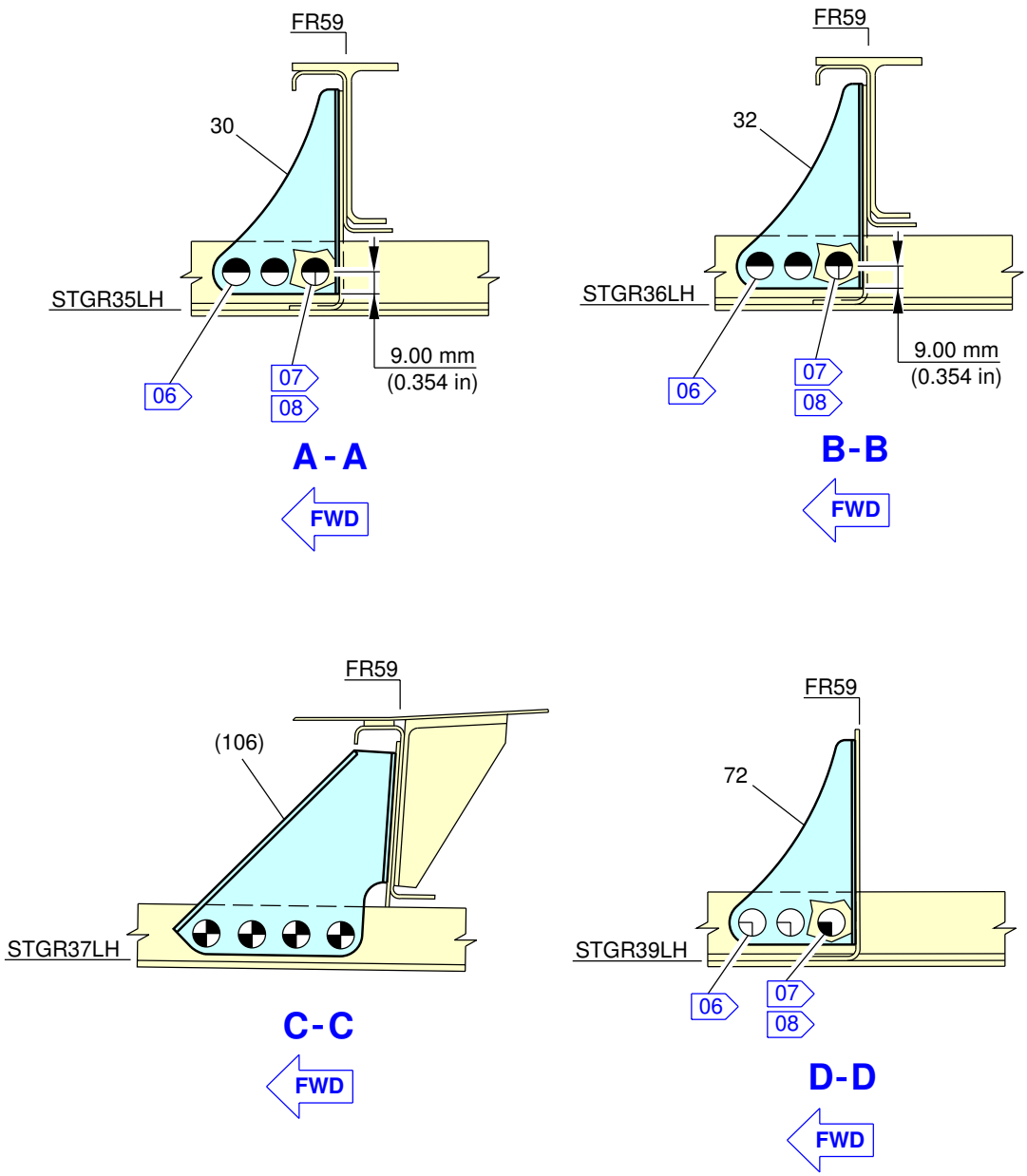
**CONF 009



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BKAJ_03_01

Figure A-GBKAJ - Sheet 03
Replacement of Webs and Angles at Frame 59

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**CONF 009

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	556	EN6069D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BKAJ_04_01

Figure A-GBKAJ - Sheet 04
Replacement of Webs and Angles at Frame 59

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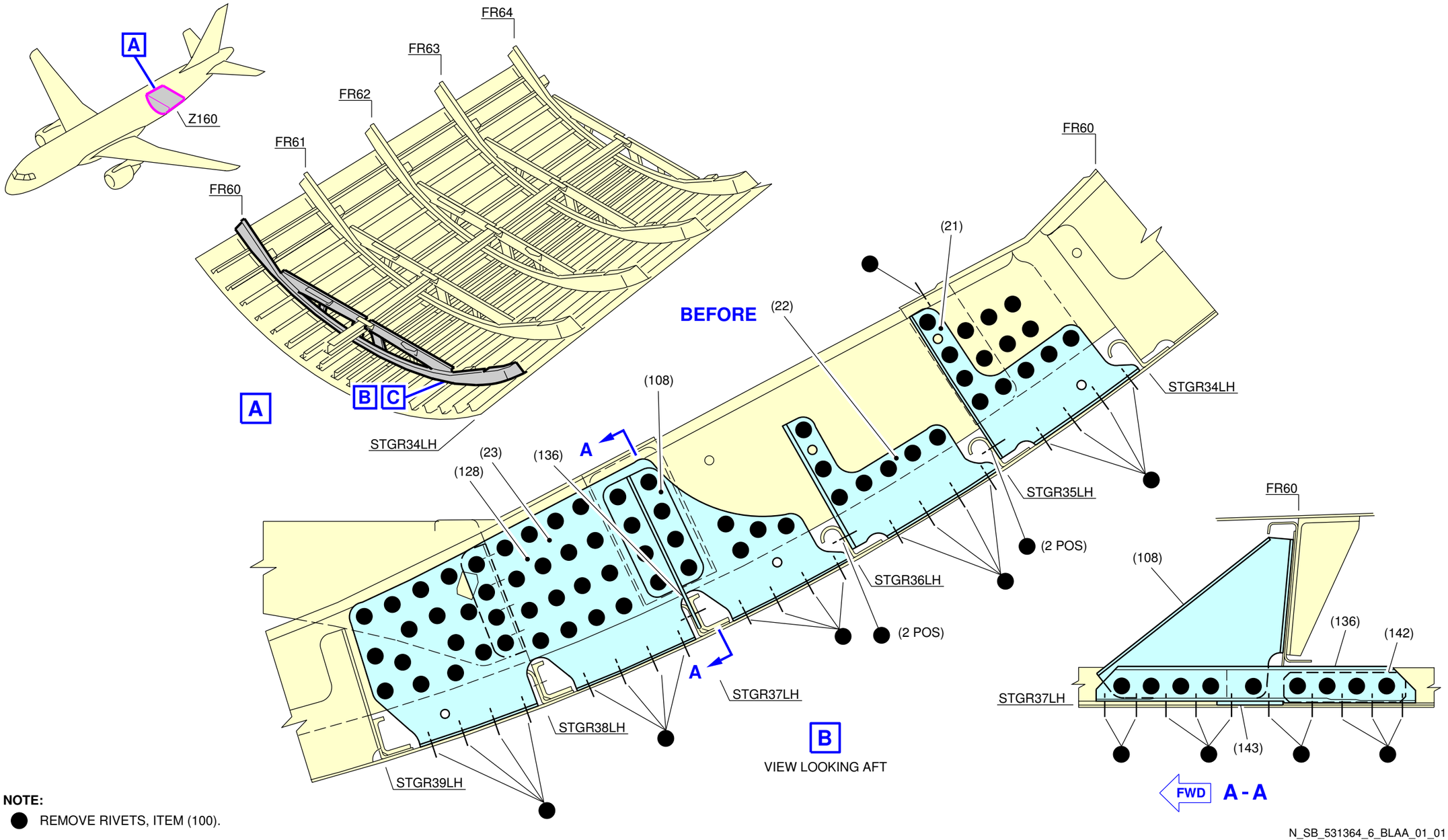
**CONF 001, 008



NOTE:

● REMOVE RIVETS, ITEM (100).

N_SB_531364_6_BLAA_01_01

Figure A-GBLAA - Sheet 01
Replacement of Webs and Angles at Frame 60

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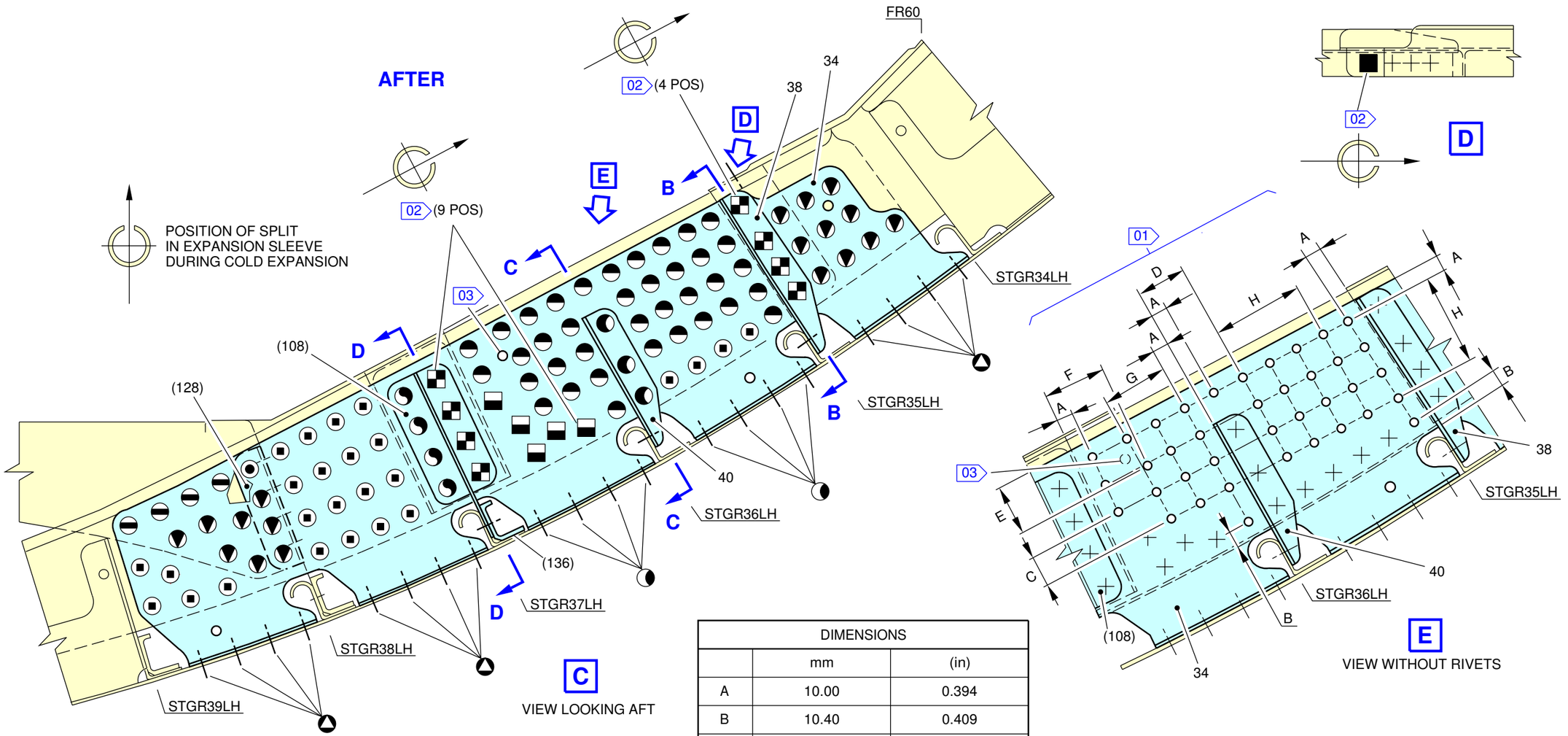
**CONF 001, 008



DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	10.40	0.409
C	18.50	0.728
D	30.00	1.181
E	30.40	1.200
F	38.20	1.504
G	2 x 20.00	2 x 0.787
H	3 x 18.50	3 x 0.728

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BLAA_02_01

Figure A-GBLAA - Sheet 02
Replacement of Webs and Angles at Frame 60

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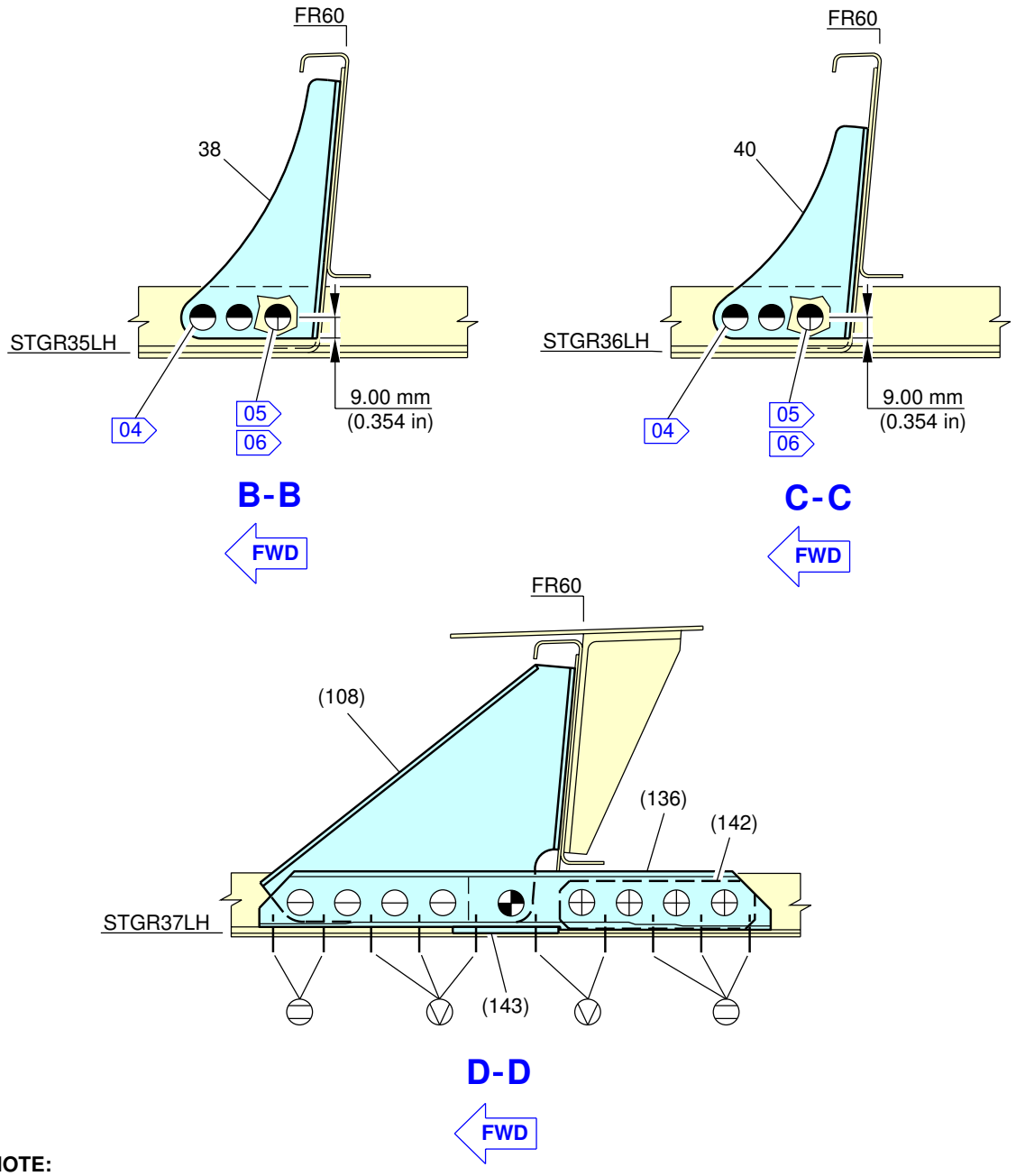
****CONF 001, 008**



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BLAA_03_01

Figure A-GBLAA - Sheet 03
Replacement of Webs and Angles at Frame 60

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**CONF 001, 008

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	864	DAN6–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	865	DAN6–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BLAA_04_01

Figure A-GBLAA - Sheet 04
Replacement of Webs and Angles at Frame 60

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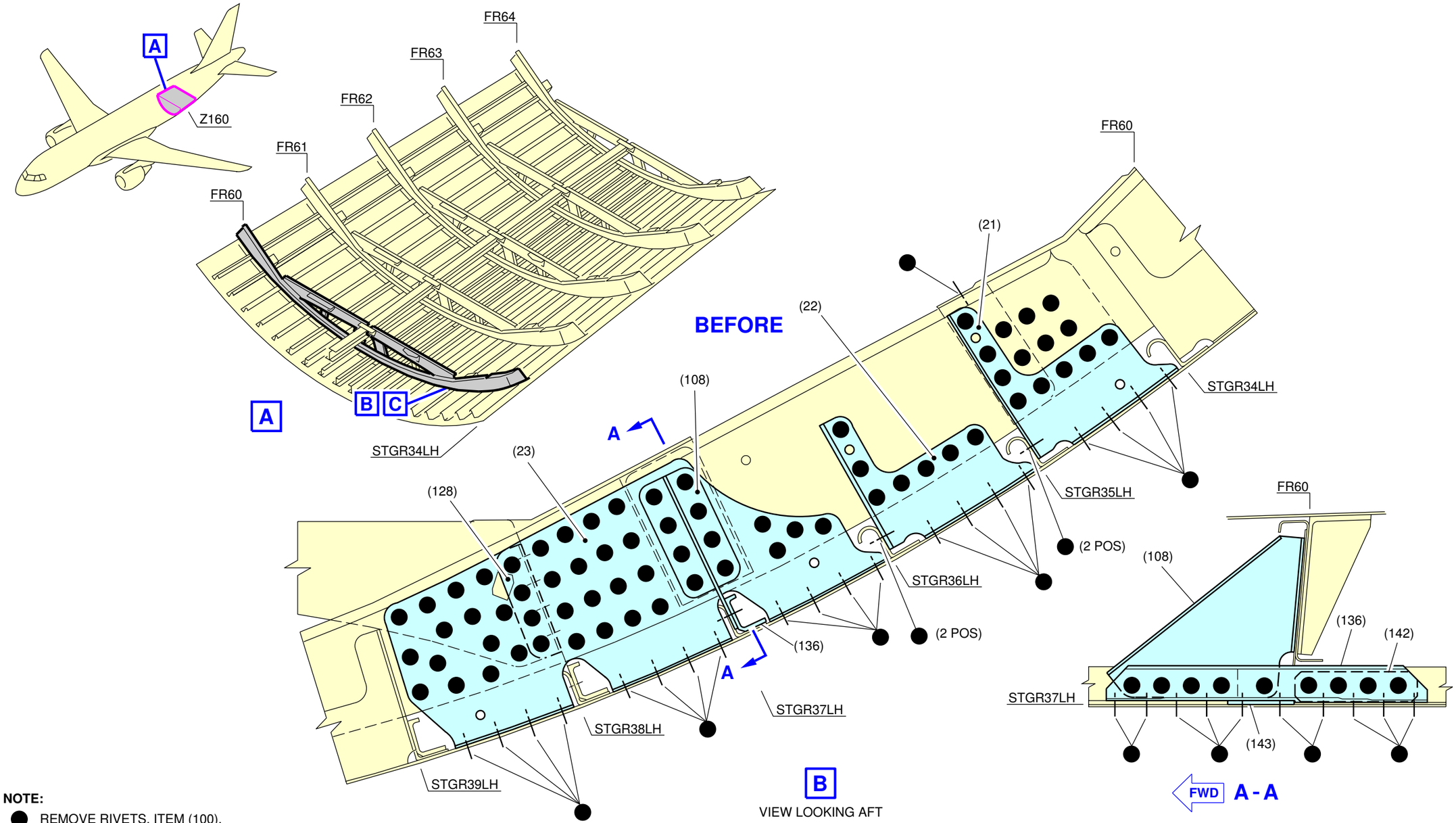
**CONF 002 thru 003



NOTE:

● REMOVE RIVETS, ITEM (100).

N_SB_531364_6_BLAB_01_01

Figure A-GBLAB - Sheet 01
Replacement of Webs and Angles at Frame 60

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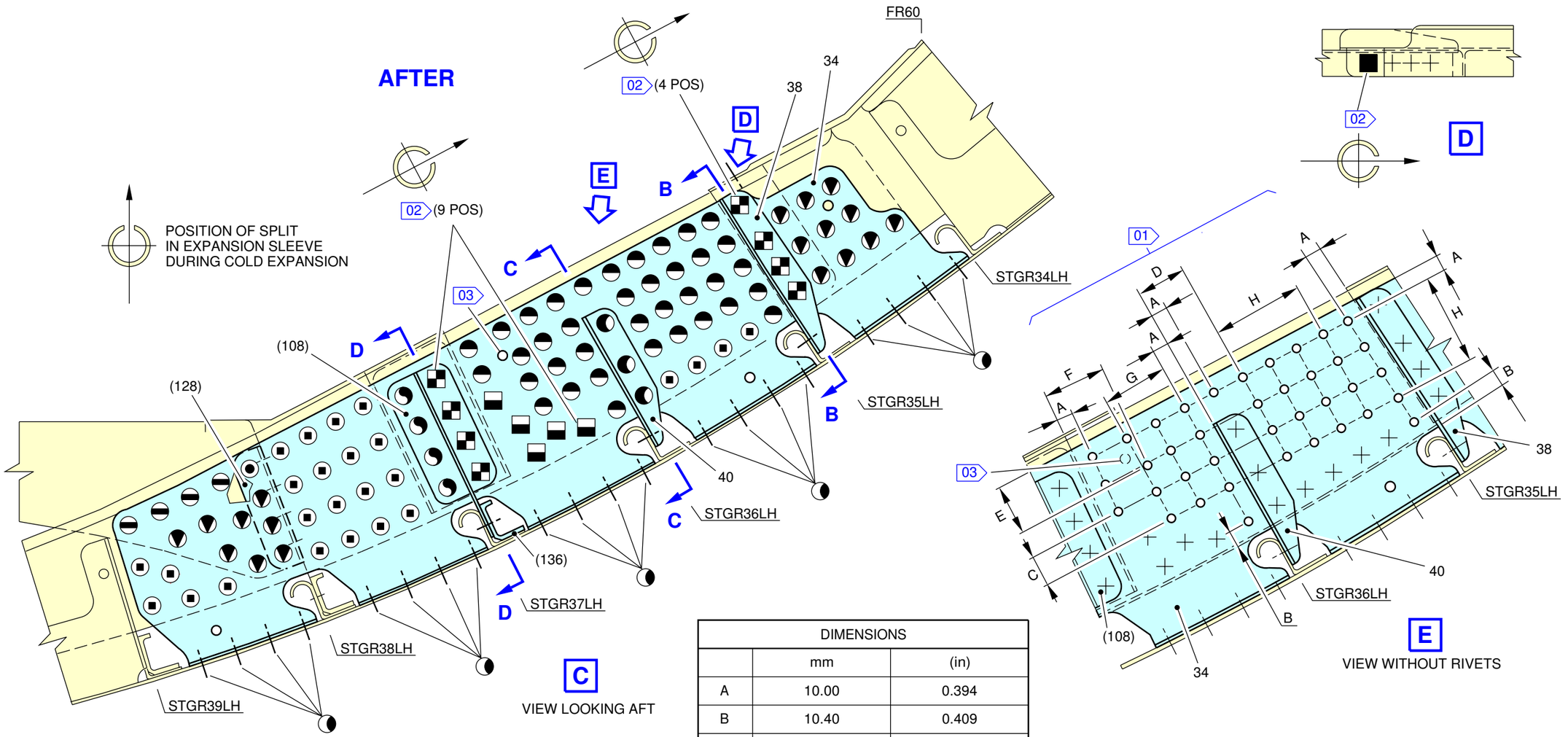
**CONF 002 thru 003



DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	10.40	0.409
C	18.50	0.728
D	30.00	1.181
E	30.40	1.200
F	38.20	1.504
G	2 x 20.00	2 x 0.787
H	3 x 18.50	3 x 0.728

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BLAB_02_01

Figure A-GBLAB - Sheet 02
Replacement of Webs and Angles at Frame 60

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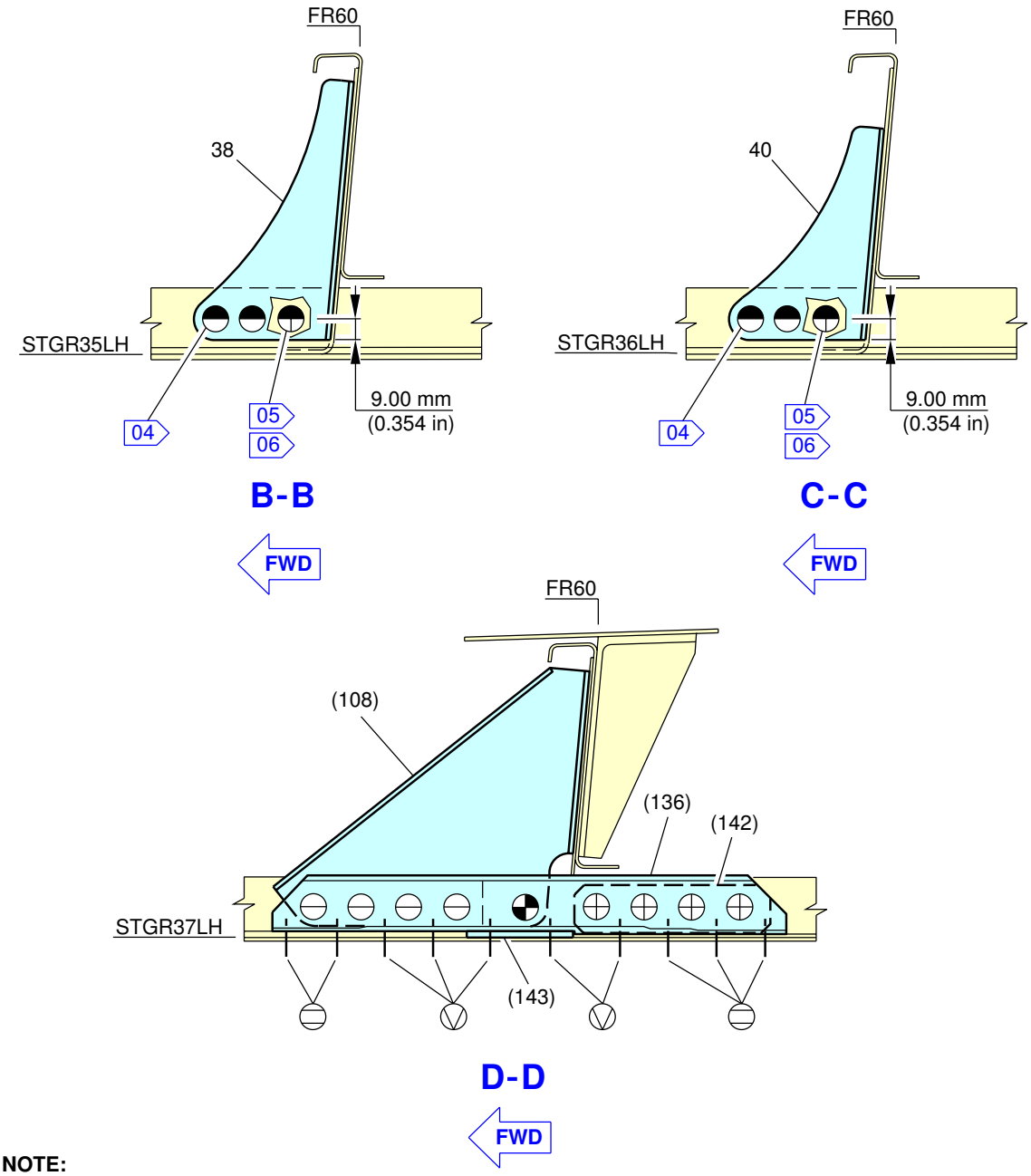
****CONF 002 thru 003**



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BLAB_03_01

Figure A-GBLAB - Sheet 03
Replacement of Webs and Angles at Frame 60

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**CONF 002 thru 003

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	864	DAN6–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	865	DAN6–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BLAB_04_01

Figure A-GBLAB - Sheet 04
Replacement of Webs and Angles at Frame 60

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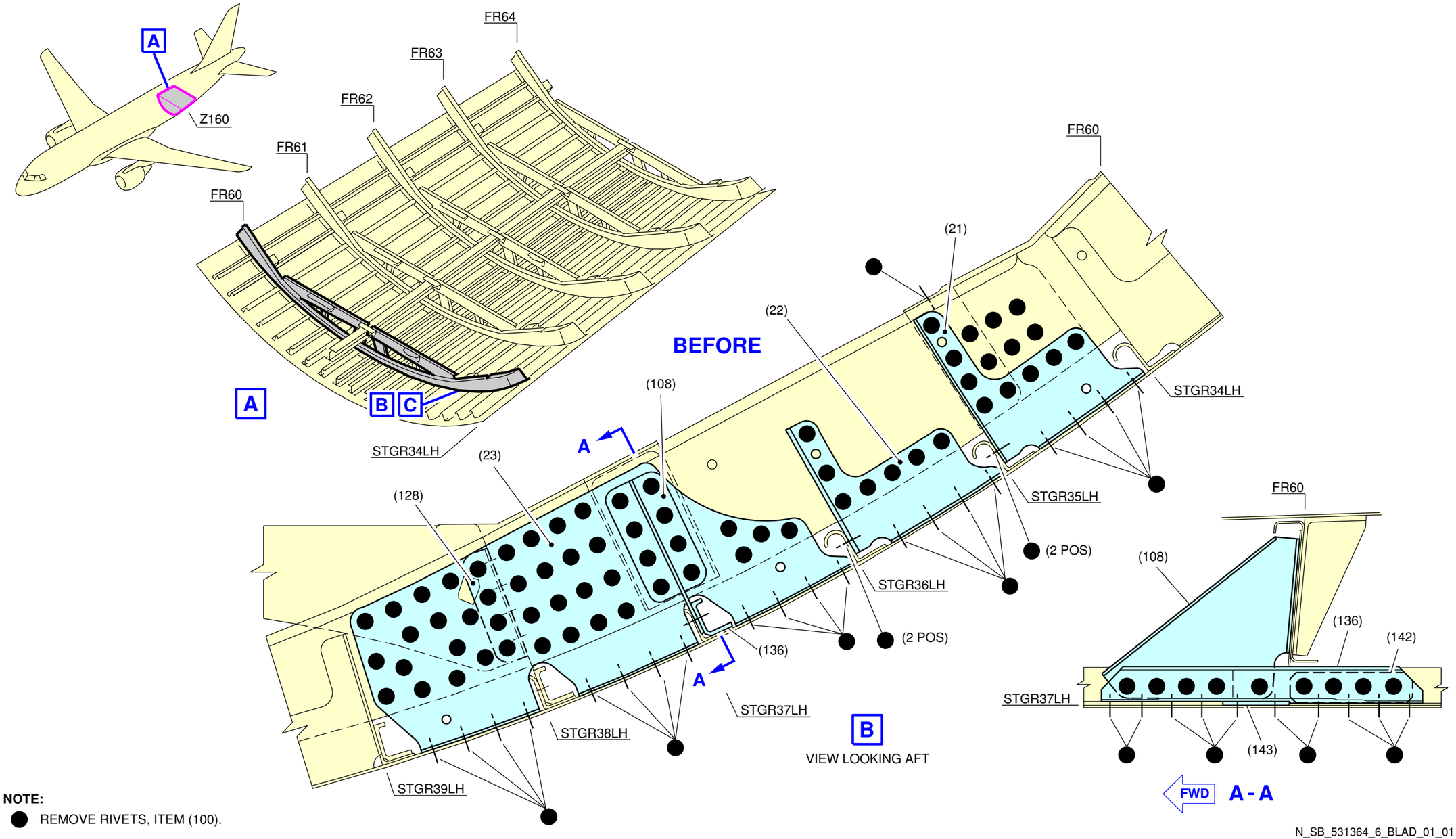
**CONF 004, 006



NOTE:

● REMOVE RIVETS, ITEM (100).

N_SB_531364_6_BLAD_01_01

Figure A-GBLAD - Sheet 01
Replacement of Webs and Angles at Frame 60

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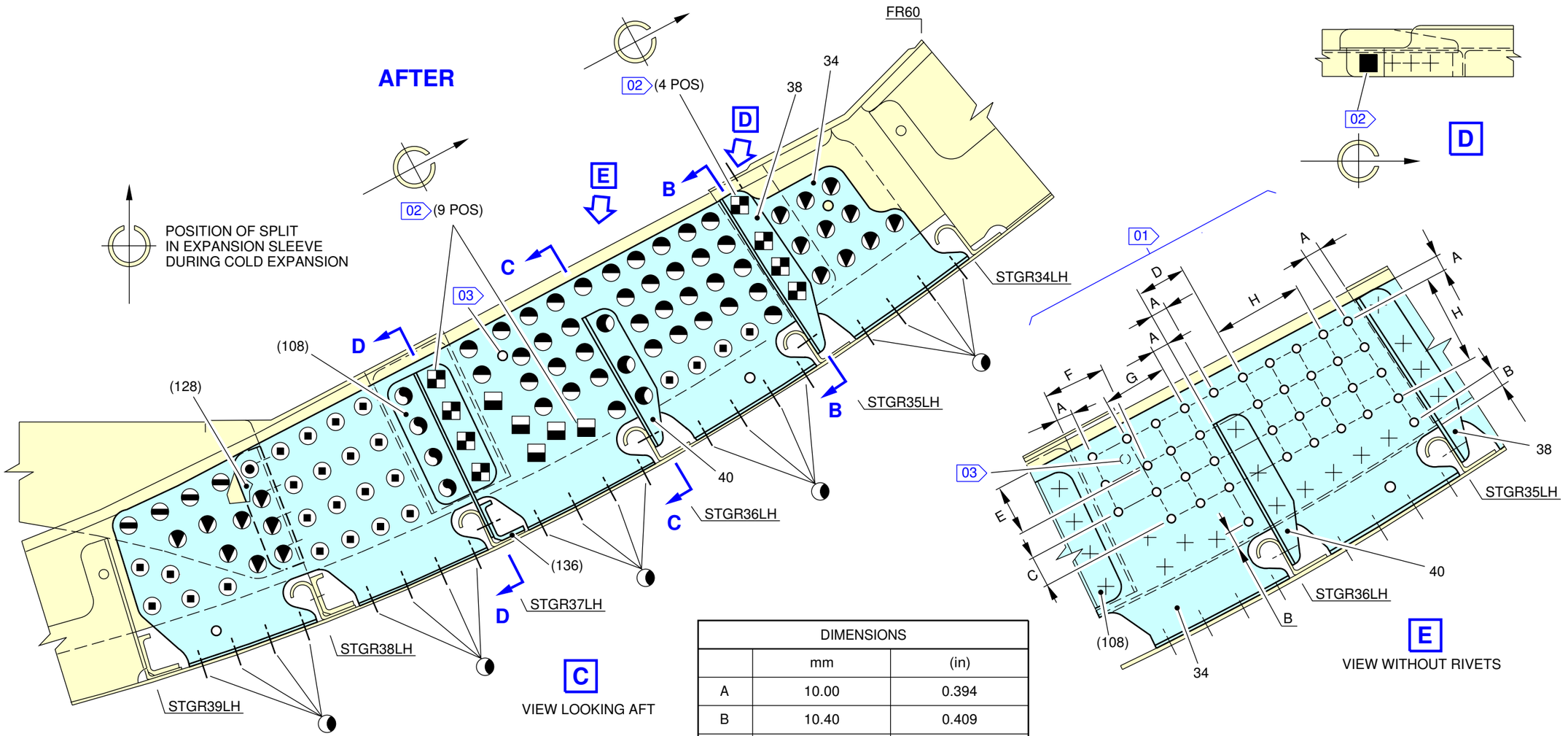
**CONF 004, 006



DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	10.40	0.409
C	18.50	0.728
D	30.00	1.181
E	30.40	1.200
F	38.20	1.504
G	2 x 20.00	2 x 0.787
H	3 x 18.50	3 x 0.728

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BLAD_02_01

Figure A-GBLAD - Sheet 02
Replacement of Webs and Angles at Frame 60

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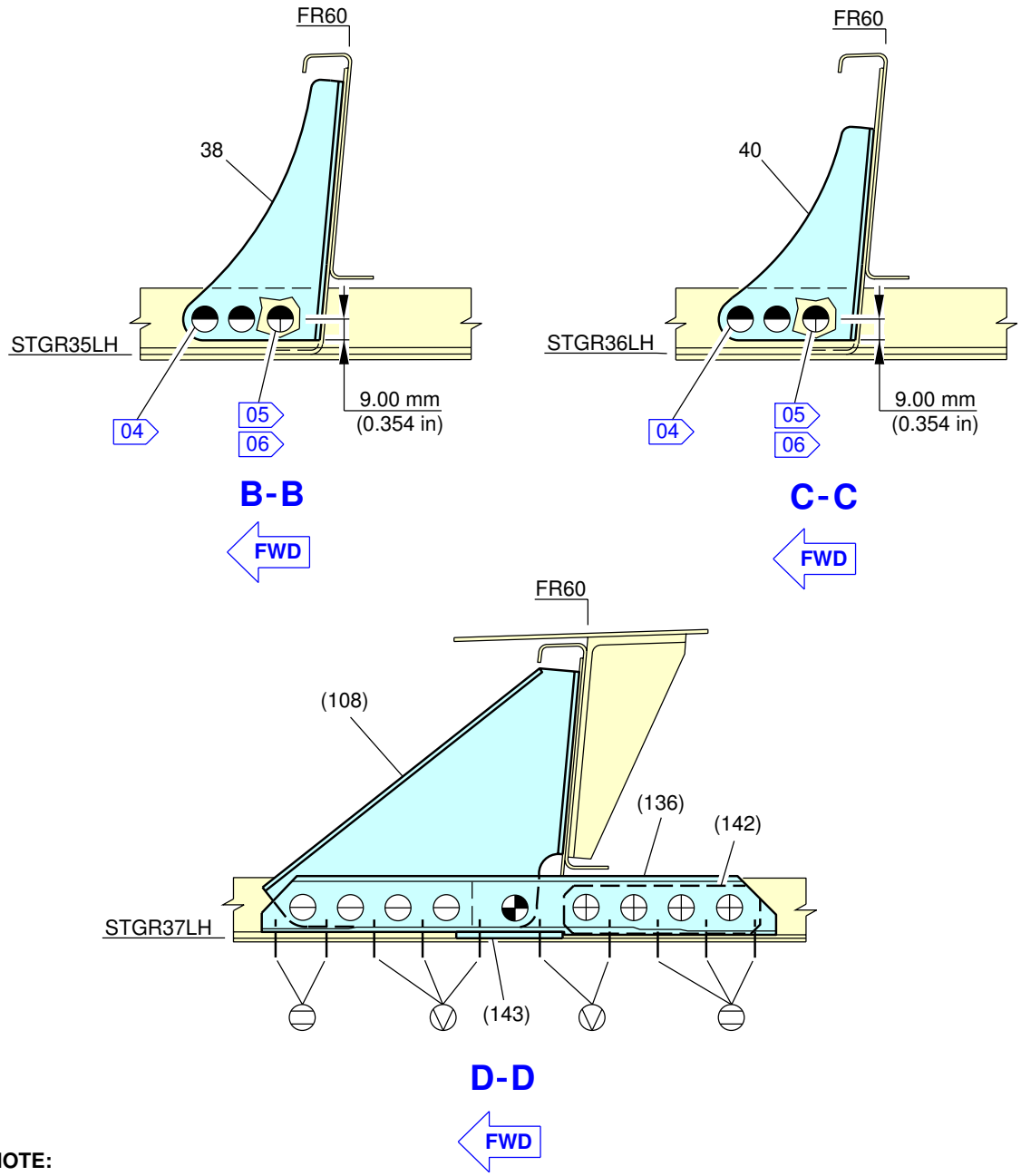
****CONF 004, 006**



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BLAD_03_01

Figure A-GBLAD - Sheet 03
Replacement of Webs and Angles at Frame 60

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**CONF 004, 006

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	864	DAN6–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	865	DAN6–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BLAD_04_01

Figure A-GBLAD - Sheet 04
Replacement of Webs and Angles at Frame 60

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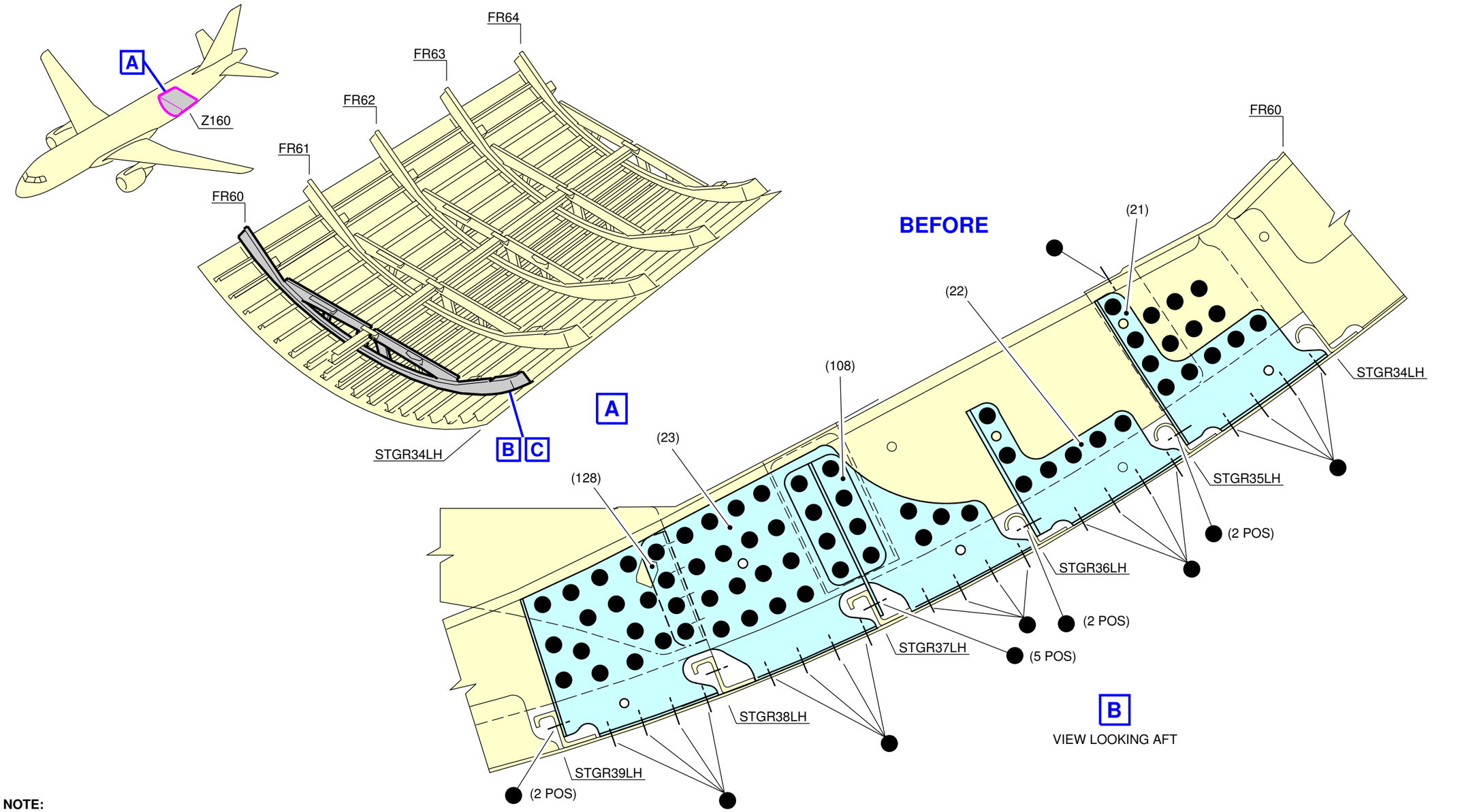
**CONF 005, 007



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BLAE_01_00

Figure A-GBLAE - Sheet 01
Replacement of Webs and Angles at Frame 60

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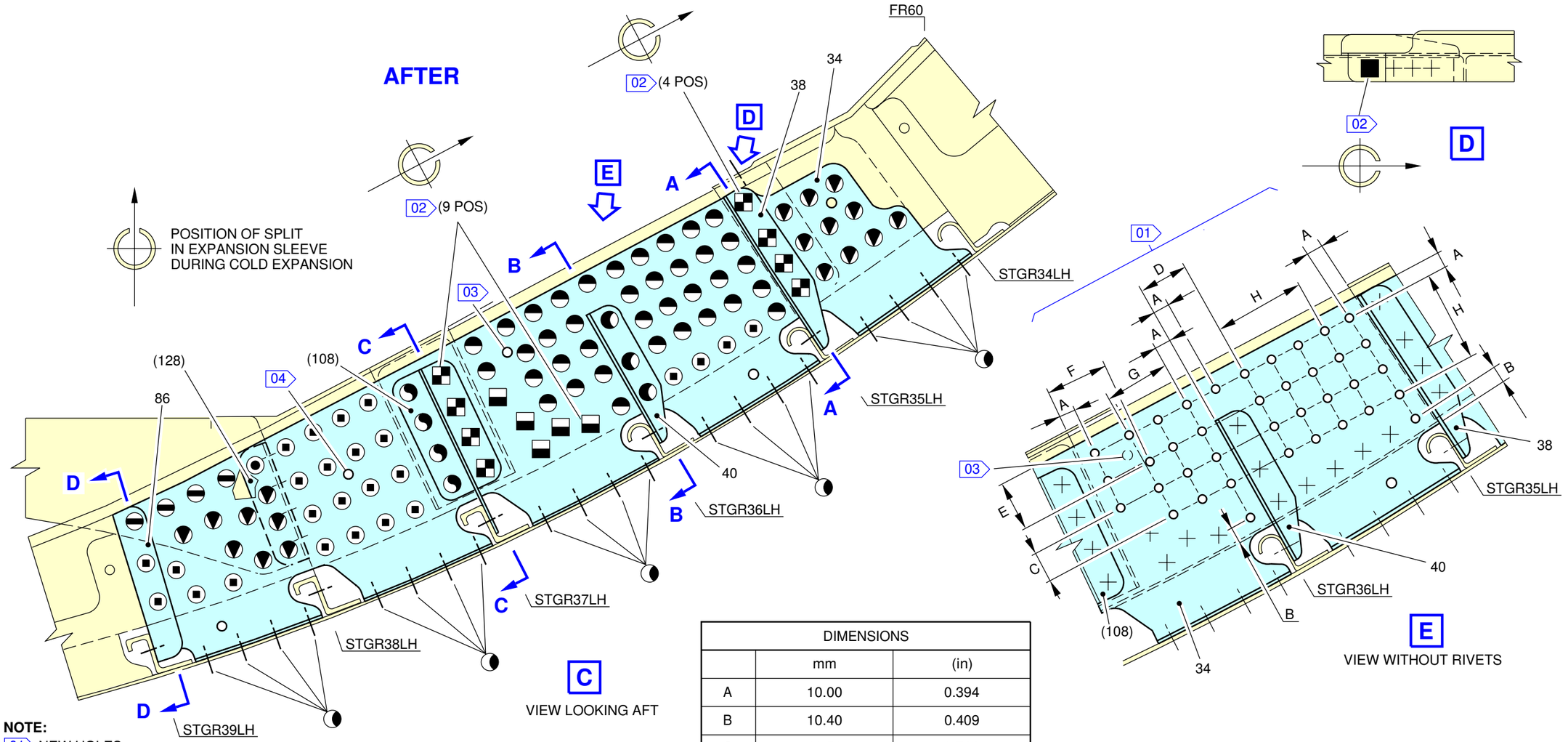
**CONF 005, 007



DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	10.40	0.409
C	18.50	0.728
D	30.00	1.181
E	30.40	1.200
F	38.20	1.504
G	2 x 20.00	2 x 0.787
H	3 x 18.50	3 x 0.728

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in) FOR MSN 3999 AND SUBSEQUENT.

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BLAE_02_01

Figure A-GBLAE - Sheet 02
Replacement of Webs and Angles at Frame 60

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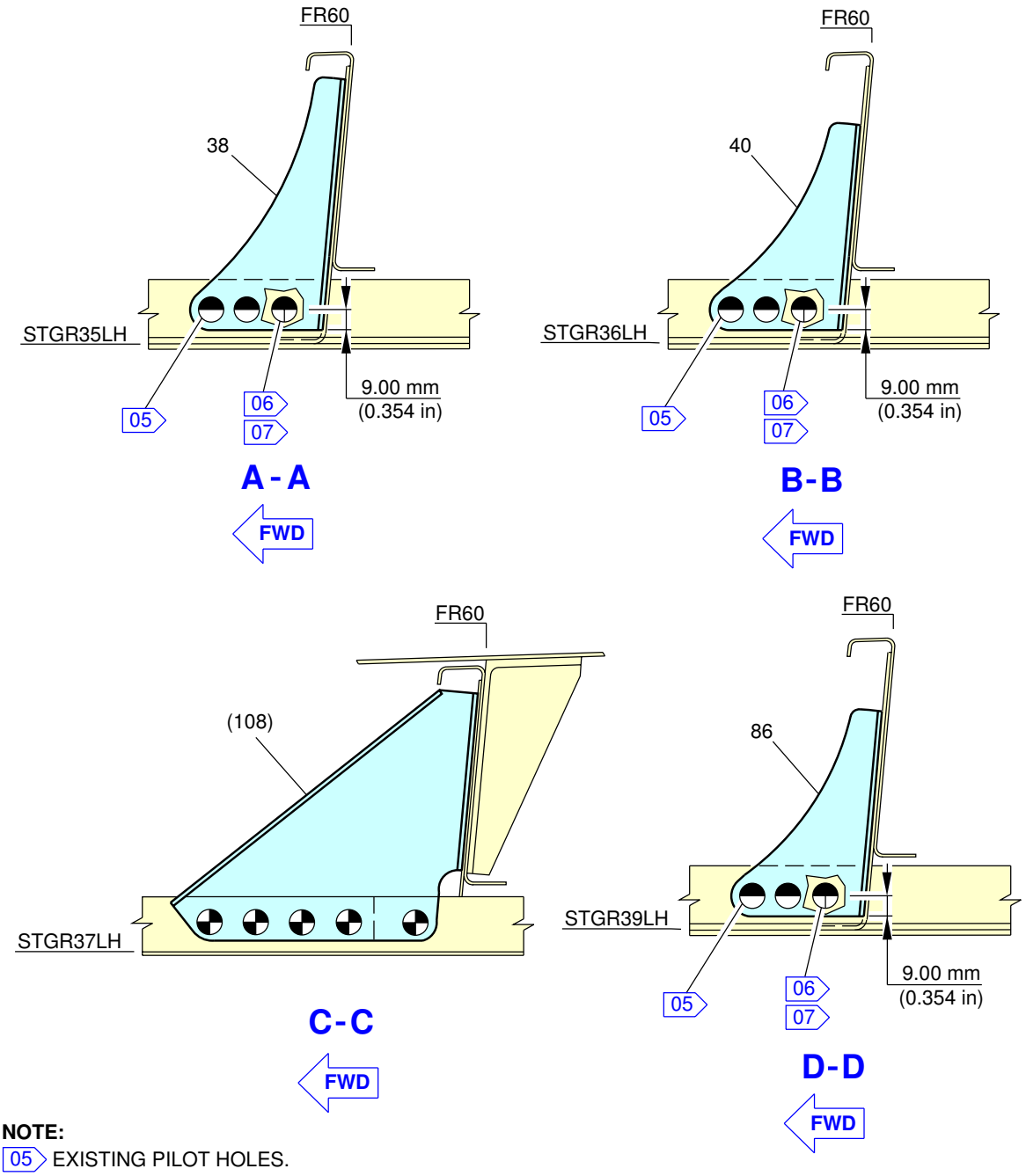
****CONF 005, 007**



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BLAE_03_01

Figure A-GBLAE - Sheet 03
Replacement of Webs and Angles at Frame 60

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**CONF 005, 007

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
◒	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
◪	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
■	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
◓	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◑	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◓	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◉	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◑	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◡	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◔	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
◒	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
◉	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
◒	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BLAE_04_01

Figure A-GBLAE - Sheet 04
Replacement of Webs and Angles at Frame 60

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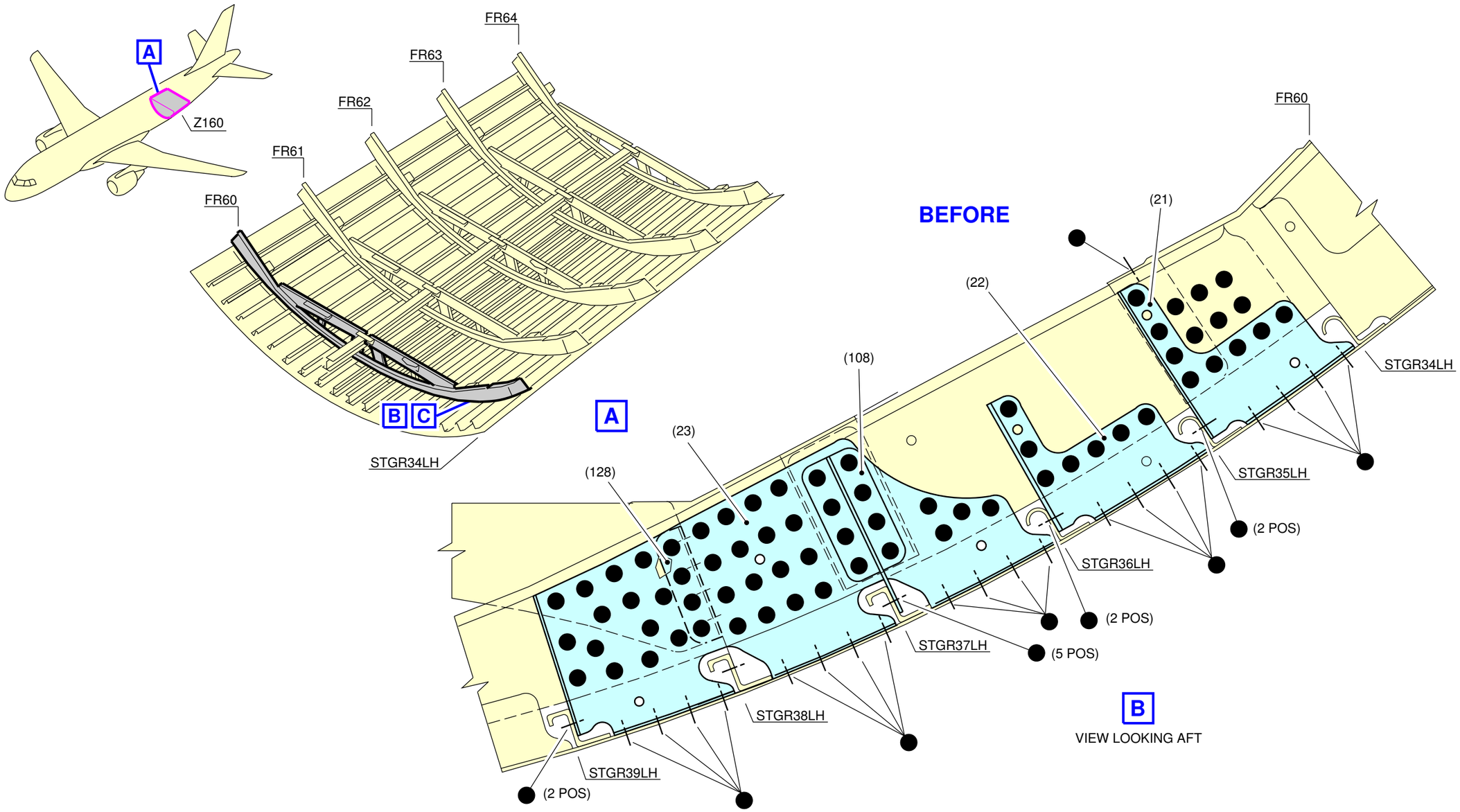
**CONF 009



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BLAJ_01_00

Figure A-GBLAJ - Sheet 01
Replacement of Webs and Angles at Frame 60

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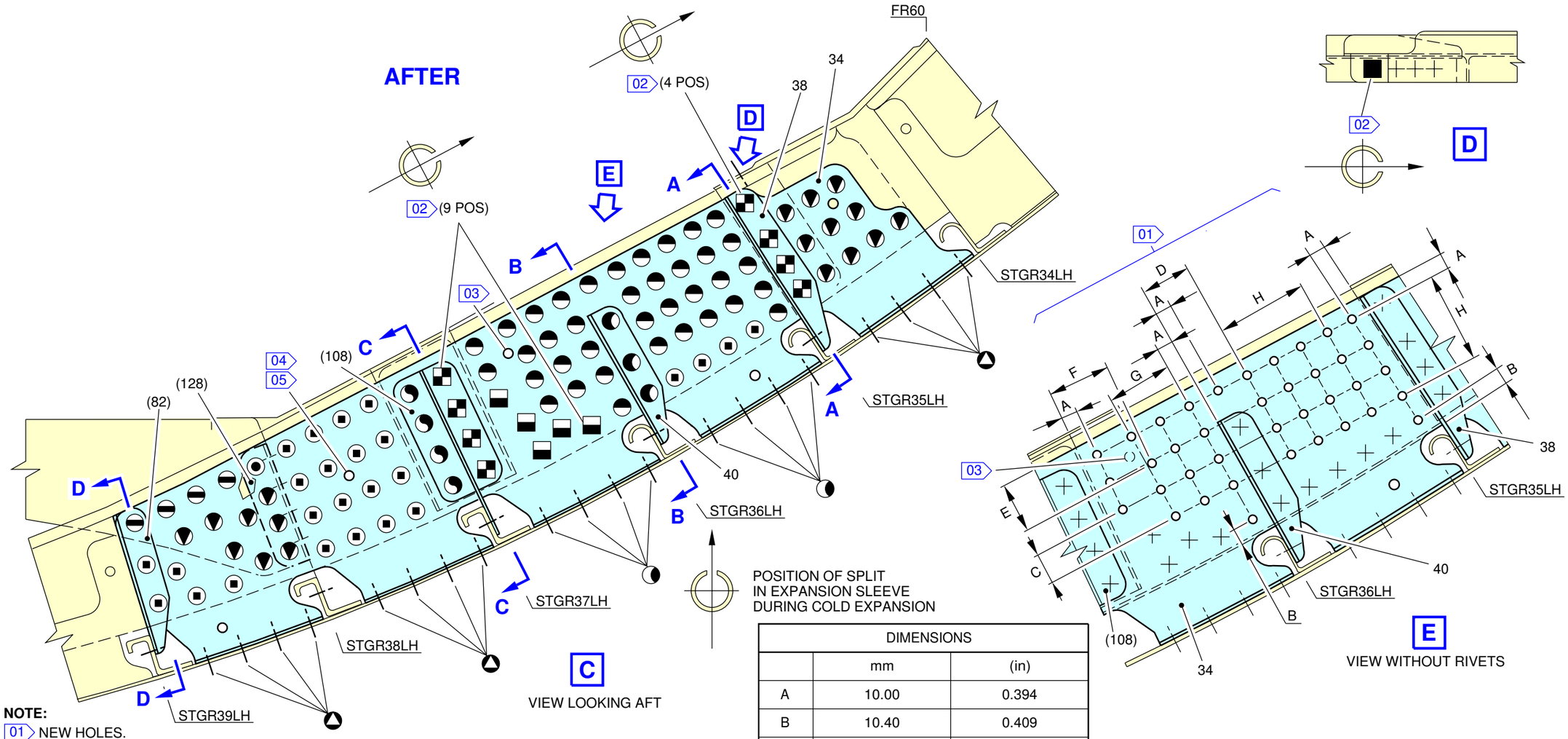
**CONF 009



DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	10.40	0.409
C	18.50	0.728
D	30.00	1.181
E	30.40	1.200
F	38.20	1.504
G	2 x 20.00	2 x 0.787
H	3 x 18.50	3 x 0.728

NOTE:

01 NEW HOLES.

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in).

05 VALID FOR MSN 4005 AND SUBSEQUENT.

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BLAJ_02_01

Figure A-GBLAJ - Sheet 02
Replacement of Webs and Angles at Frame 60

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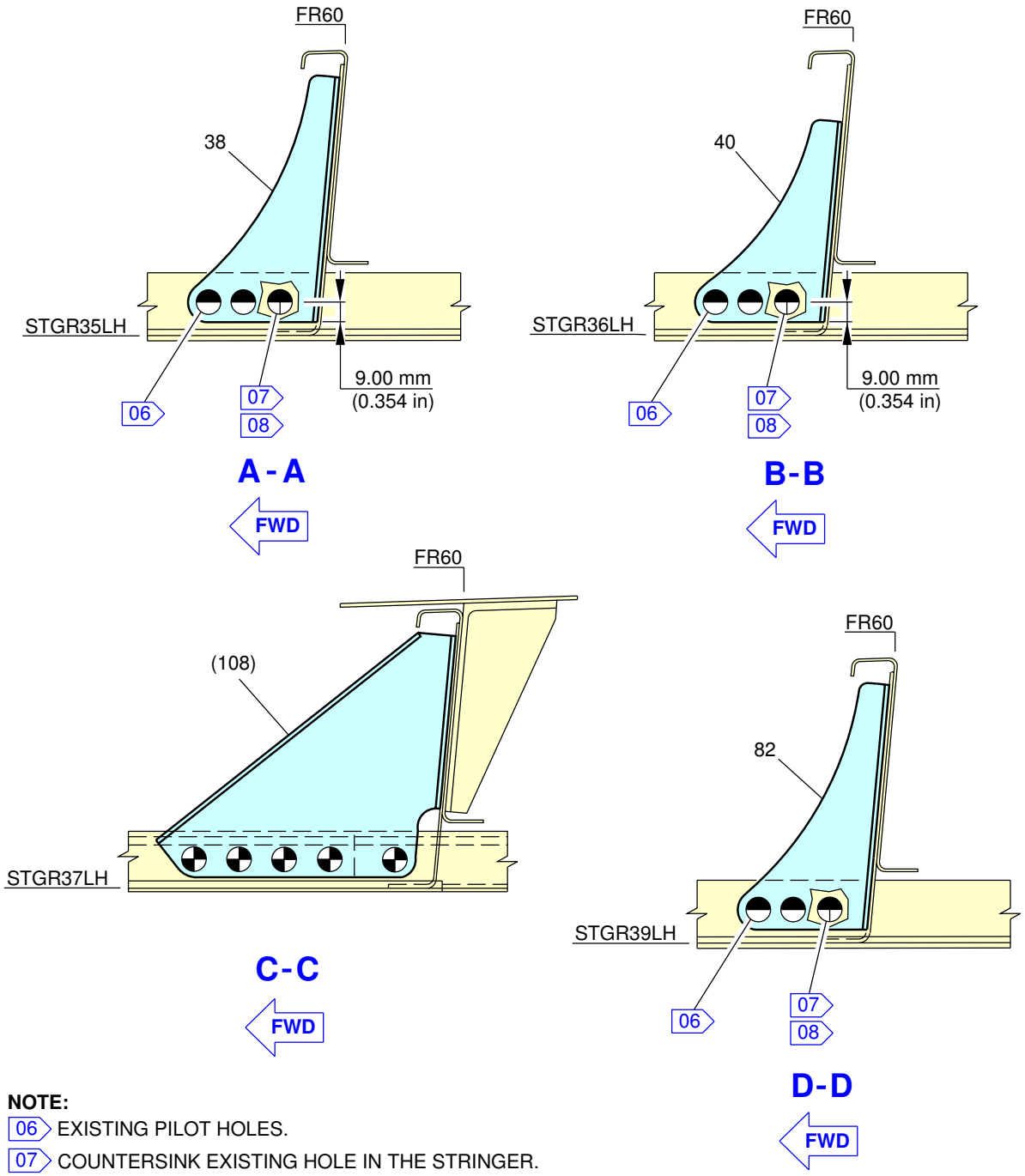
**CONF 009



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BLAJ_03_01

Figure A-GBLAJ - Sheet 03
Replacement of Webs and Angles at Frame 60

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**CONF 009

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BLAJ_04_01

Figure A-GBLAJ - Sheet 04
Replacement of Webs and Angles at Frame 60

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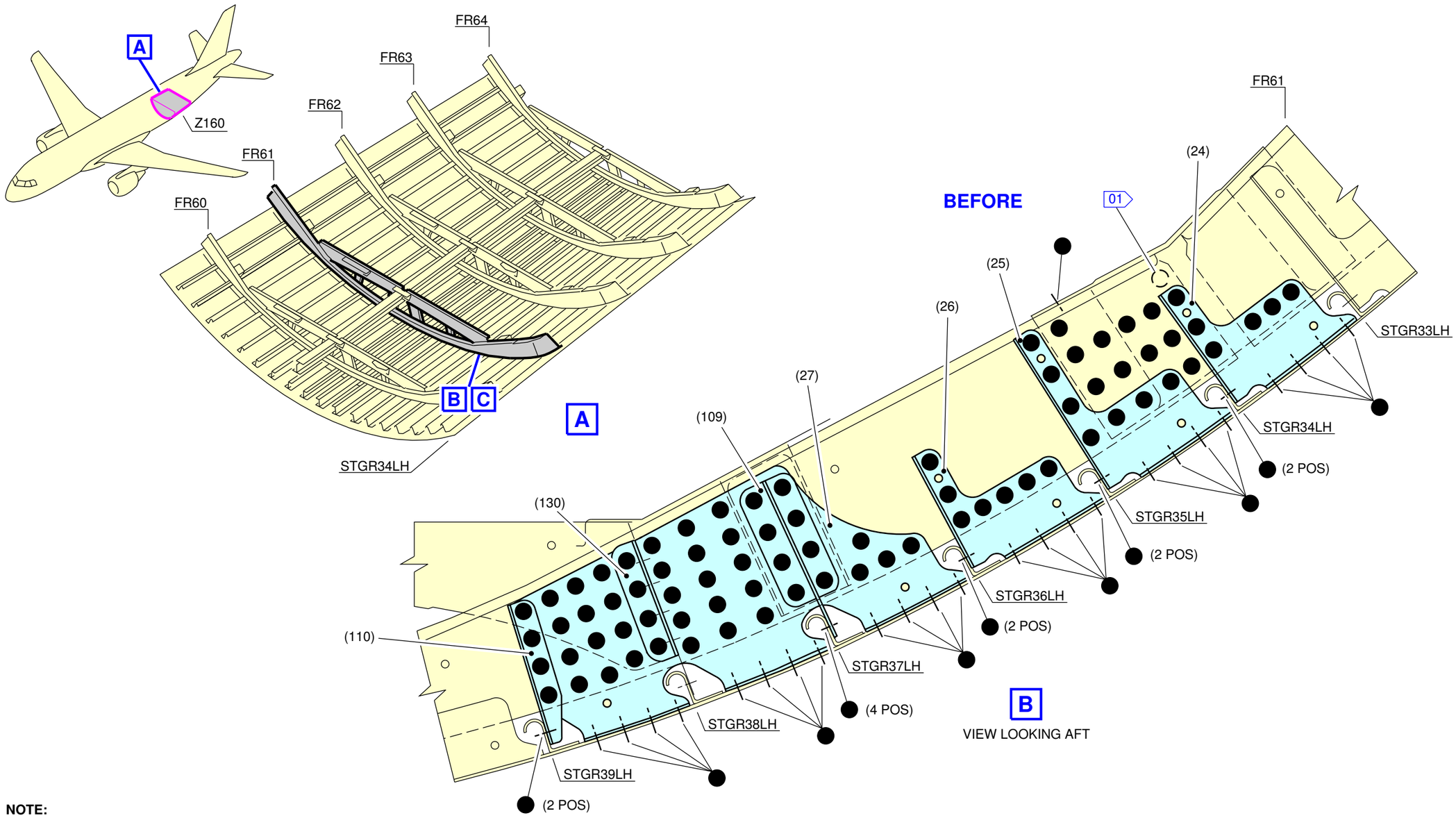
**CONF 001



NOTE:

● REMOVE RIVETS, ITEM (100)

01 ◌ REMOVE RIVET IF INSTALLED, ITEM (100)

N_SB_531364_6_BMAA_01_00

Figure A-GBMAA - Sheet 01
Replacement of Webs and Angles at Frame 61

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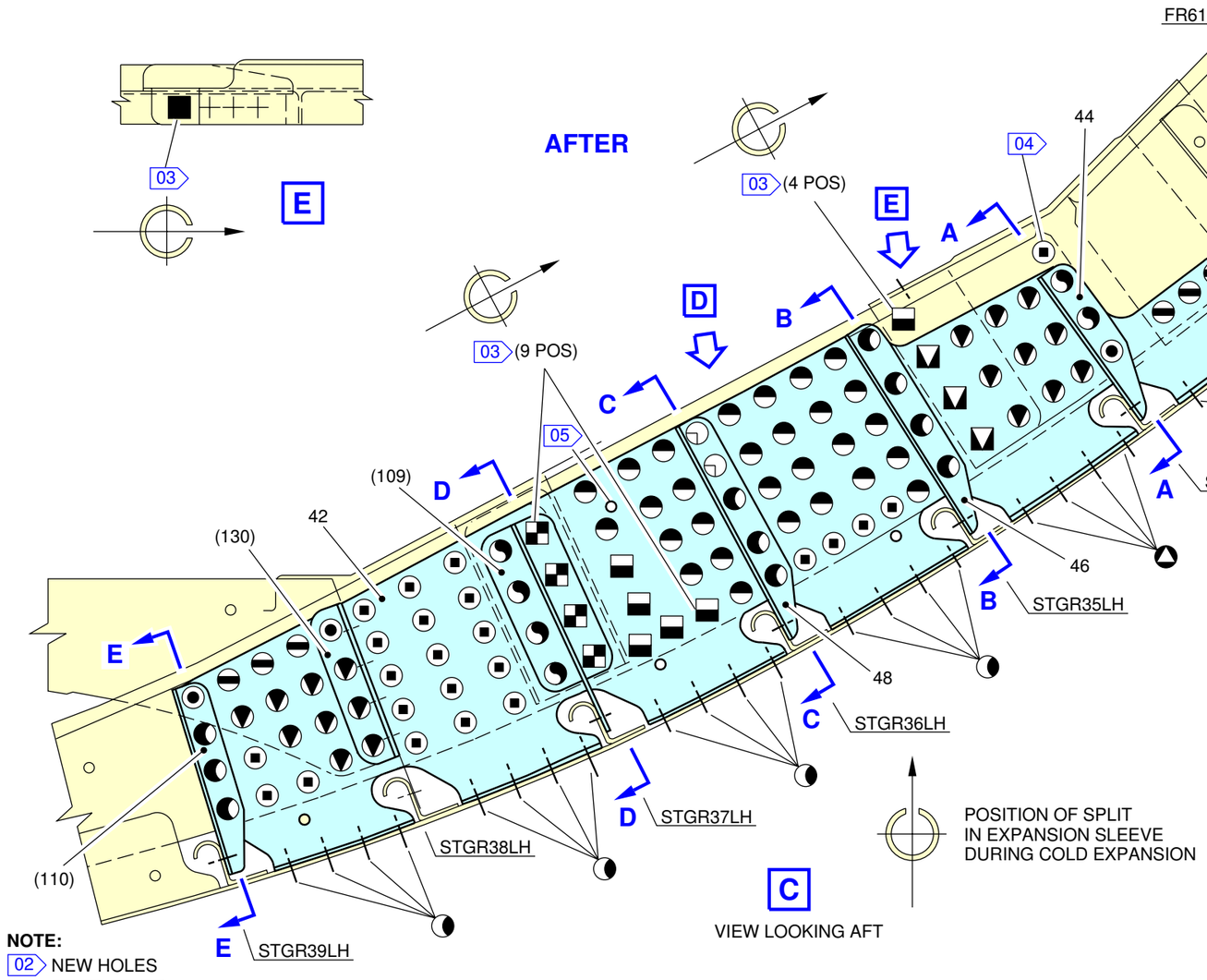
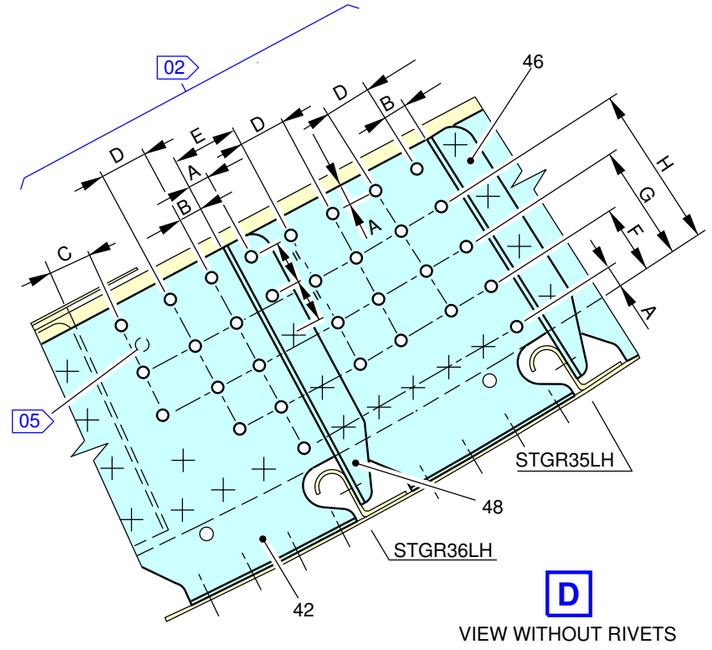
**CONF 001



DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	20.00	0.787
D	22.00	0.866
E	31.00	1.220
F	32.00	1.260
G	54.00	2.126
H	76.00	2.992



NOTE:

02 NEW HOLES

03 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00

04 IF NECESSARY HOLE MUST BE CLOSED

05 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4

N_SB_531364_6_BMAA_02_01

Figure A-GBMAA - Sheet 02
Replacement of Webs and Angles at Frame 61

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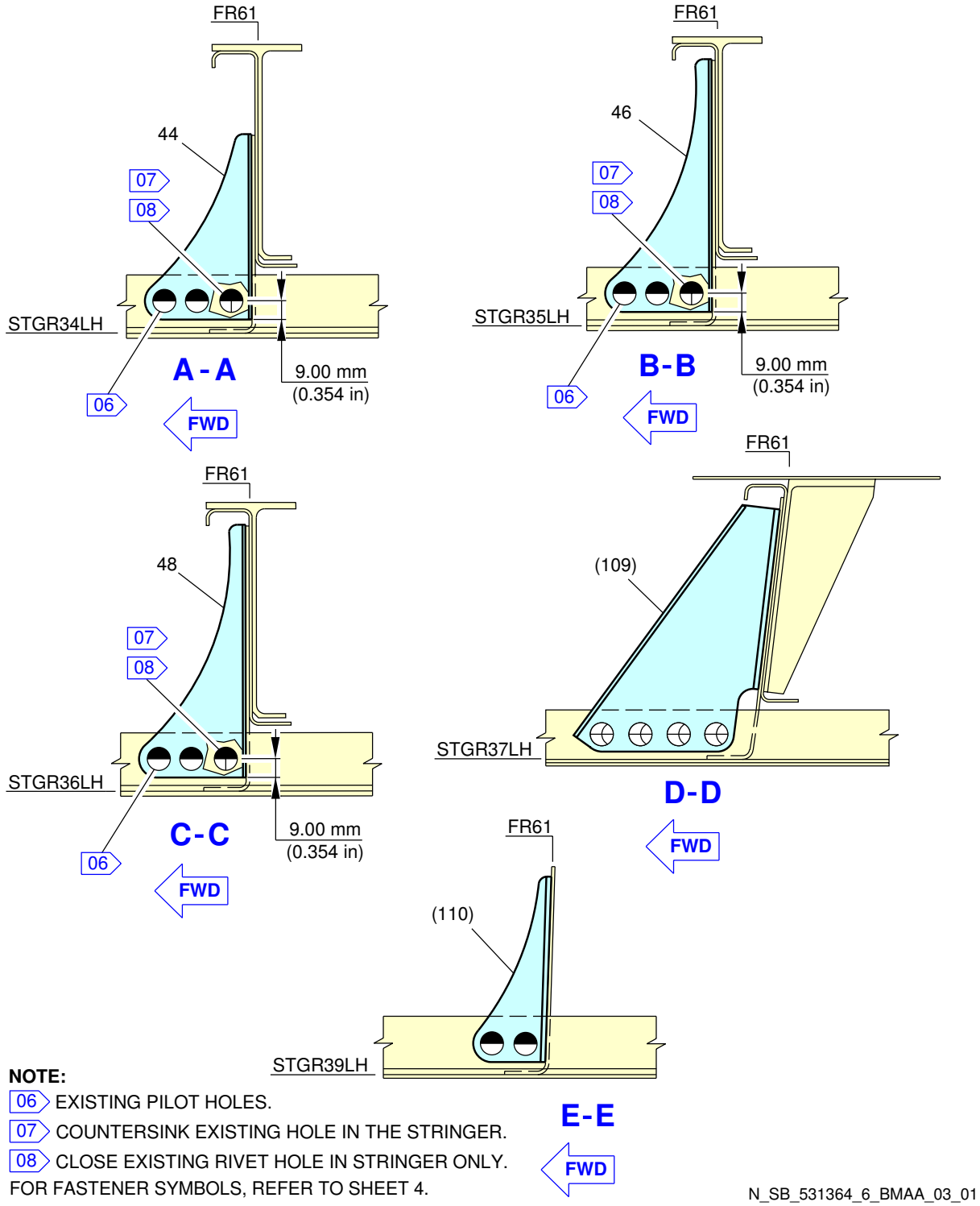
**CONF 001



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BMAA_03_01

Figure A-GBMAA - Sheet 03
Replacement of Webs and Angles at Frame 61

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**CONF 001

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	763	DAN5–6–3X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BMAA_04_01

Figure A-GBMAA - Sheet 04
Replacement of Webs and Angles at Frame 61

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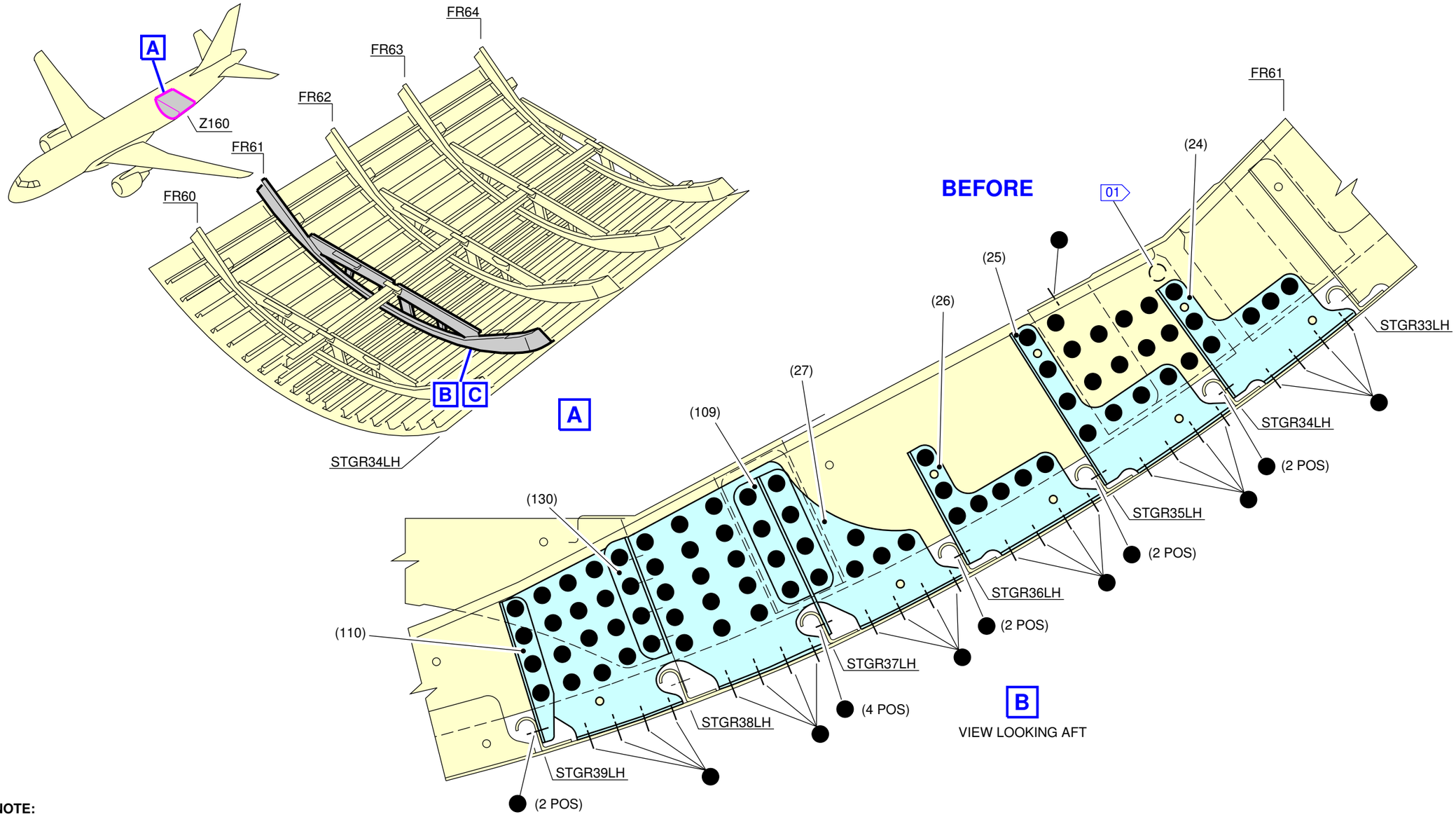
**CONF 002 thru 003



NOTE:

● REMOVE RIVETS, ITEM (100)

01 ◌ REMOVE RIVET IF INSTALLED, ITEM (100)

N_SB_531364_6_BMAB_01_00

Figure A-GBMAB - Sheet 01
Replacement of Webs and Angles at Frame 61

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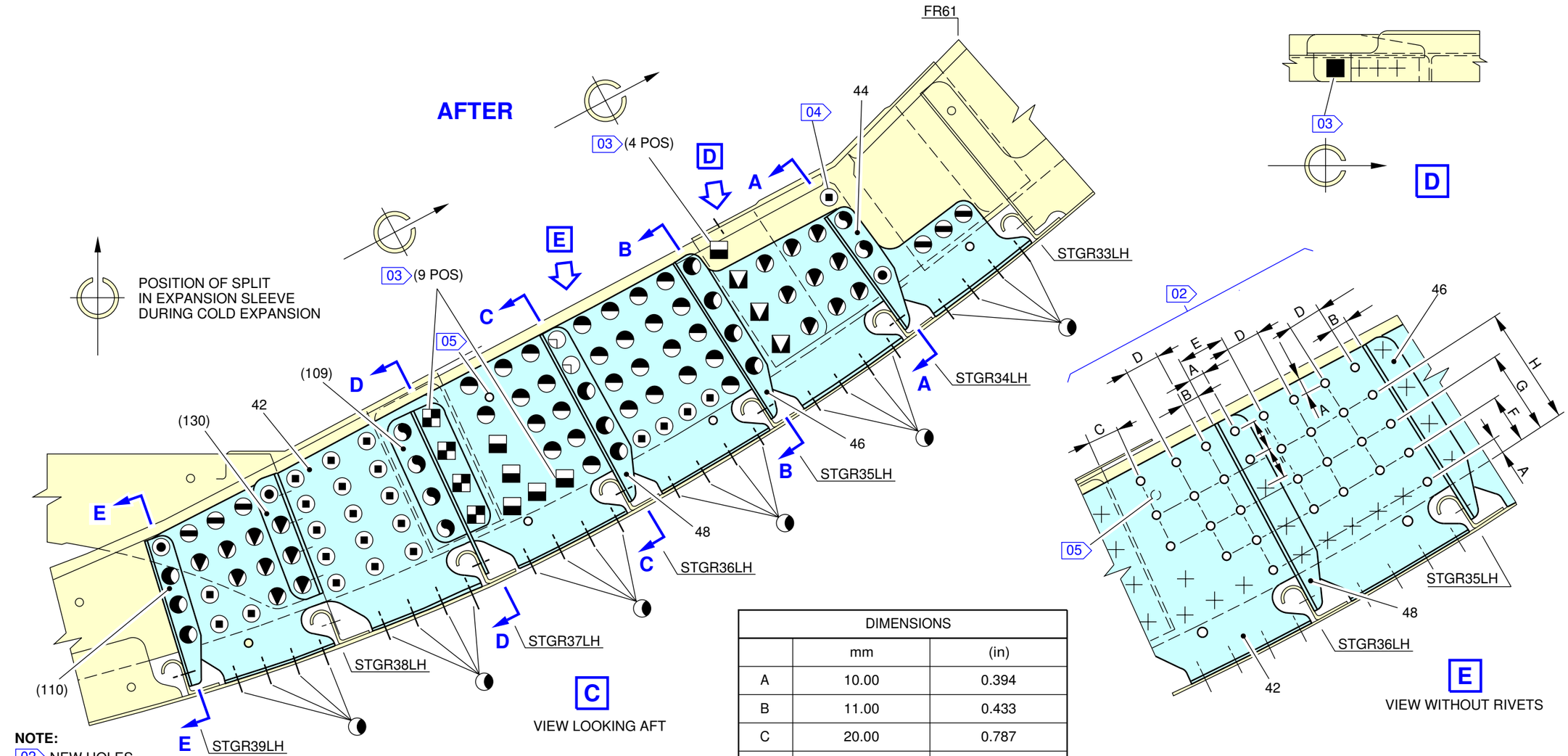
**CONF 002 thru 003



DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	20.00	0.787
D	22.00	0.866
E	31.00	1.220
F	32.00	1.260
G	54.00	2.126
H	76.00	2.992

NOTE:

02 NEW HOLES.

03 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

04 IF NECESSARY HOLE MUST BE CLOSED.

05 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BMAB_02_01

Figure A-GBMAB - Sheet 02
Replacement of Webs and Angles at Frame 61

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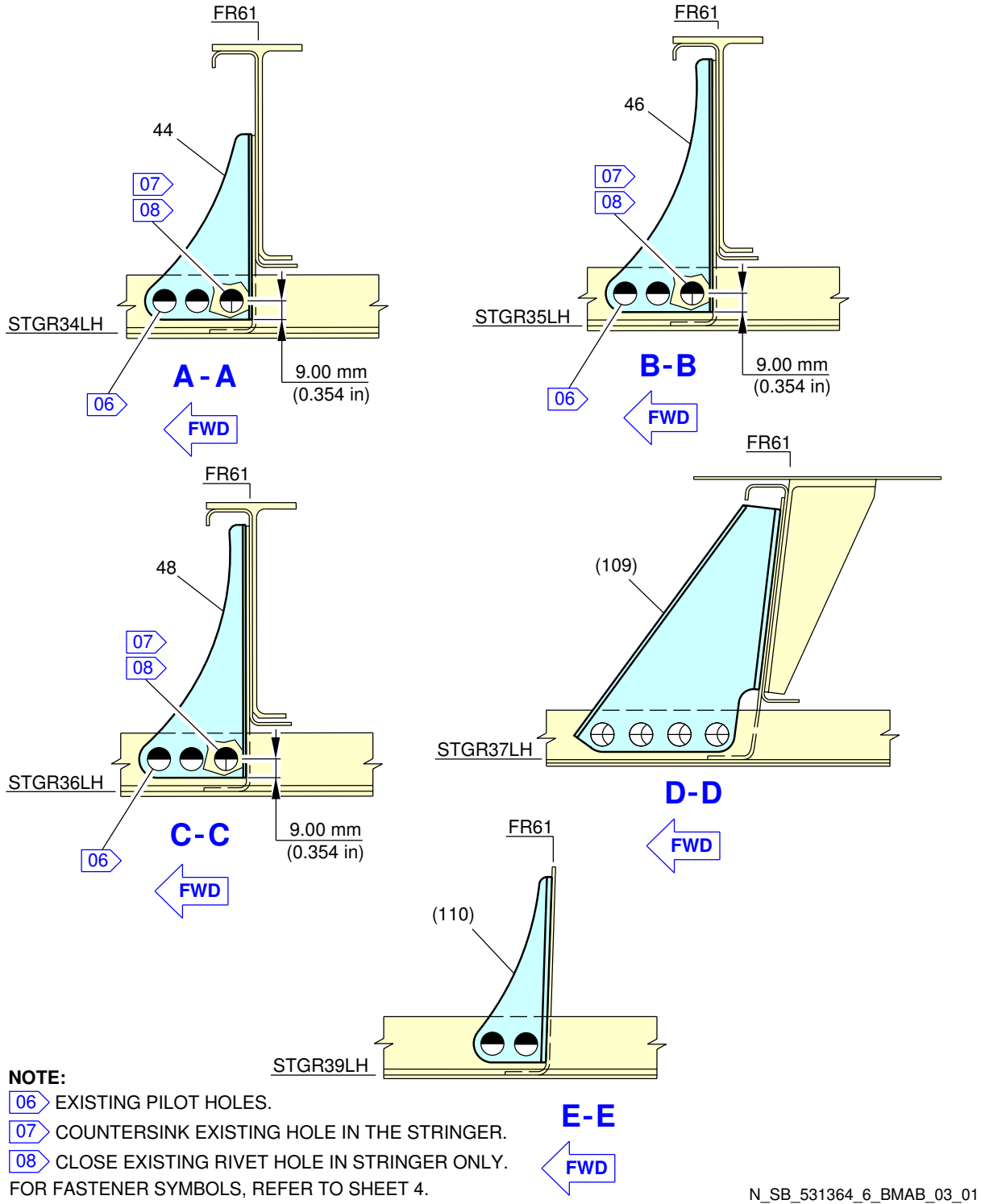
**CONF 002 thru 003



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BMAB_03_01

Figure A-GBMAB - Sheet 03
Replacement of Webs and Angles at Frame 61

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**CONF 002 thru 003

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	763	DAN5–6–3X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			

N_SB_531364_6_BMAB_04_01

Figure A-GBMAB - Sheet 04
Replacement of Webs and Angles at Frame 61

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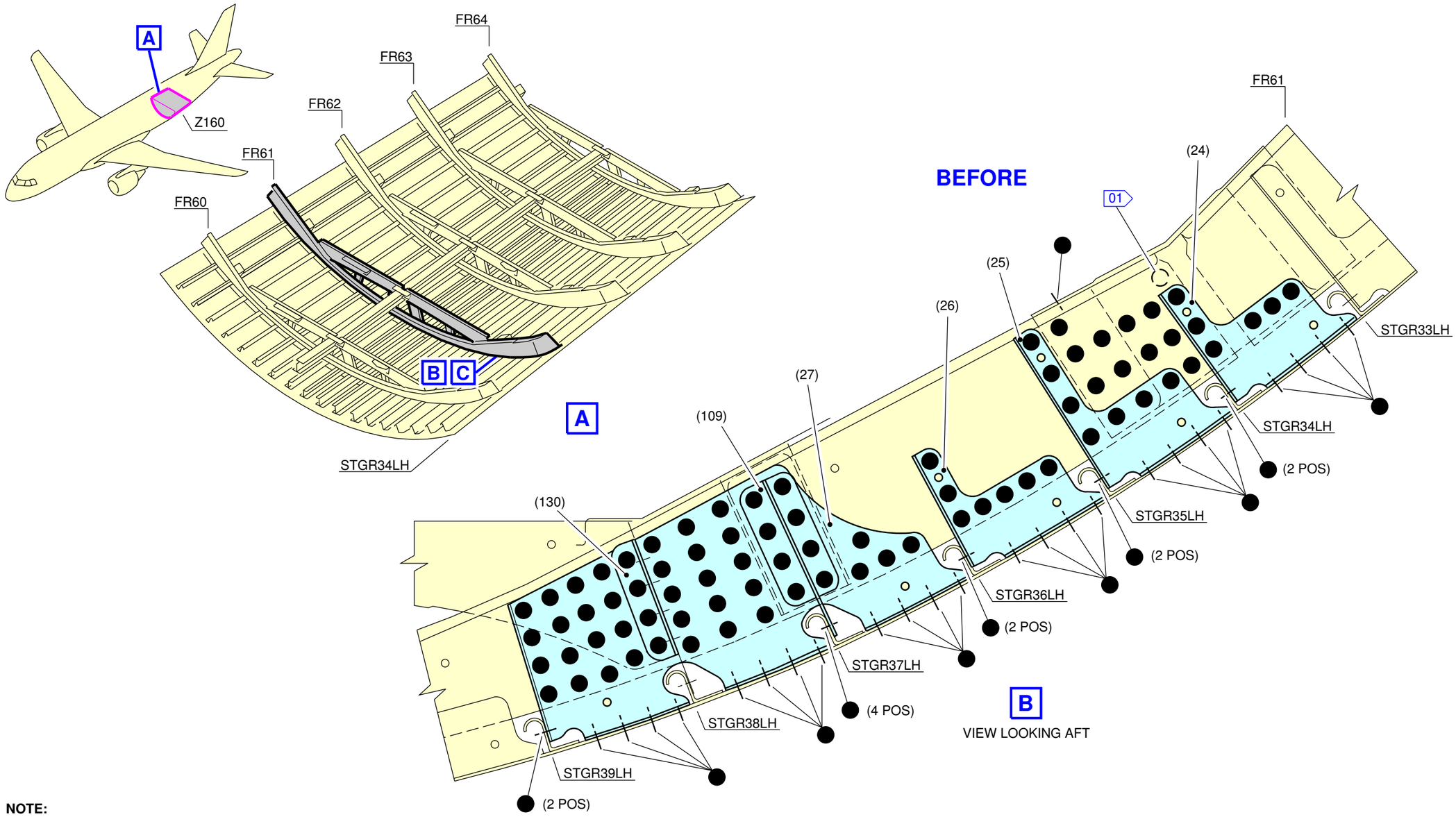
**CONF 004, 006



NOTE:

● REMOVE RIVETS, ITEM (100)

01 ◌ REMOVE RIVET IF INSTALLED, ITEM (100)

N_SB_531364_6_BMAD_01_00

Figure A-GBMAD - Sheet 01
Replacement of Webs and Angles at Frame 61

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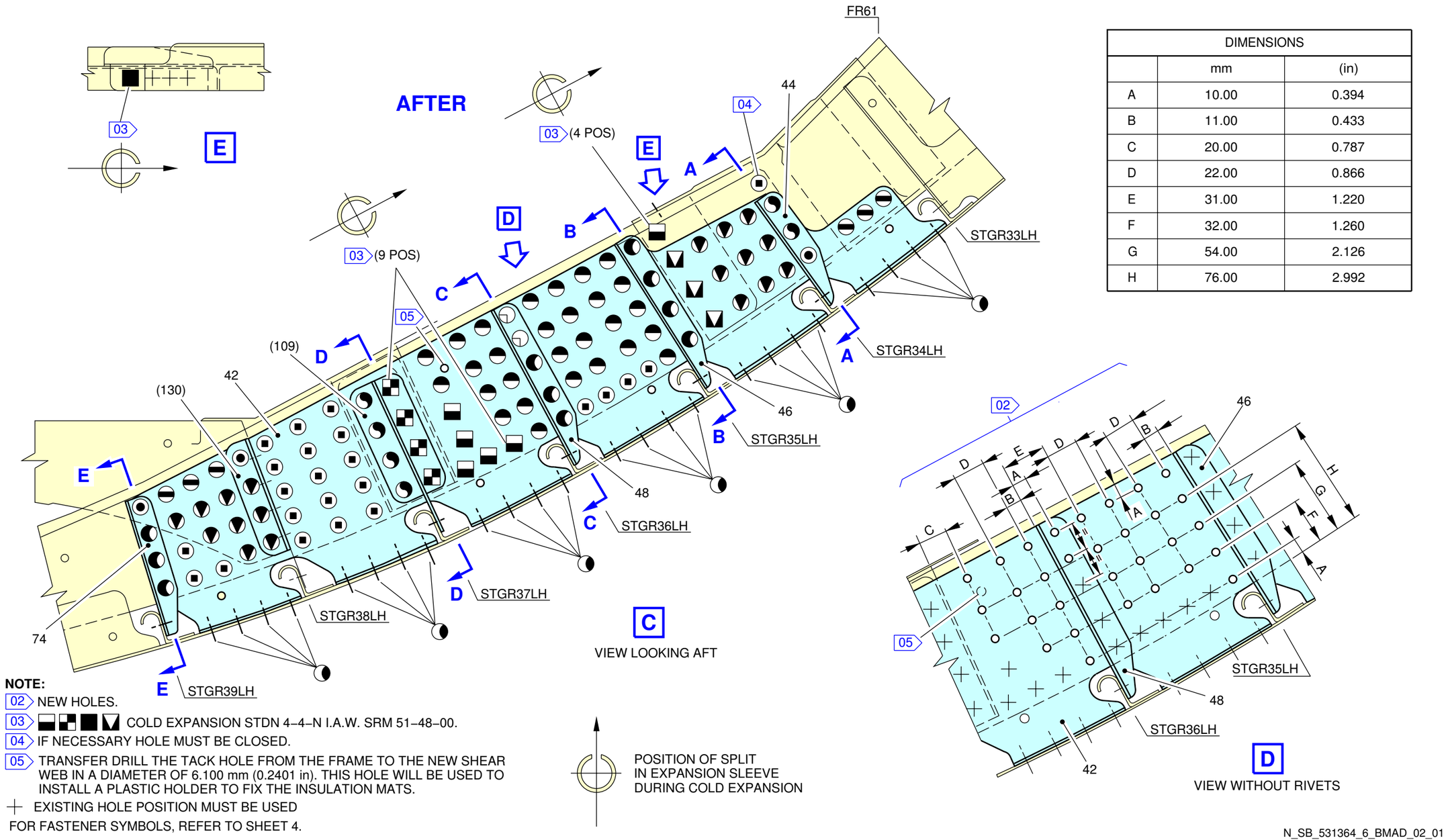
**CONF 004, 006



DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	20.00	0.787
D	22.00	0.866
E	31.00	1.220
F	32.00	1.260
G	54.00	2.126
H	76.00	2.992

NOTE:

02 NEW HOLES.

03 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

04 IF NECESSARY HOLE MUST BE CLOSED.

05 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

N_SB_531364_6_BMAD_02_01

Figure A-GBMAD - Sheet 02
Replacement of Webs and Angles at Frame 61

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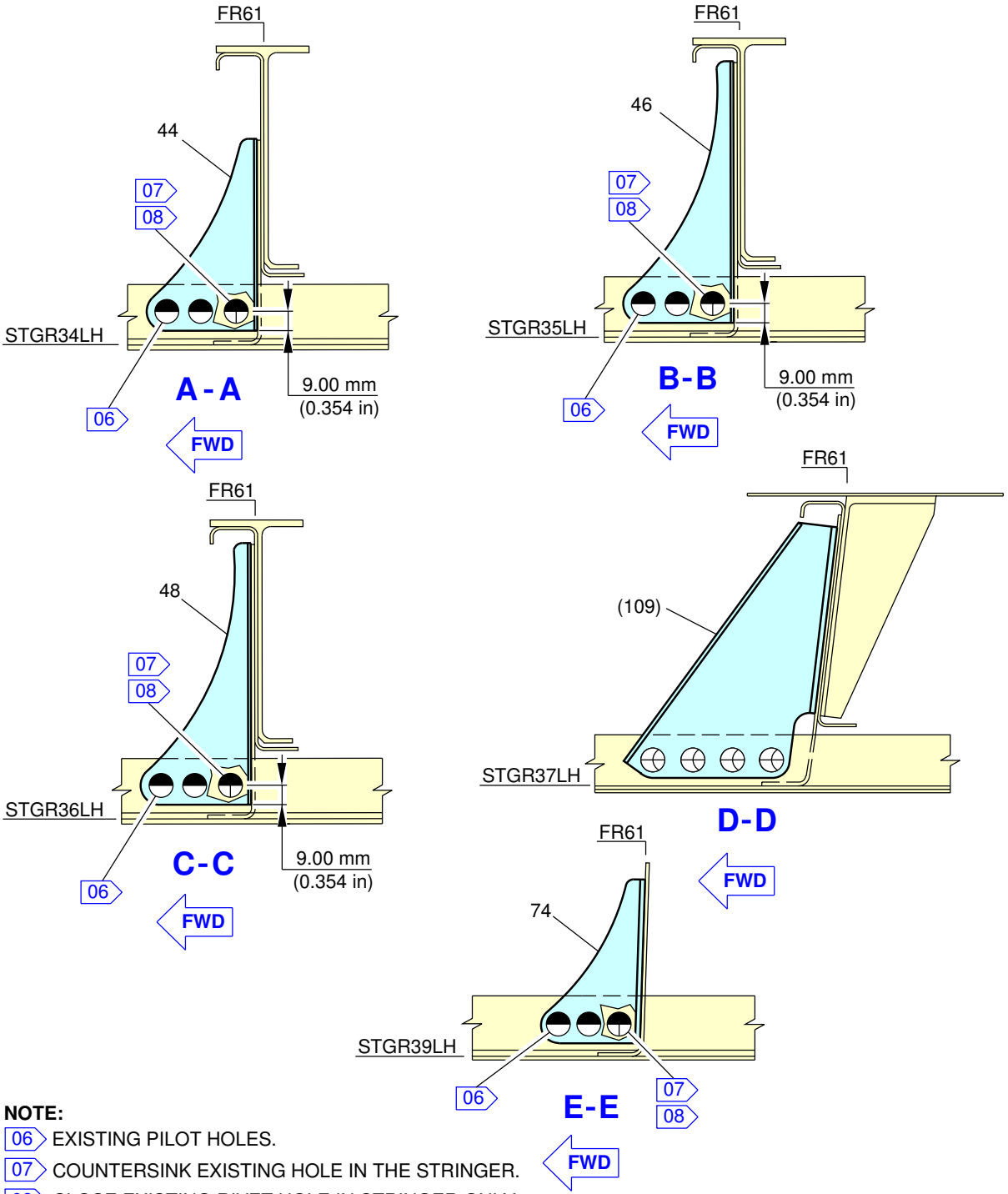
**CONF 004, 006



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BMAD_03_01

Figure A-GBMAD - Sheet 03
Replacement of Webs and Angles at Frame 61

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**CONF 004, 006

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	763	DAN5–6–3X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			

N_SB_531364_6_BMAD_04_01

Figure A-GBMAD - Sheet 04
Replacement of Webs and Angles at Frame 61

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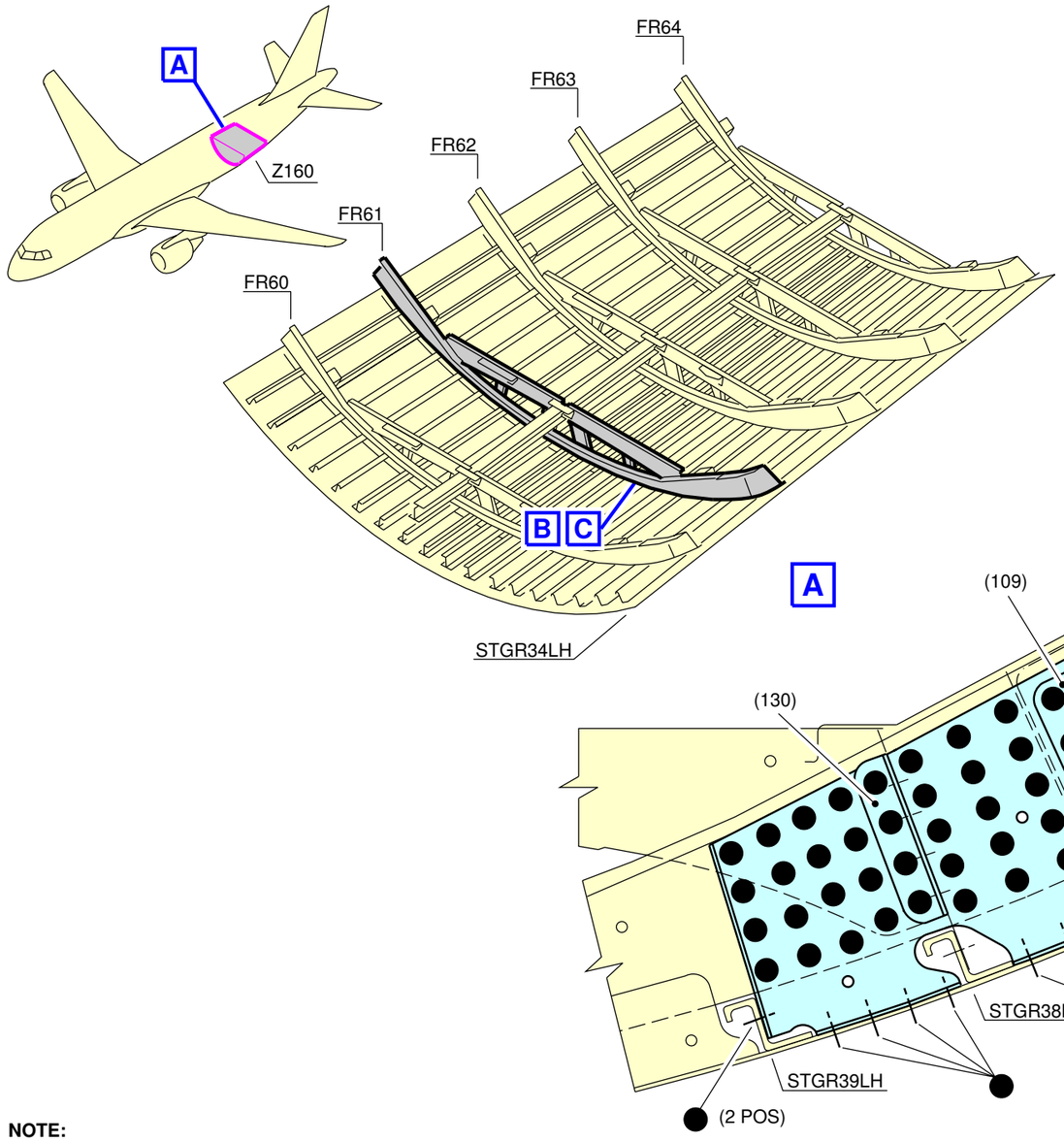
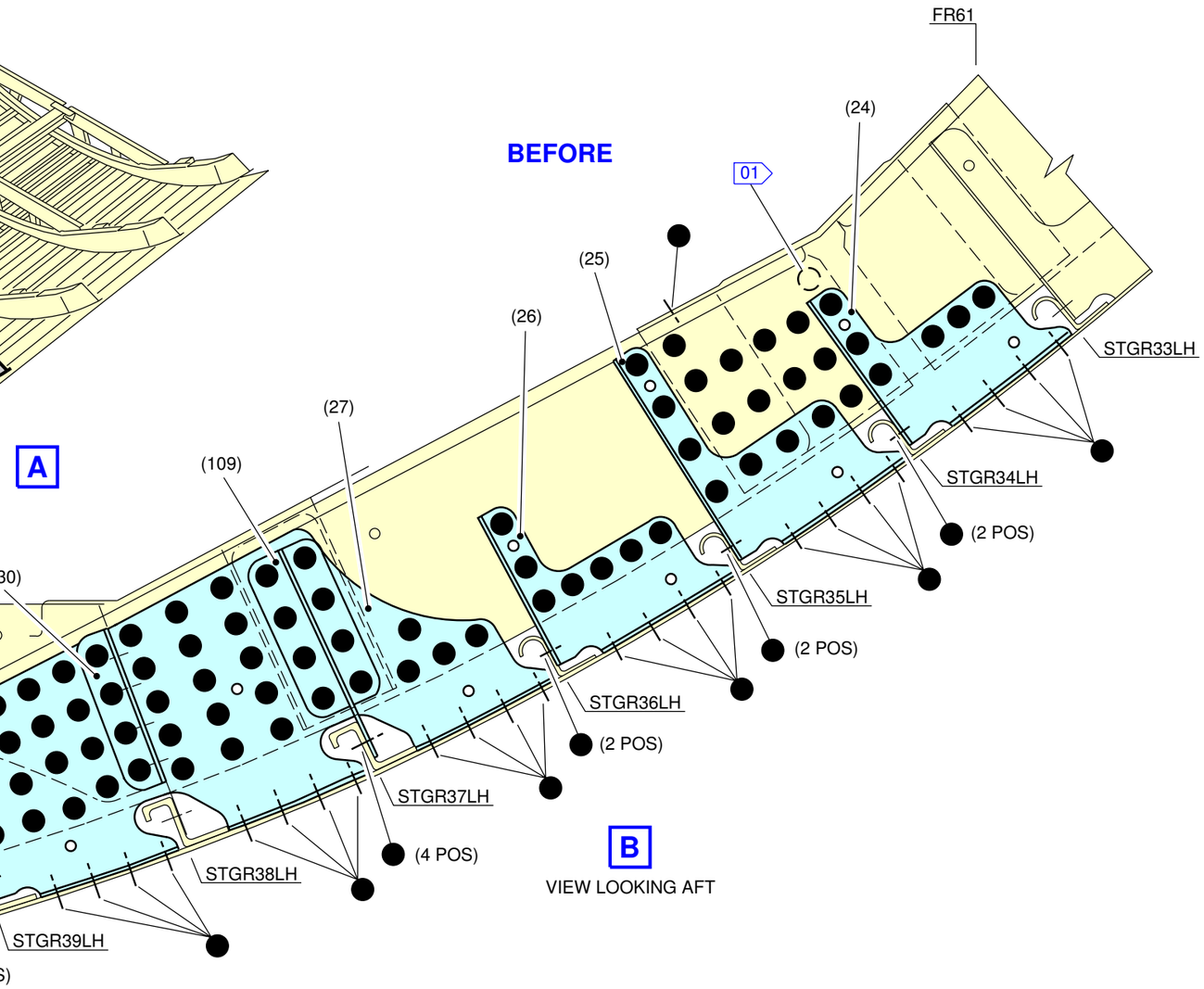
**CONF 005, 007





NOTE:

● REMOVE RIVETS, ITEM (100)

01 ◌ REMOVE RIVET IF INSTALLED, ITEM (100)

N_SB_531364_6_BMAE_01_00

Figure A-GBMAE - Sheet 01
Replacement of Webs and Angles at Frame 61

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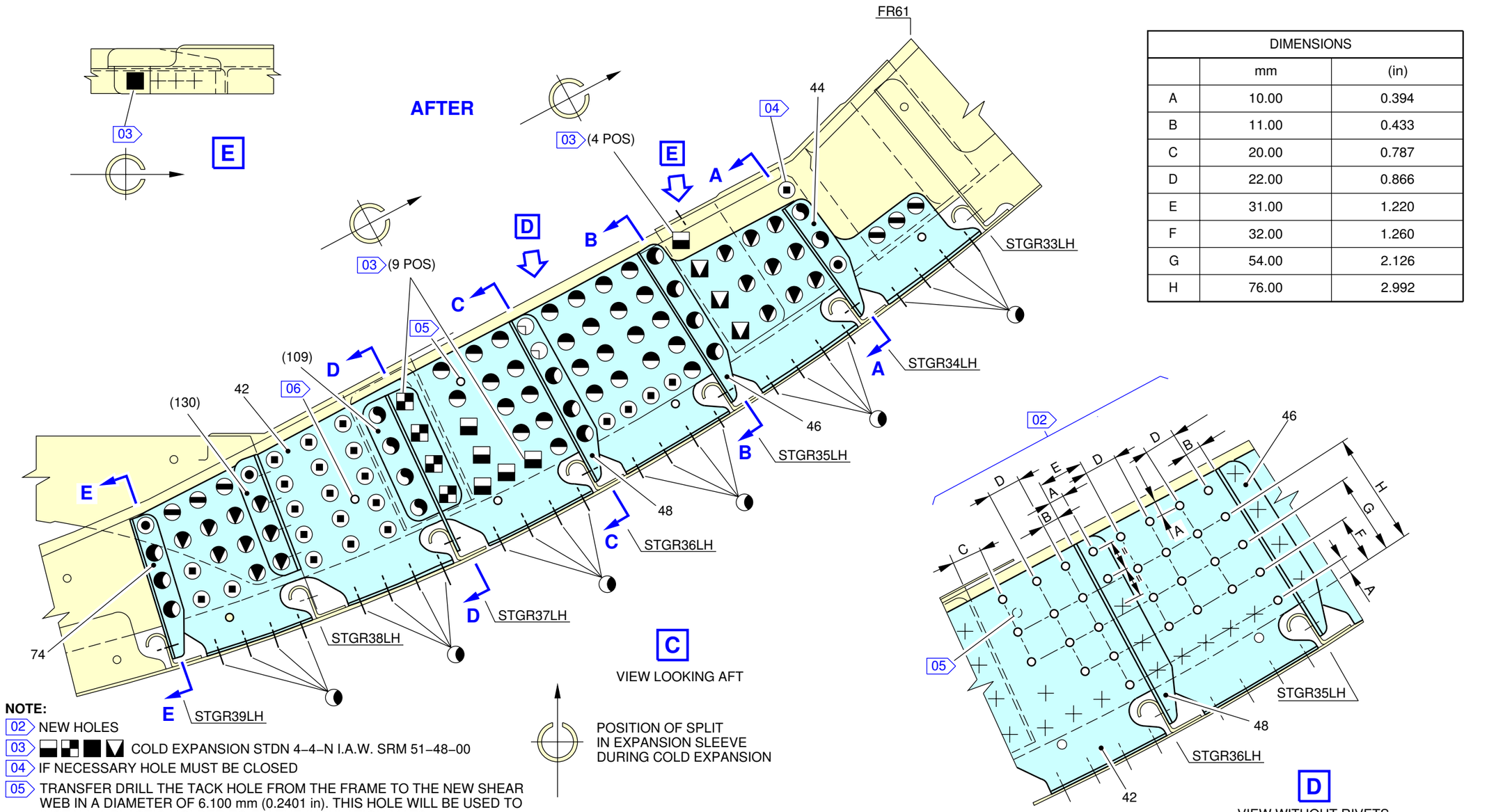
**CONF 005, 007



DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	20.00	0.787
D	22.00	0.866
E	31.00	1.220
F	32.00	1.260
G	54.00	2.126
H	76.00	2.992

NOTE:

02 NEW HOLES

03 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00

04 IF NECESSARY HOLE MUST BE CLOSED

05 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

06 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in), FOR MSN 3999 AND SUBSEQUENT.

+ EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4

N_SB_531364_6_BMAE_02_01

Figure A-GBMAE - Sheet 02
Replacement of Webs and Angles at Frame 61

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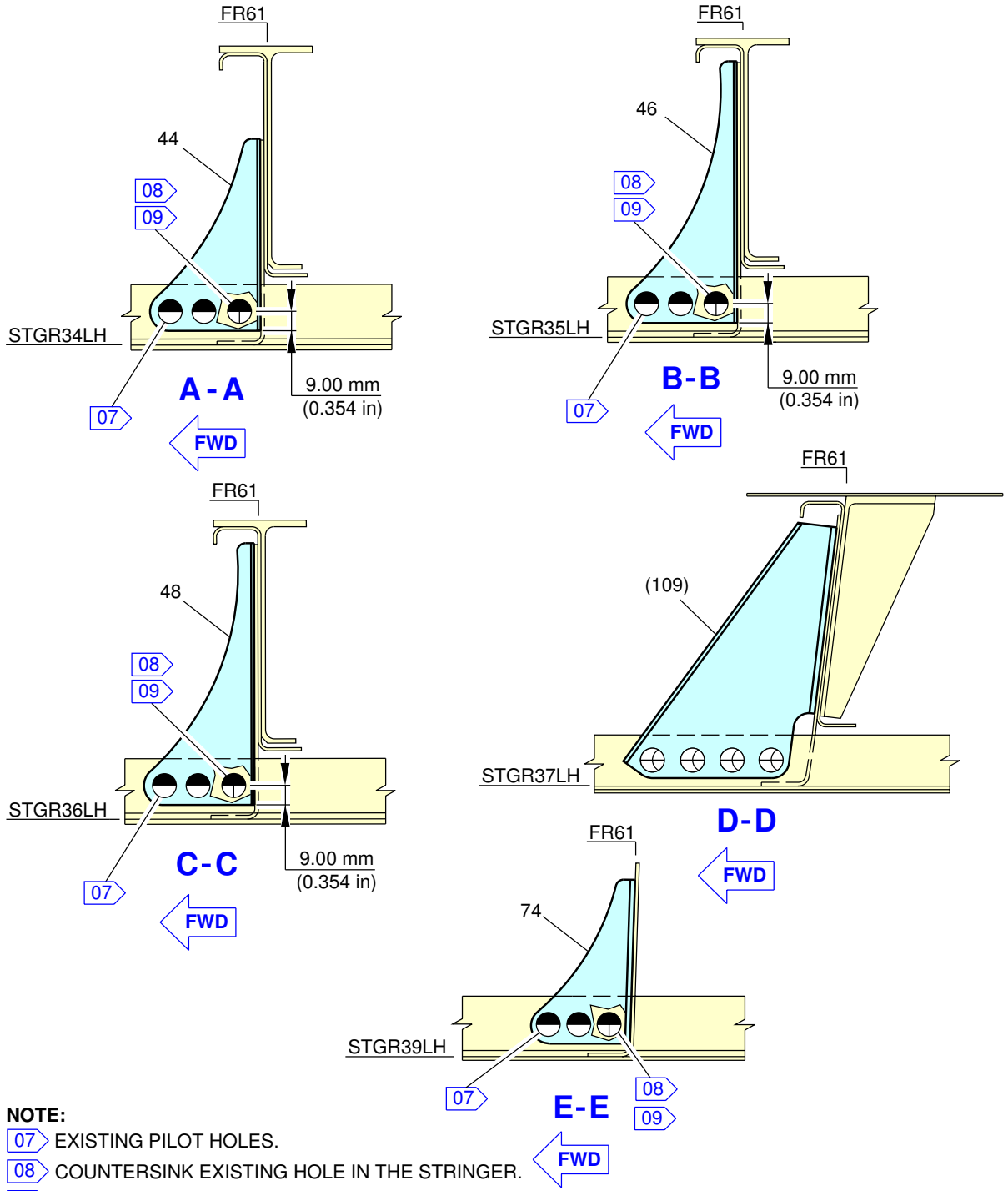
**CONF 005, 007



NOTE:

07 EXISTING PILOT HOLES.

08 COUNTERSINK EXISTING HOLE IN THE STRINGER.

09 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BMAE_03_01

Figure A-GBMAE - Sheet 03
Replacement of Webs and Angles at Frame 61

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**CONF 005, 007

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	763	DAN5–6–3X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			

N_SB_531364_6_BMAE_04_01

Figure A-GBMAE - Sheet 04
Replacement of Webs and Angles at Frame 61

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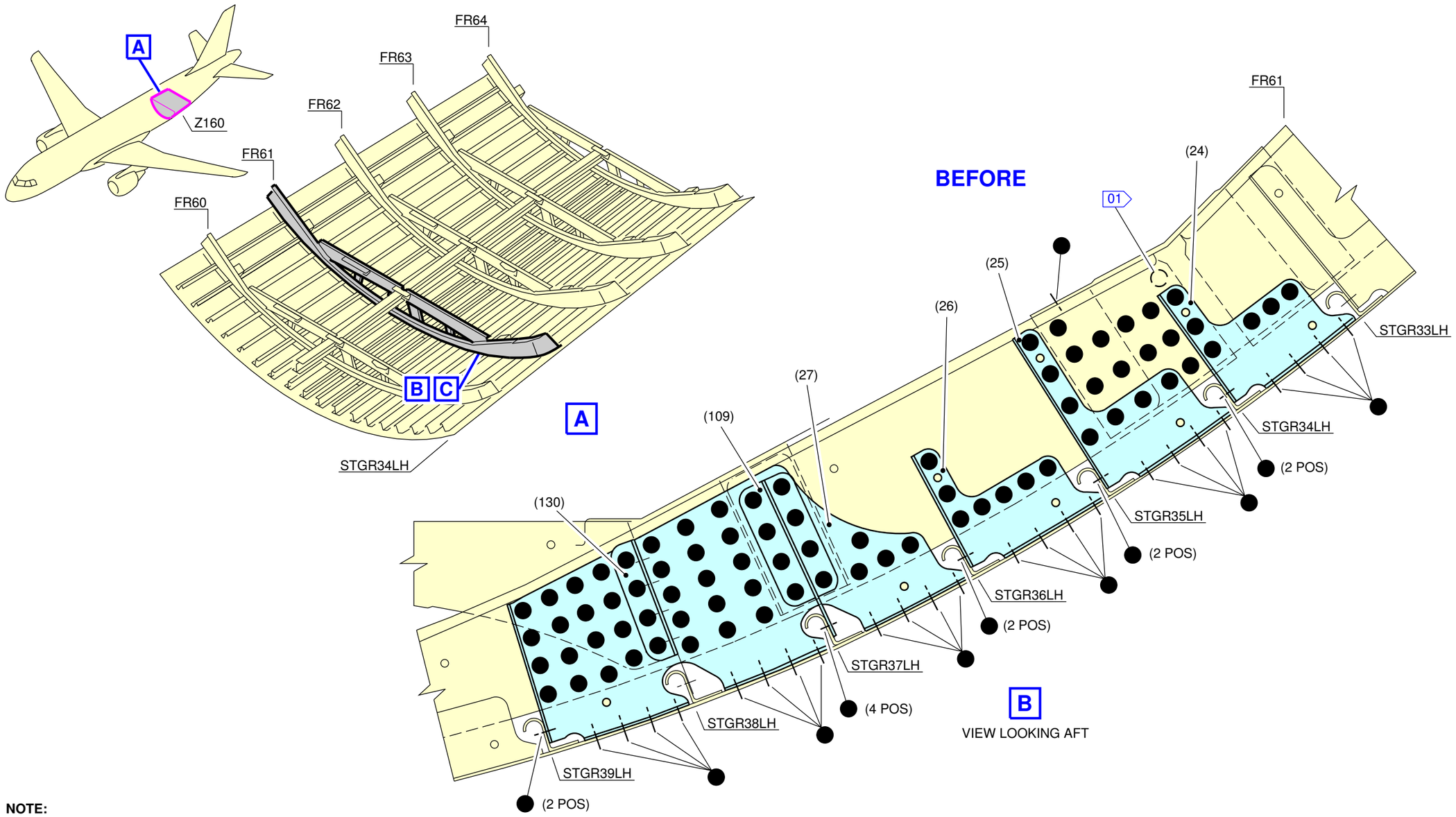
**CONF 008



NOTE:

● REMOVE RIVETS, ITEM (100)

01 ◌ REMOVE RIVET IF INSTALLED, ITEM (100)

N_SB_531364_6_BMAH_01_00

Figure A-GBMAH - Sheet 01
Replacement of Webs and Angles at Frame 61

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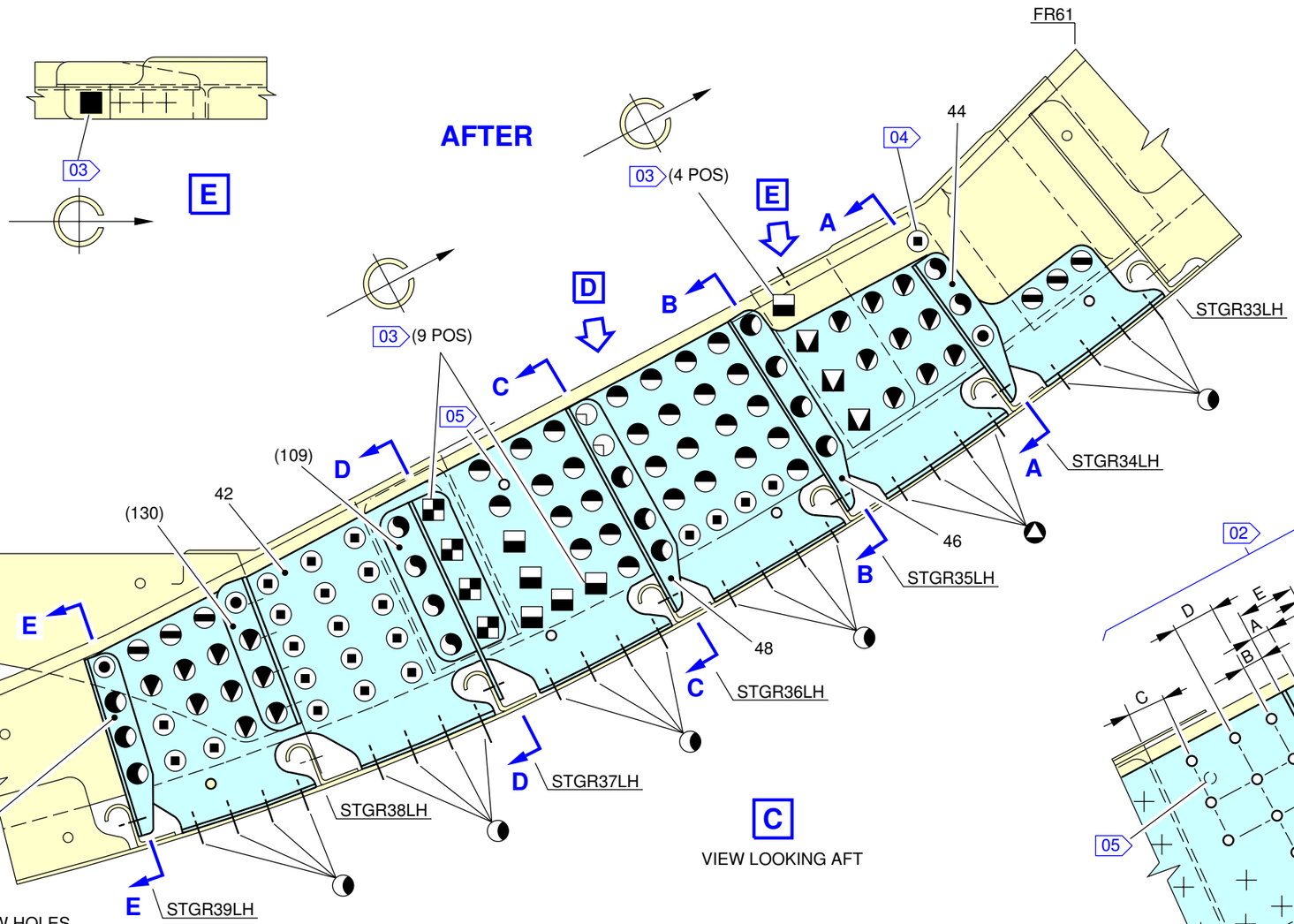
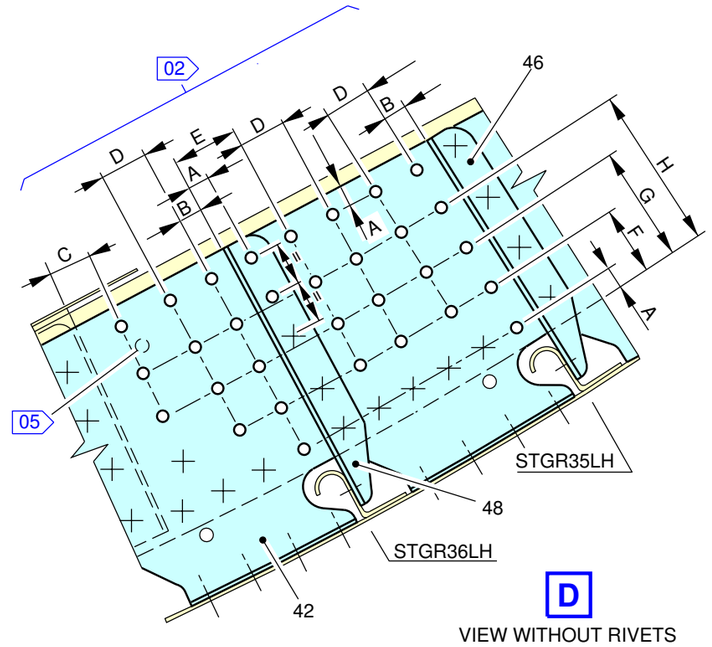
**CONF 008



C

VIEW LOOKING AFT



D

VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	20.00	0.787
D	22.00	0.866
E	31.00	1.220
F	32.00	1.260
G	54.00	2.126
H	76.00	2.992

NOTE:

02 NEW HOLES.

03 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

04 IF NECESSARY HOLE MUST BE CLOSED.

05 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

N_SB_531364_6_BMAH_02_01

Figure A-GBMAH - Sheet 02
Replacement of Webs and Angles at Frame 61

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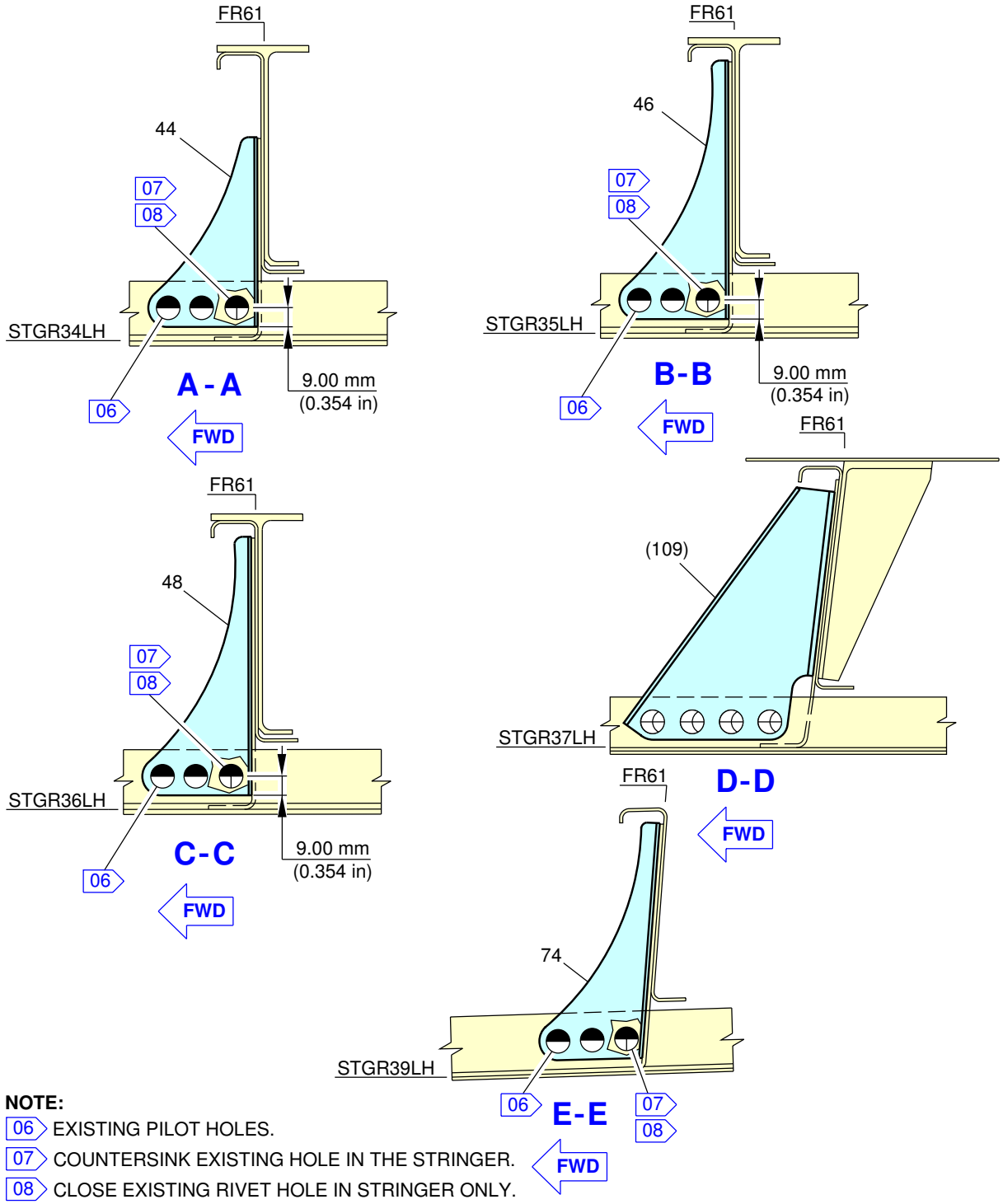
**CONF 008



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BMAH_03_01

Figure A-GBMAH - Sheet 03
Replacement of Webs and Angles at Frame 61

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**CONF 008

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	763	DAN5–6–3X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BMAH_04_01

Figure A-GBMAH - Sheet 04
Replacement of Webs and Angles at Frame 61

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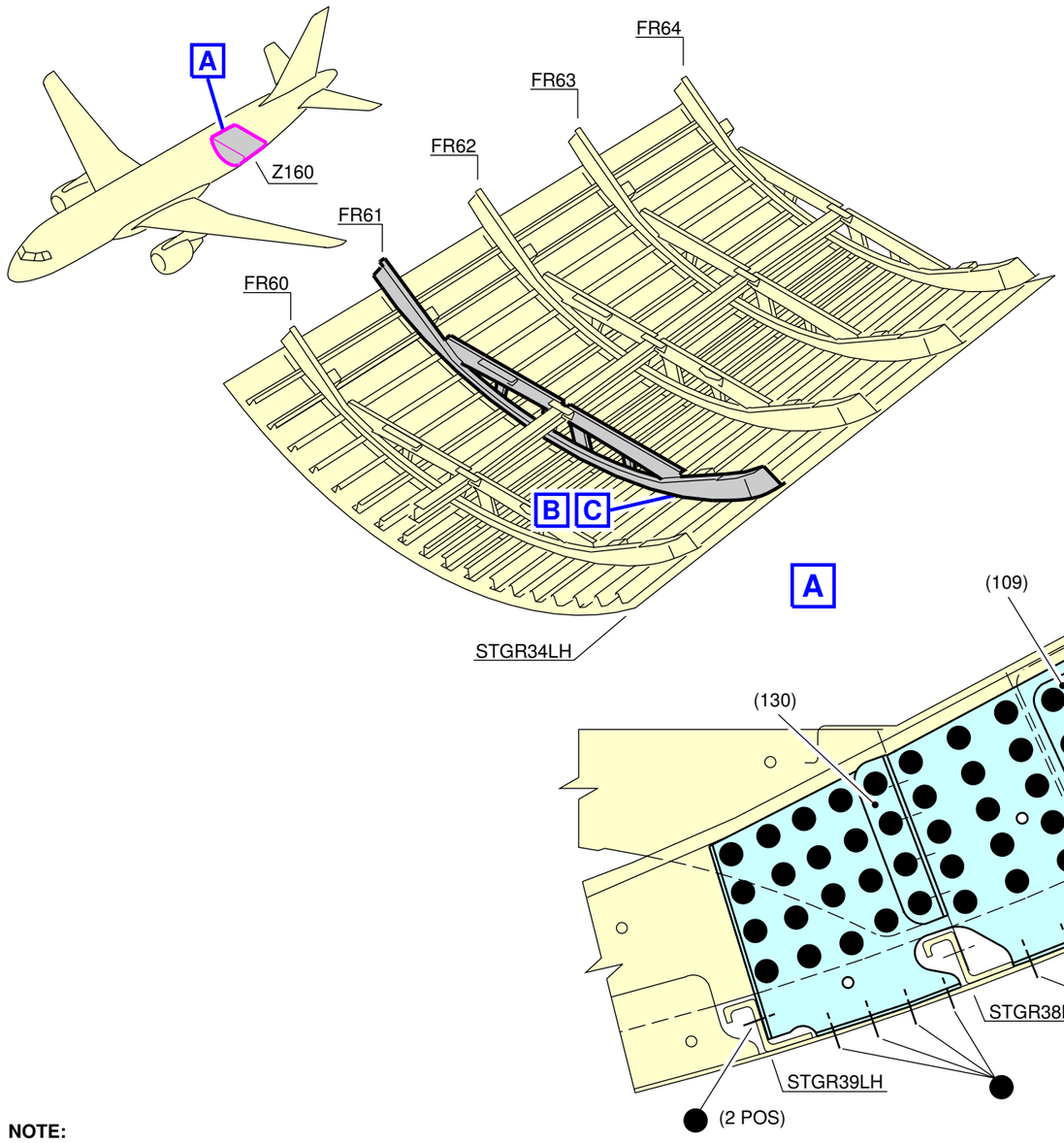
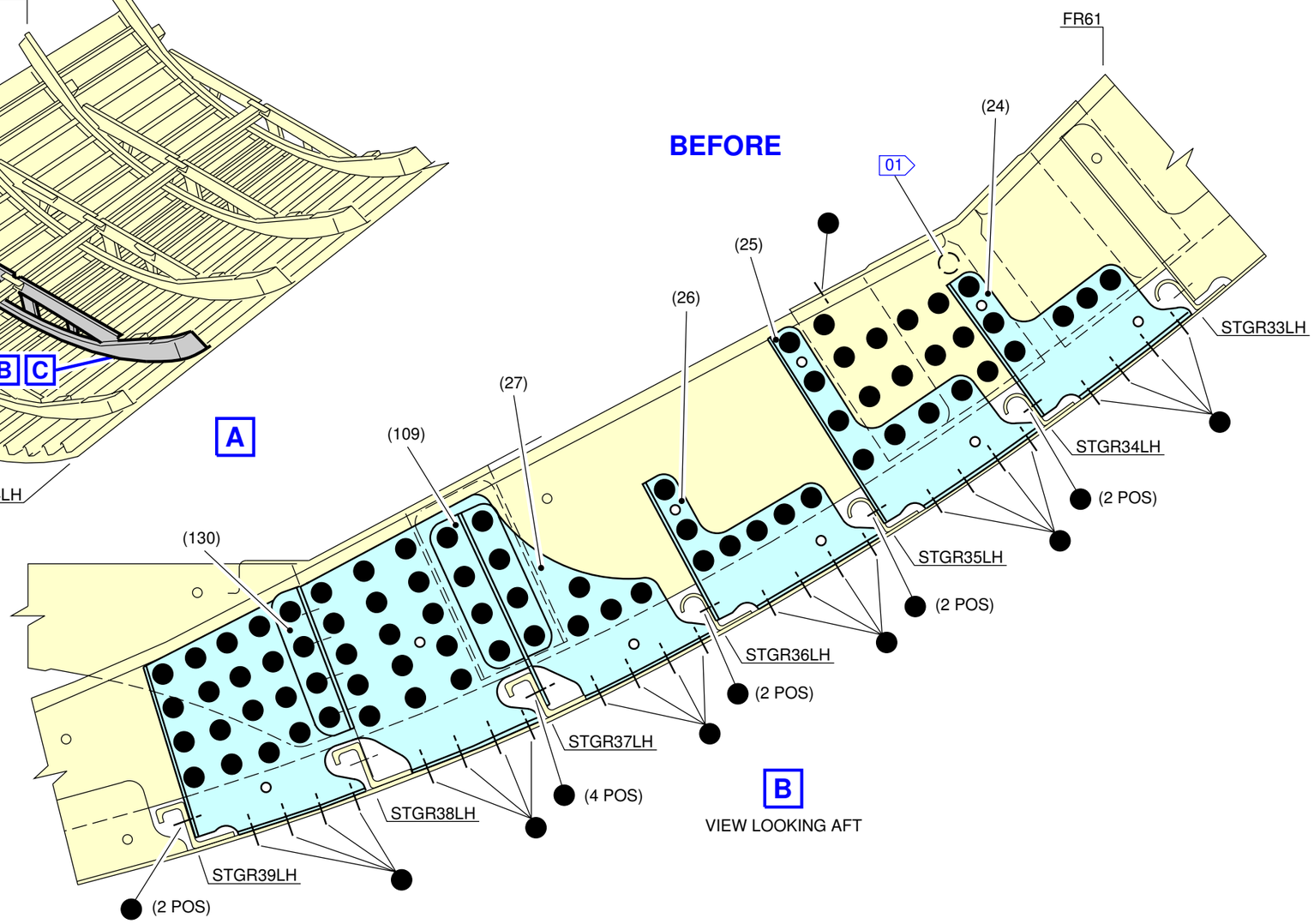
**CONF 009





NOTE:

- REMOVE RIVETS, ITEM (100)
- 01 REMOVE RIVET IF INSTALLED, ITEM (100)

N_SB_531364_6_BMAJ_01_00

Figure A-GBMAJ - Sheet 01
Replacement of Webs and Angles at Frame 61

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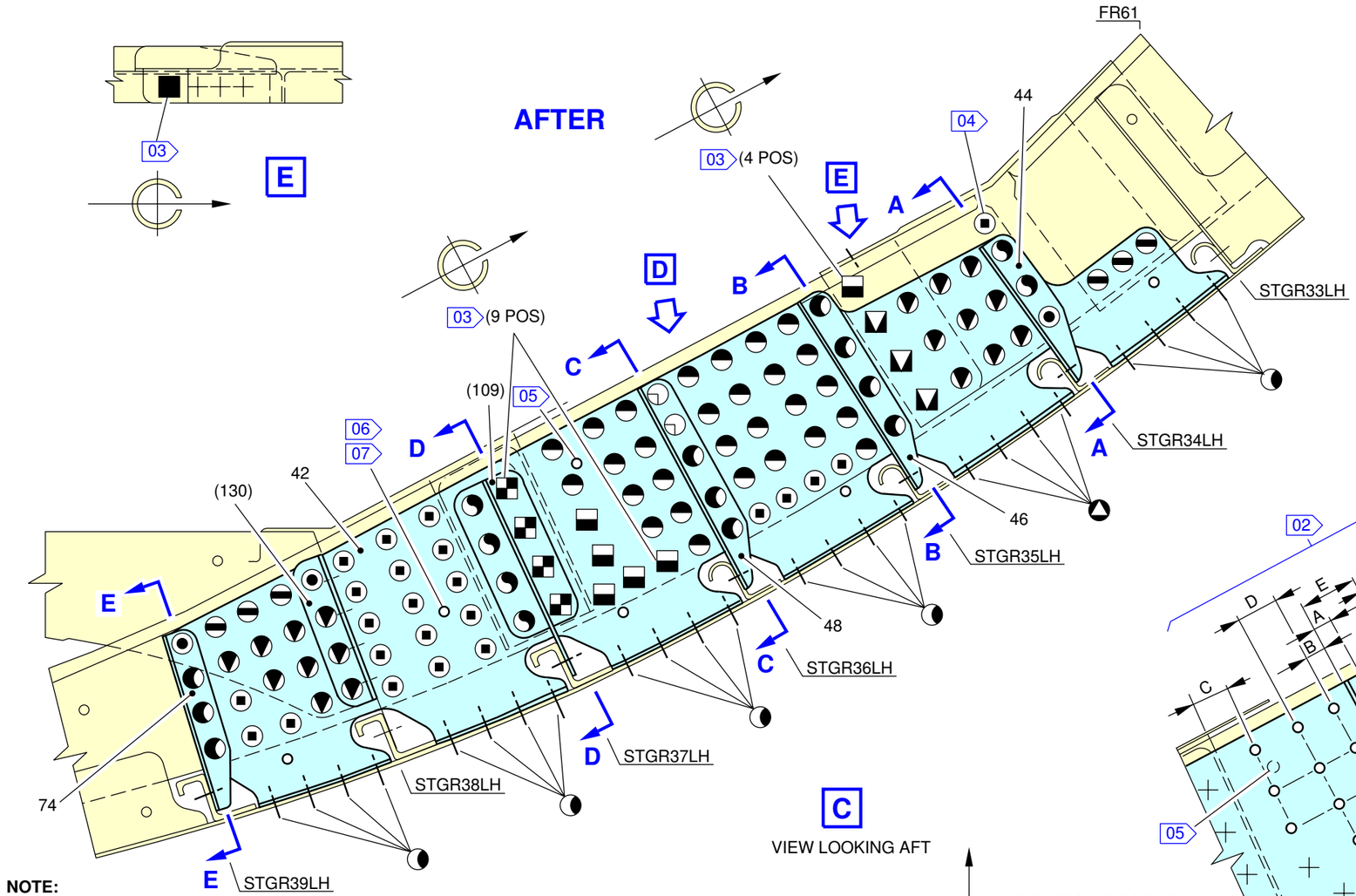
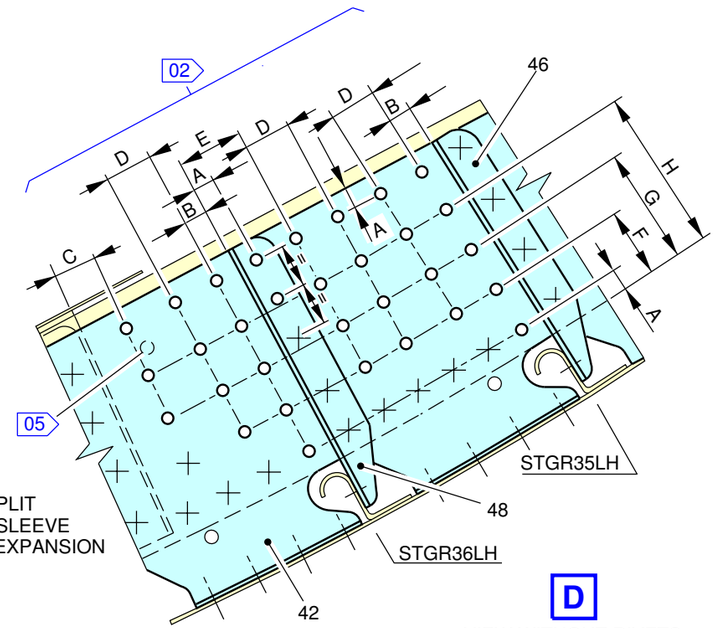
**CONF 009





DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	20.00	0.787
D	22.00	0.866
E	31.00	1.220
F	32.00	1.260
G	54.00	2.126
H	76.00	2.992

NOTE:

02 NEW HOLES.

03 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

04 IF NECESSARY HOLE MUST BE CLOSED.

05 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

06 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in).

C
VIEW LOOKING AFT

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

07 VALID FOR MSN 4005 AND SUBSEQUENT.

EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 4

D
VIEW WITHOUT RIVETS

N_SB_531364_6_BMAJ_02_01

Figure A-GBMAJ - Sheet 02
Replacement of Webs and Angles at Frame 61

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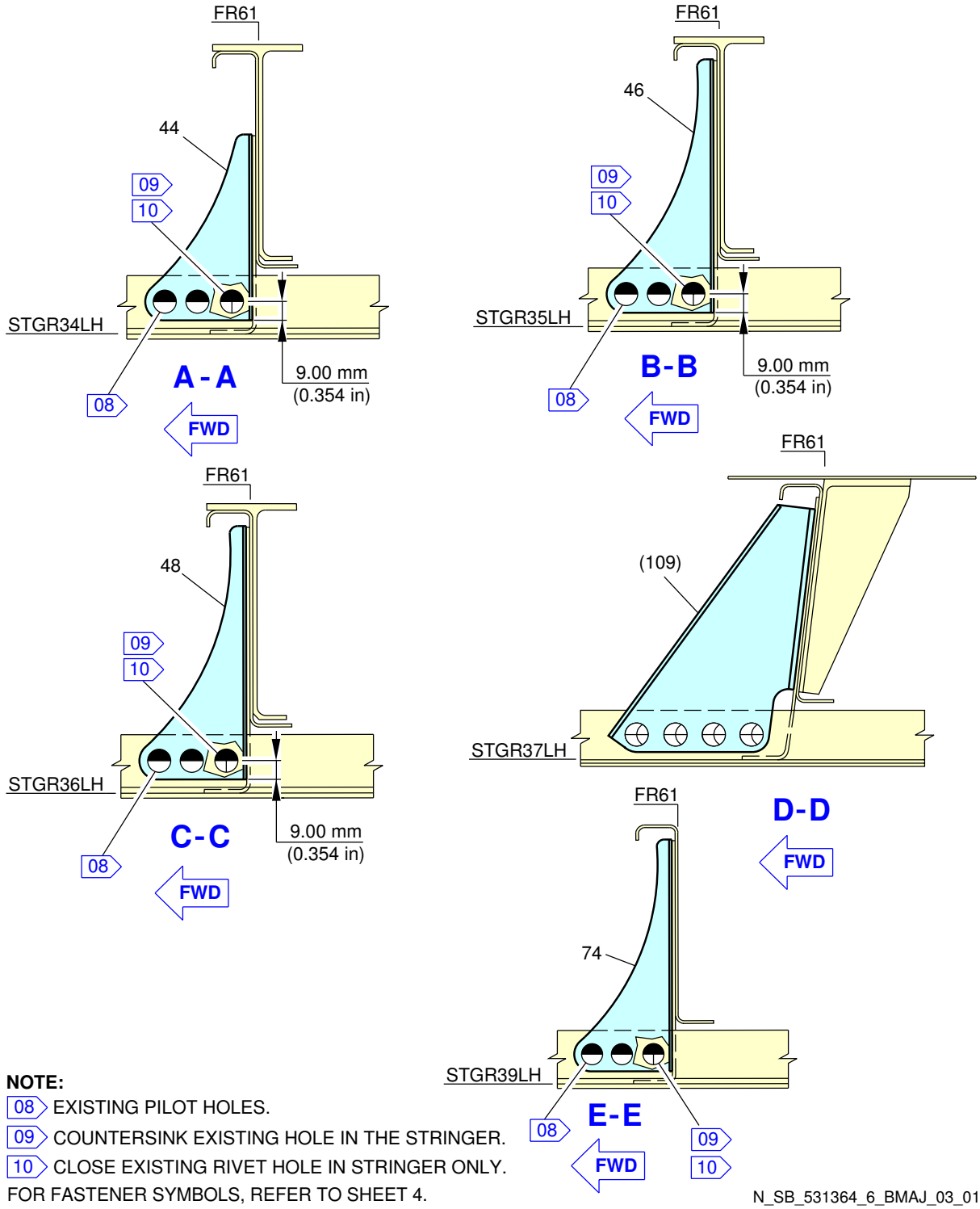
**CONF 009



NOTE:

08 EXISTING PILOT HOLES.

09 COUNTERSINK EXISTING HOLE IN THE STRINGER.

10 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 4.

N_SB_531364_6_BMAJ_03_01

Figure A-GBMAJ - Sheet 03
Replacement of Webs and Angles at Frame 61

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**CONF 009

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	763	DAN5–6–3X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BMAJ_04_01

Figure A-GBMAJ - Sheet 04
Replacement of Webs and Angles at Frame 61

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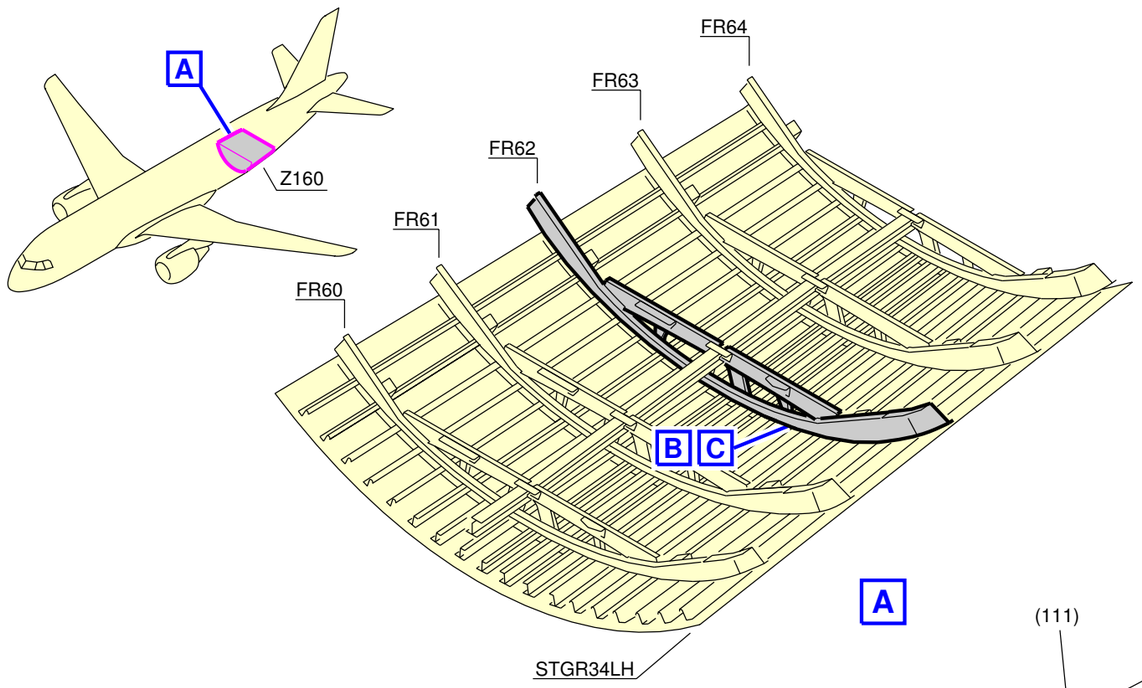
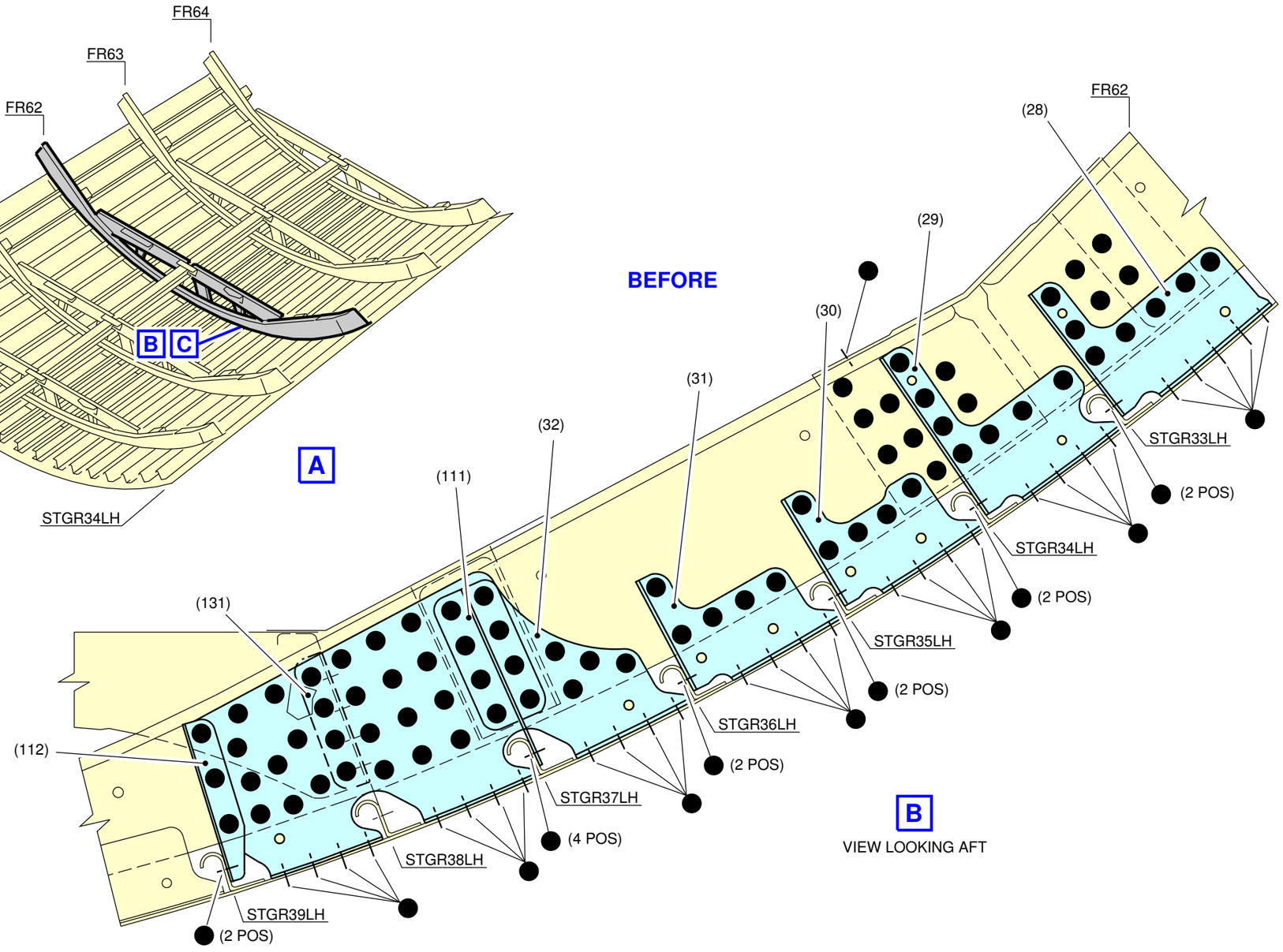
**CONF 001





NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BNAA_01_00

Figure A-GBNAA - Sheet 01
Replacement of Webs and Angles at Frame 62

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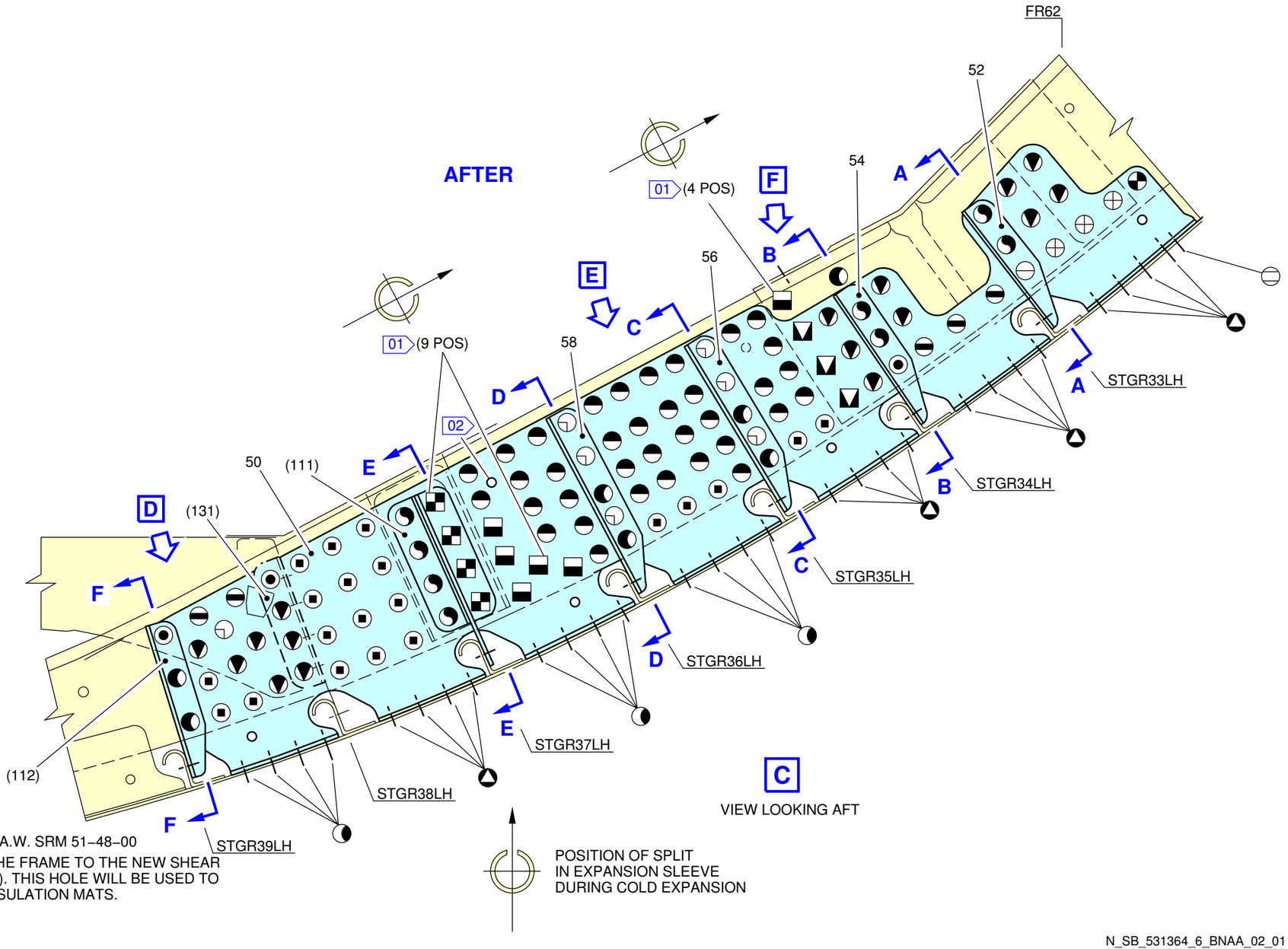
**CONF 001



NOTE:

01 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00

02 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

+ EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 6

N_SB_531364_6_BNAA_02_01

Figure A-GBNAA - Sheet 02
Replacement of Webs and Angles at Frame 62

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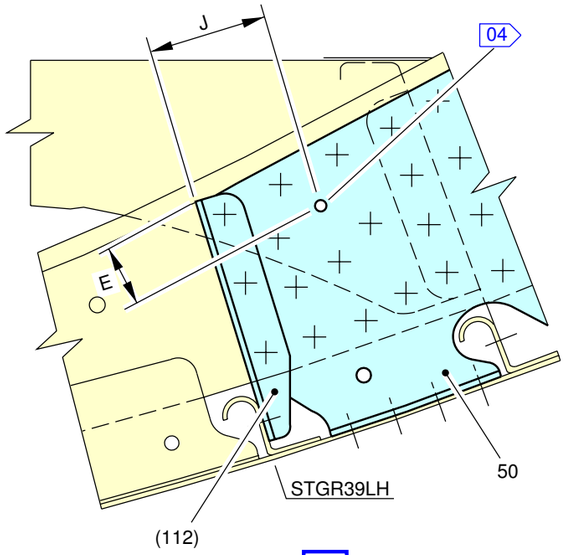
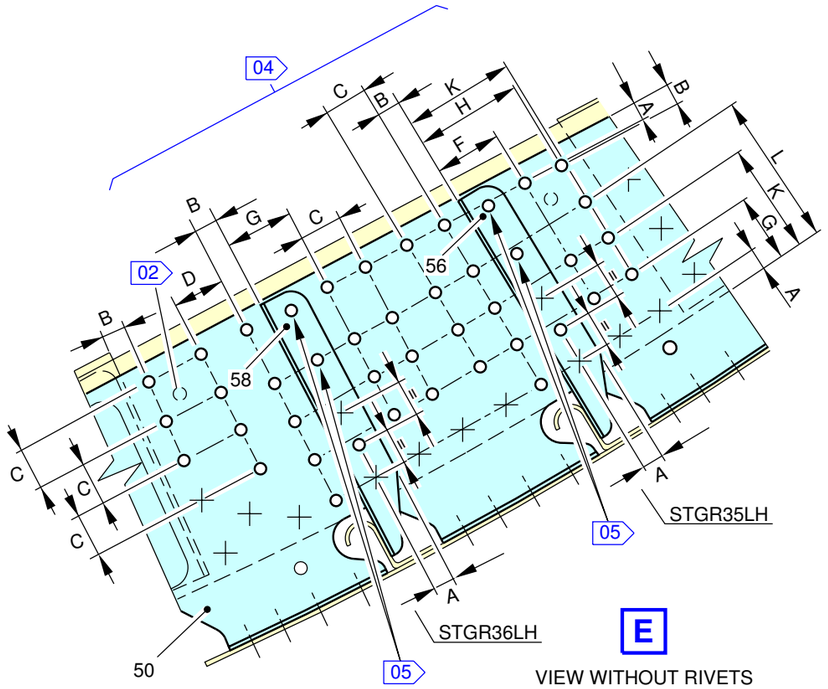
**CONF 001



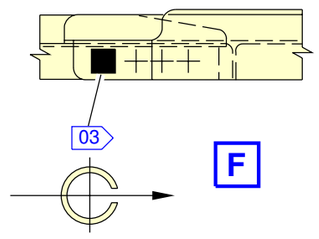
D

VIEW WITHOUT RIVETS



E

VIEW WITHOUT RIVETS



F

NOTE:

02 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

03 ■ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00

04 NEW HOLES

05 EXISTING PILOT HOLES

┼ EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 6

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	20.00	0.787
D	24.00	0.945
E	26.00	1.024
F	31.00	1.220
G	31.50	1.240
H	49.80	1.961
J	50.00	1.968
K	51.50	2.028
L	71.50	2.815

N_SB_531364_6_BNAA_03_01

Figure A-GBNAA - Sheet 03
Replacement of Webs and Angles at Frame 62

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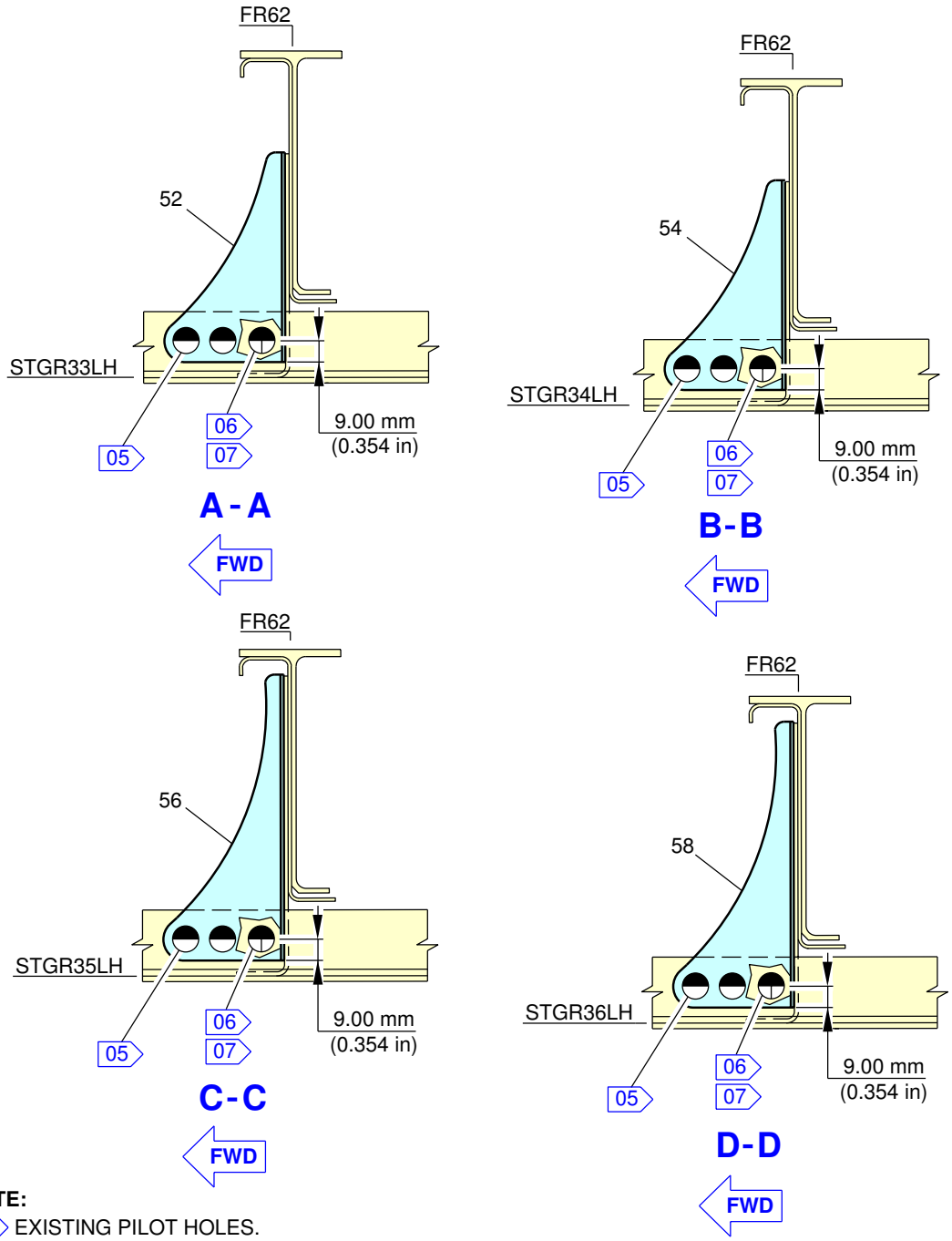
**CONF 001



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BNAA_04_01

Figure A-GBNAA - Sheet 04
Replacement of Webs and Angles at Frame 62

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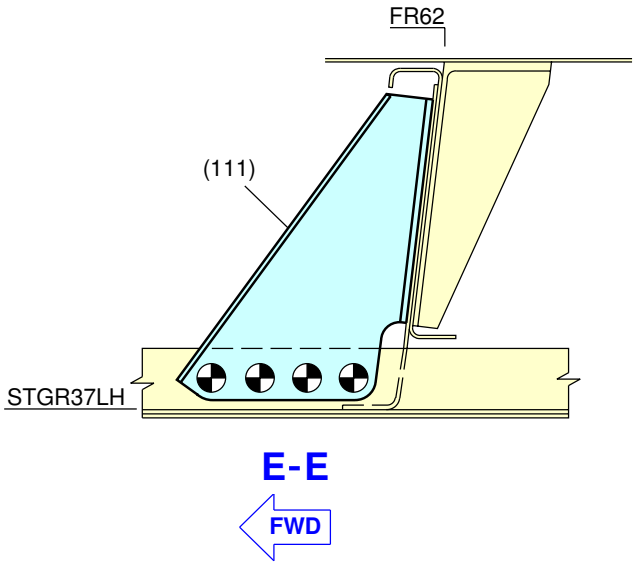
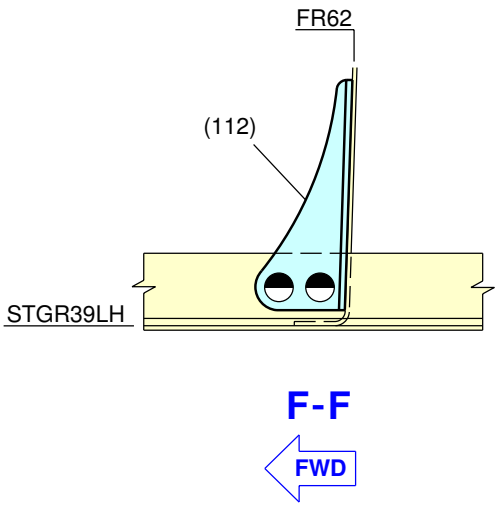
**CONF 001





NOTE:
FOR FASTENER SYMBOLS, REFER TO SHEET 6

N_SB_531364_6_BNAA_05_00

Figure A-GBNAA - Sheet 05
Replacement of Webs and Angles at Frame 62

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**CONF 001

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	864	DAN6–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BNAA_06_01

Figure A-GBNAA - Sheet 06
Replacement of Webs and Angles at Frame 62

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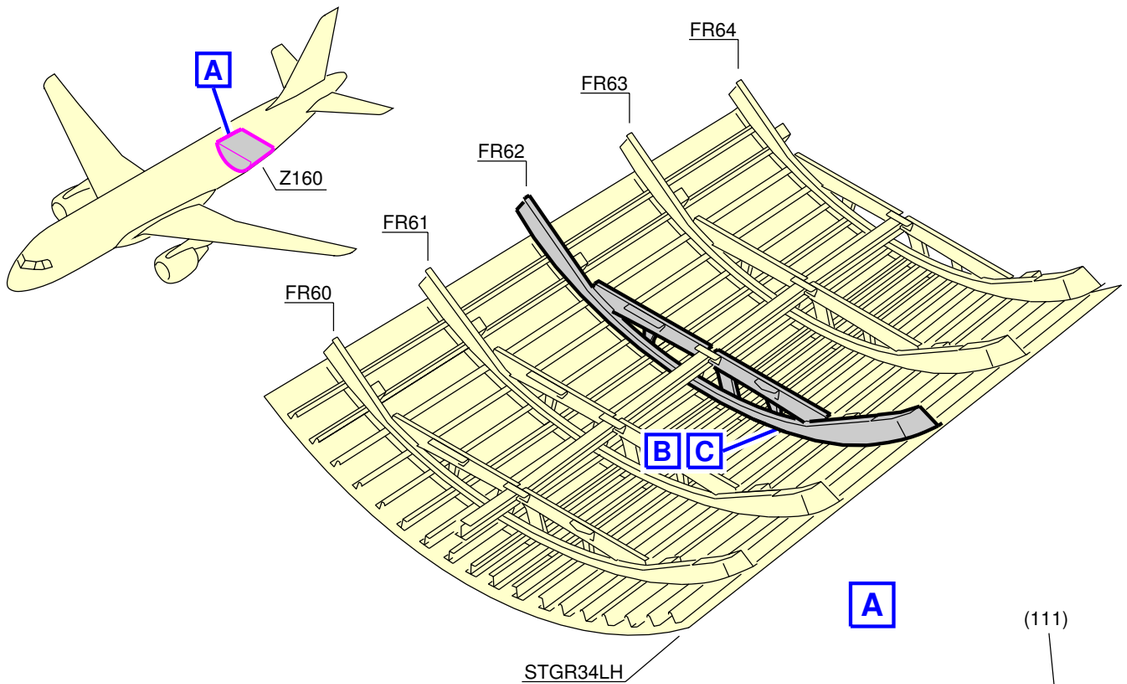
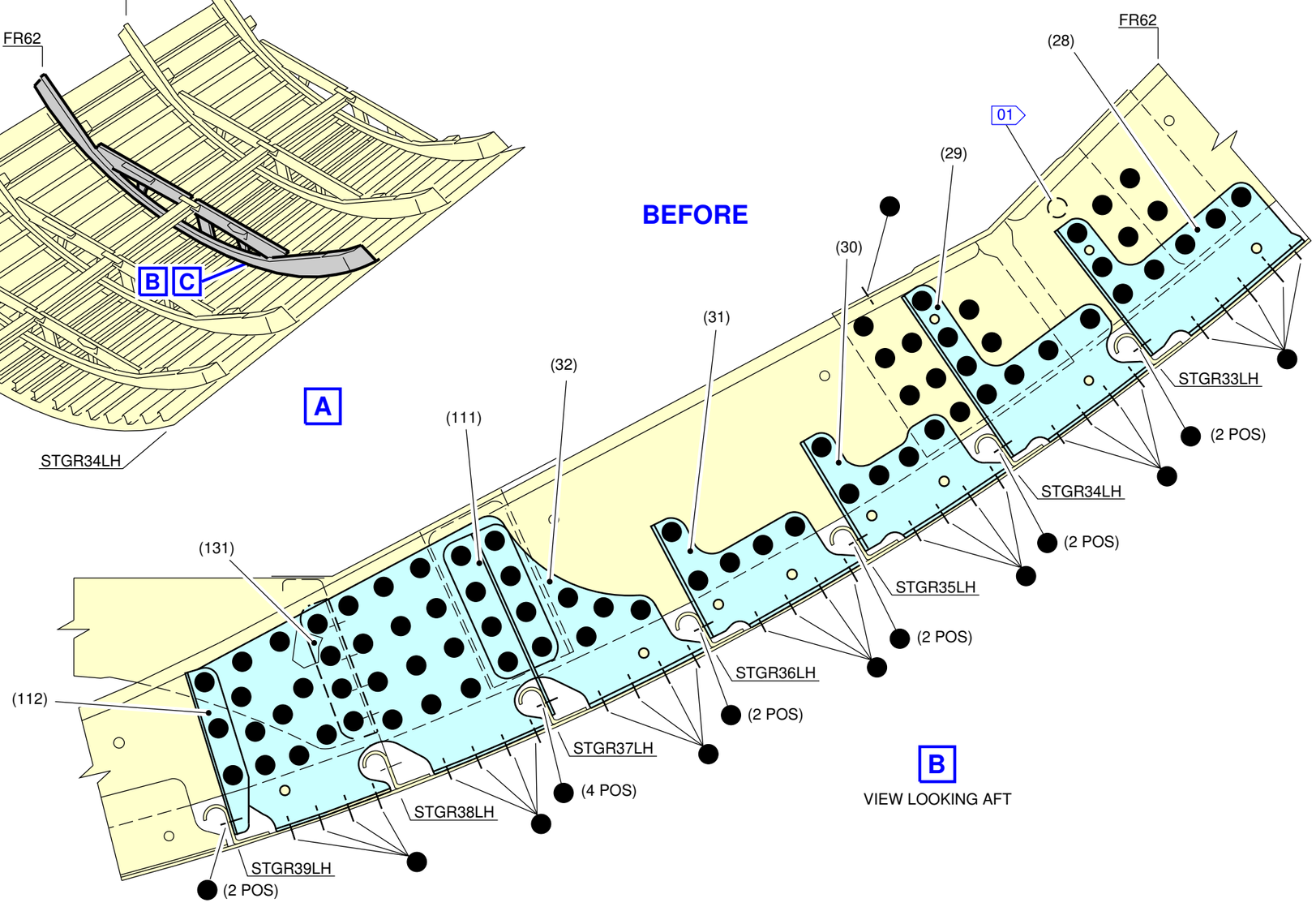
**CONF 002 thru 003





NOTE:

- REMOVE RIVETS, ITEM (100)
- 01 REMOVE RIVET IF INSTALLED, ITEM (100)

N_SB_531364_6_BNAB_01_00

Figure A-GBNAB - Sheet 01
Replacement of Webs and Angles at Frame 62

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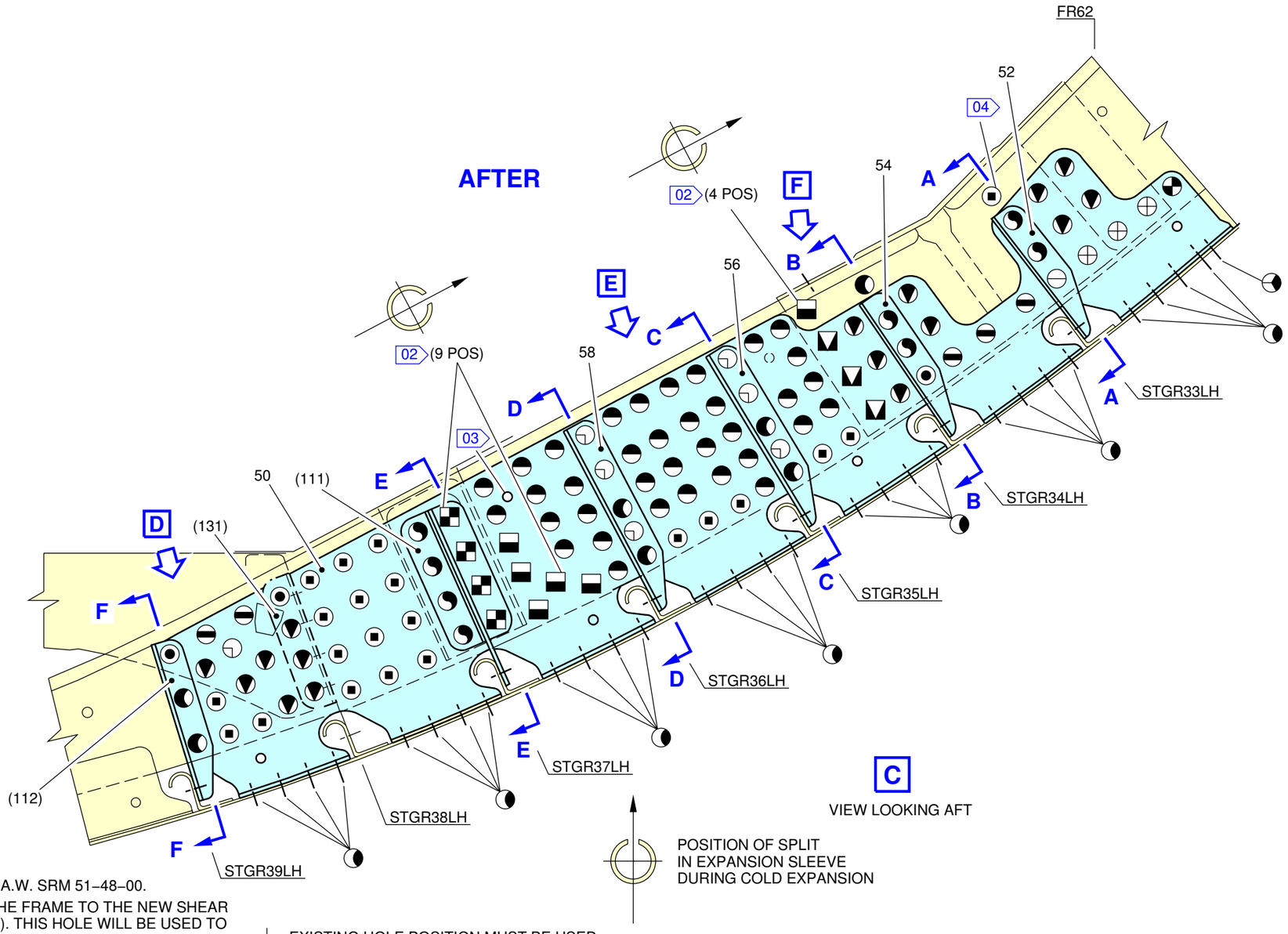
**CONF 002 thru 003



NOTE:

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

04 IF NECESSARY HOLE MUST BE CLOSED.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BNAB_02_01

Figure A-GBNAB - Sheet 02
Replacement of Webs and Angles at Frame 62

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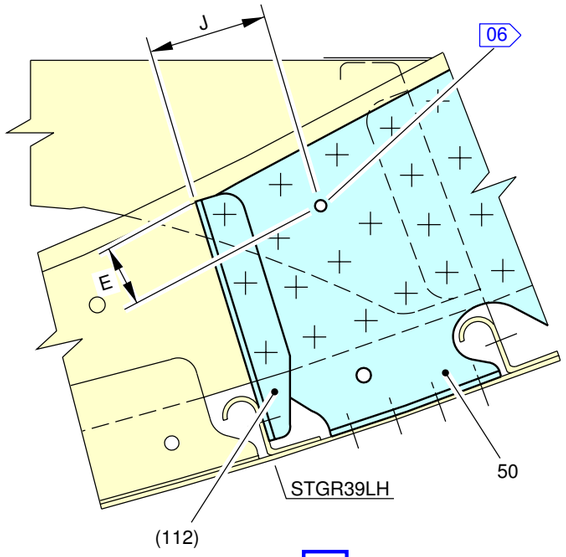
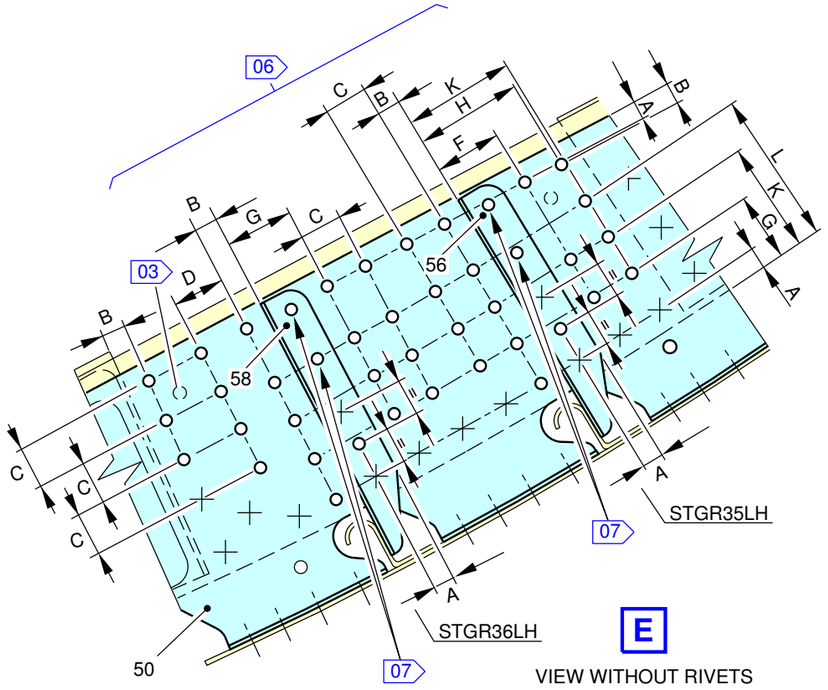
**CONF 002 thru 003



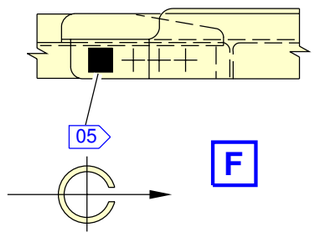
D

VIEW WITHOUT RIVETS



E

VIEW WITHOUT RIVETS



F

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	20.00	0.787
D	24.00	0.945
E	26.00	1.024
F	31.00	1.220
G	31.50	1.240
H	49.80	1.961
J	50.00	1.968
K	51.50	2.028
L	71.50	2.815

NOTE:

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

05 ■ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

06 NEW HOLES.

07 EXISTING PILOT HOLES.

┼ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BNAB_03_01

Figure A-GBNAB - Sheet 03
Replacement of Webs and Angles at Frame 62

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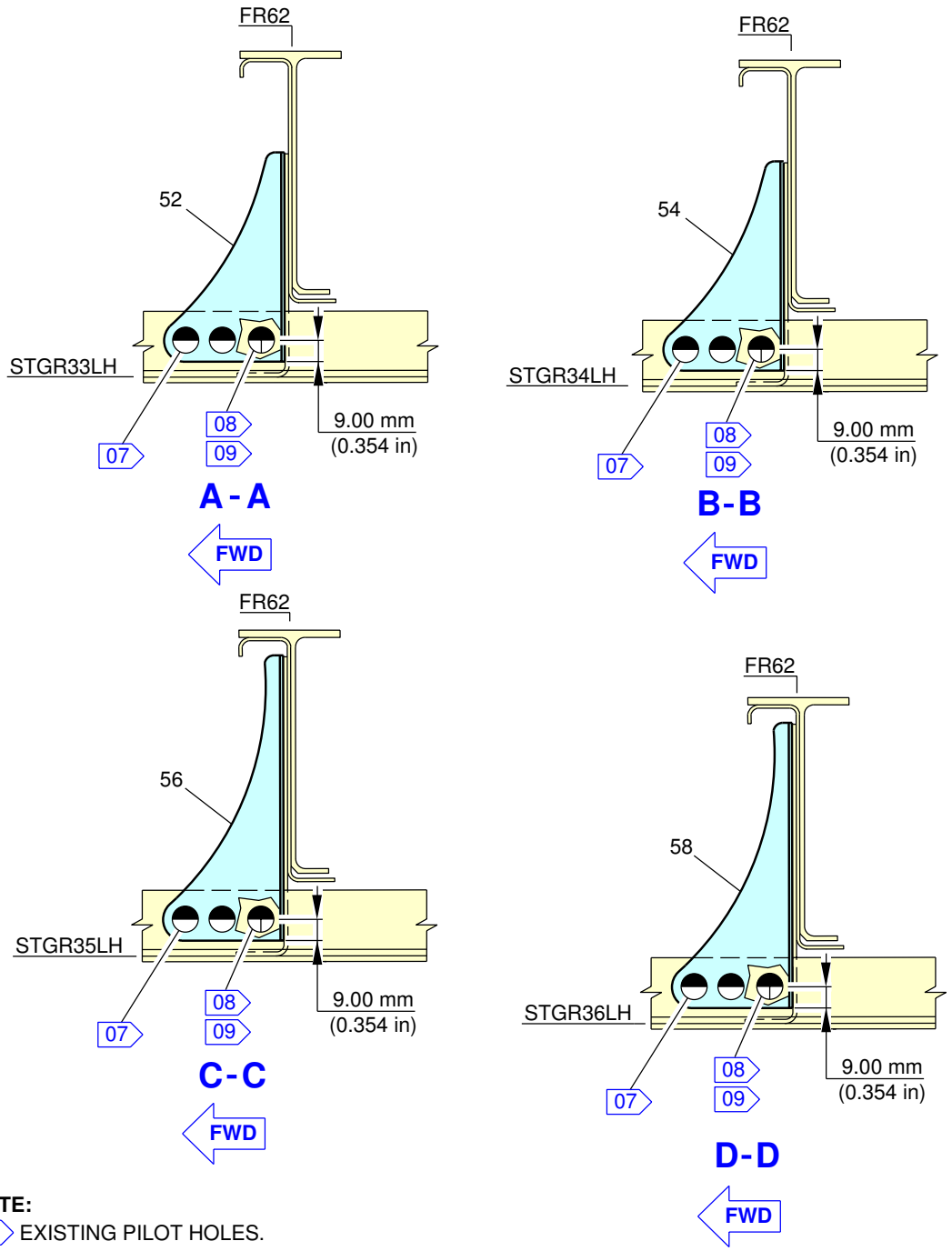
**CONF 002 thru 003



NOTE:

07 EXISTING PILOT HOLES.

08 COUNTERSINK EXISTING HOLE IN THE STRINGER.

09 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BNAB_04_01

Figure A-GBNAB - Sheet 04
Replacement of Webs and Angles at Frame 62

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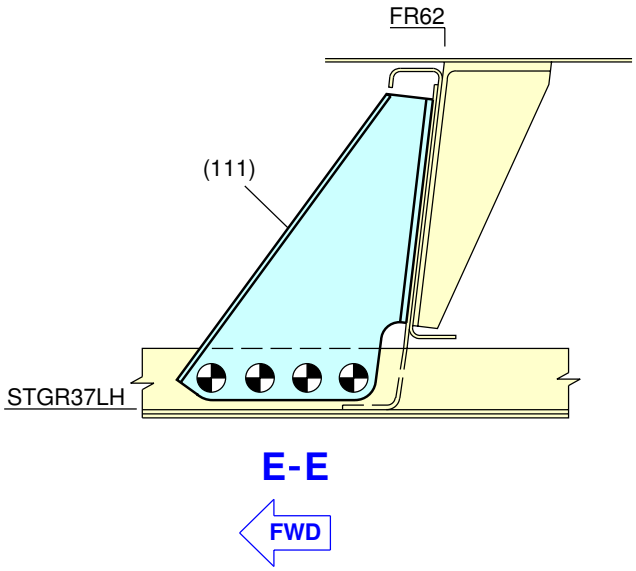
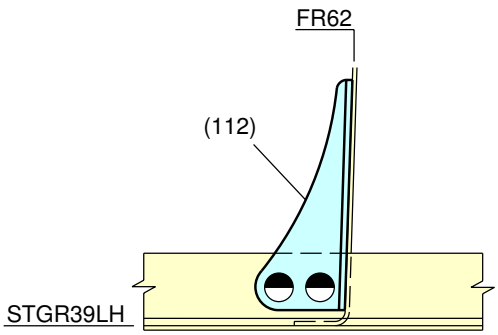
****CONF 002 thru 003**



E-E

FWD



F-F

FWD

NOTE:

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BNAB_05_00

Figure A-GBNAB - Sheet 05
Replacement of Webs and Angles at Frame 62

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**CONF 002 thru 003

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	568	EN6069D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE

N_SB_531364_6_BNAB_06_01

Figure A-GBNAB - Sheet 06
Replacement of Webs and Angles at Frame 62

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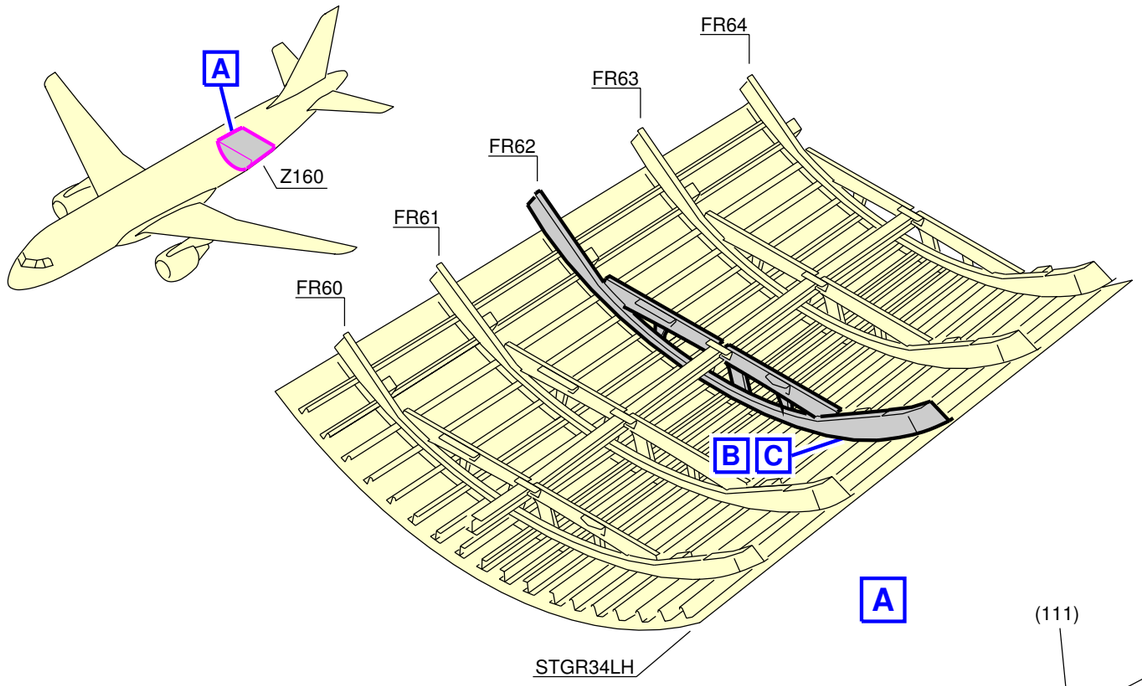
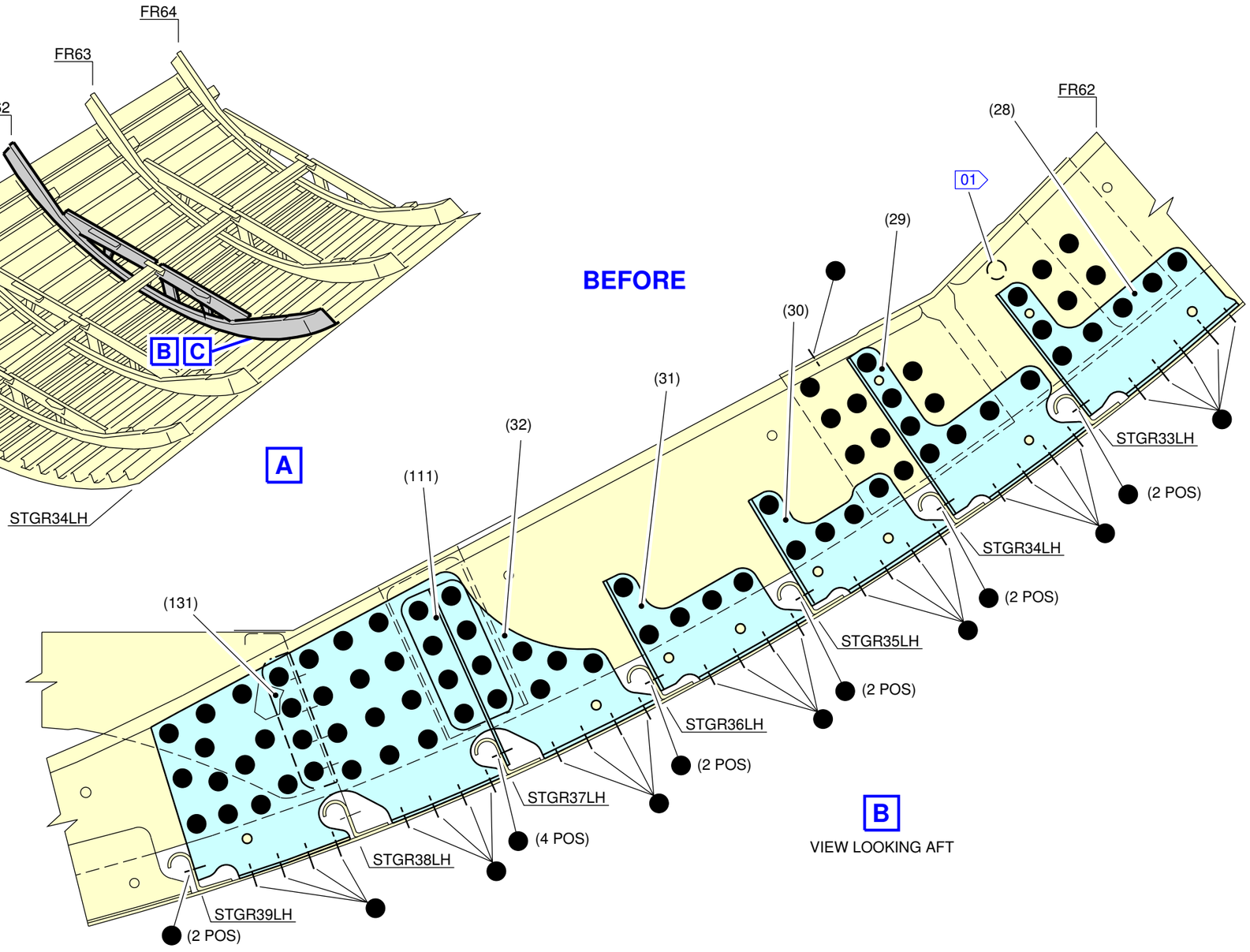
**CONF 004, 006





NOTE:

- ● REMOVE RIVETS, ITEM (100)
- 01 ◌ REMOVE RIVET IF INSTALLED, ITEM (100)

N_SB_531364_6_BNAD_01_00

Figure A-GBNAD - Sheet 01
Replacement of Webs and Angles at Frame 62

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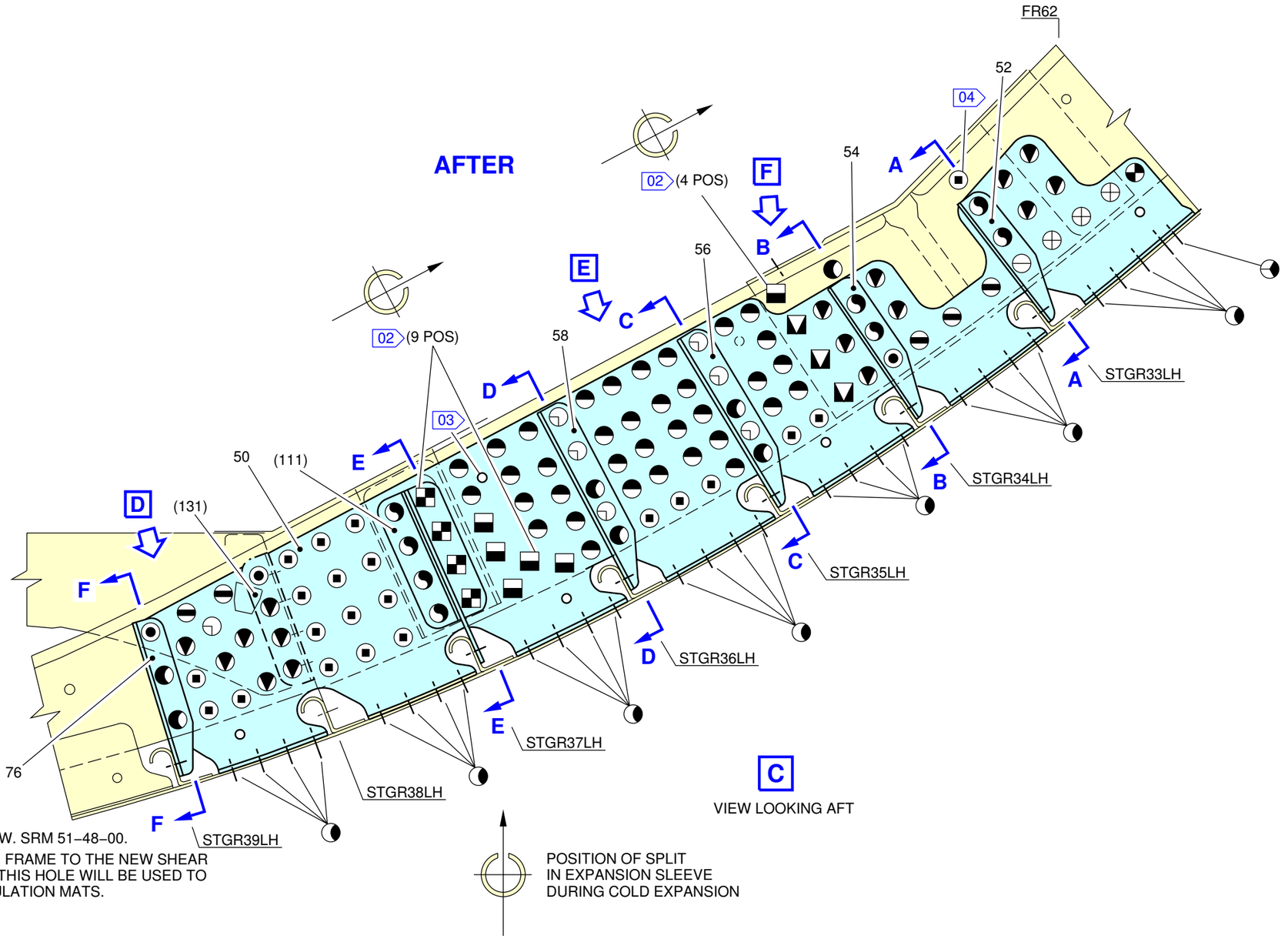
**CONF 004, 006



NOTE:

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

04 IF NECESSARY HOLE MUST BE CLOSED.

EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BNAD_02_01

Figure A-GBNAD - Sheet 02
Replacement of Webs and Angles at Frame 62

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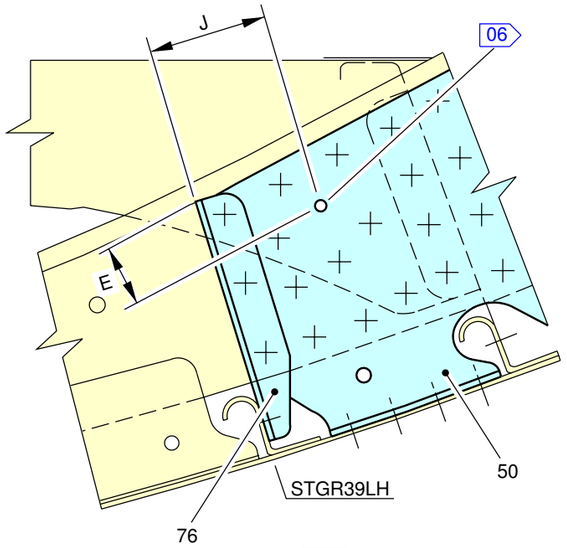
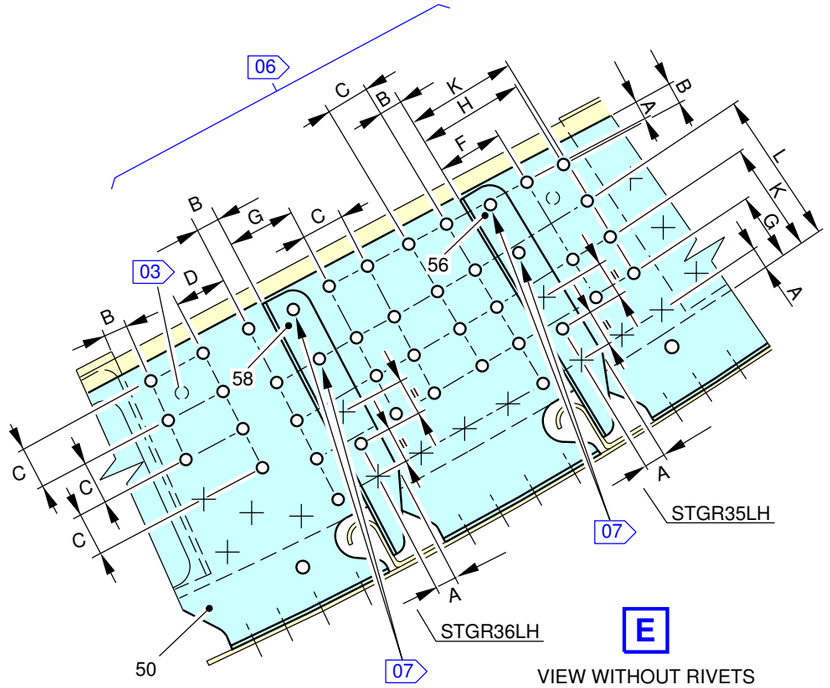
**CONF 004, 006



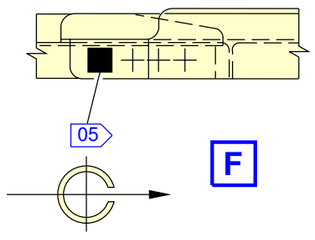
D

VIEW WITHOUT RIVETS



E

VIEW WITHOUT RIVETS



F

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	20.00	0.787
D	24.00	0.945
E	26.00	1.024
F	31.00	1.220
G	31.50	1.240
H	49.80	1.961
J	50.00	1.968
K	51.50	2.028
L	71.50	2.815

NOTE:

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

05 ■ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

06 NEW HOLES.

07 EXISTING PILOT HOLES.

┼ EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BNAD_03_01

Figure A-GBNAD - Sheet 03
Replacement of Webs and Angles at Frame 62

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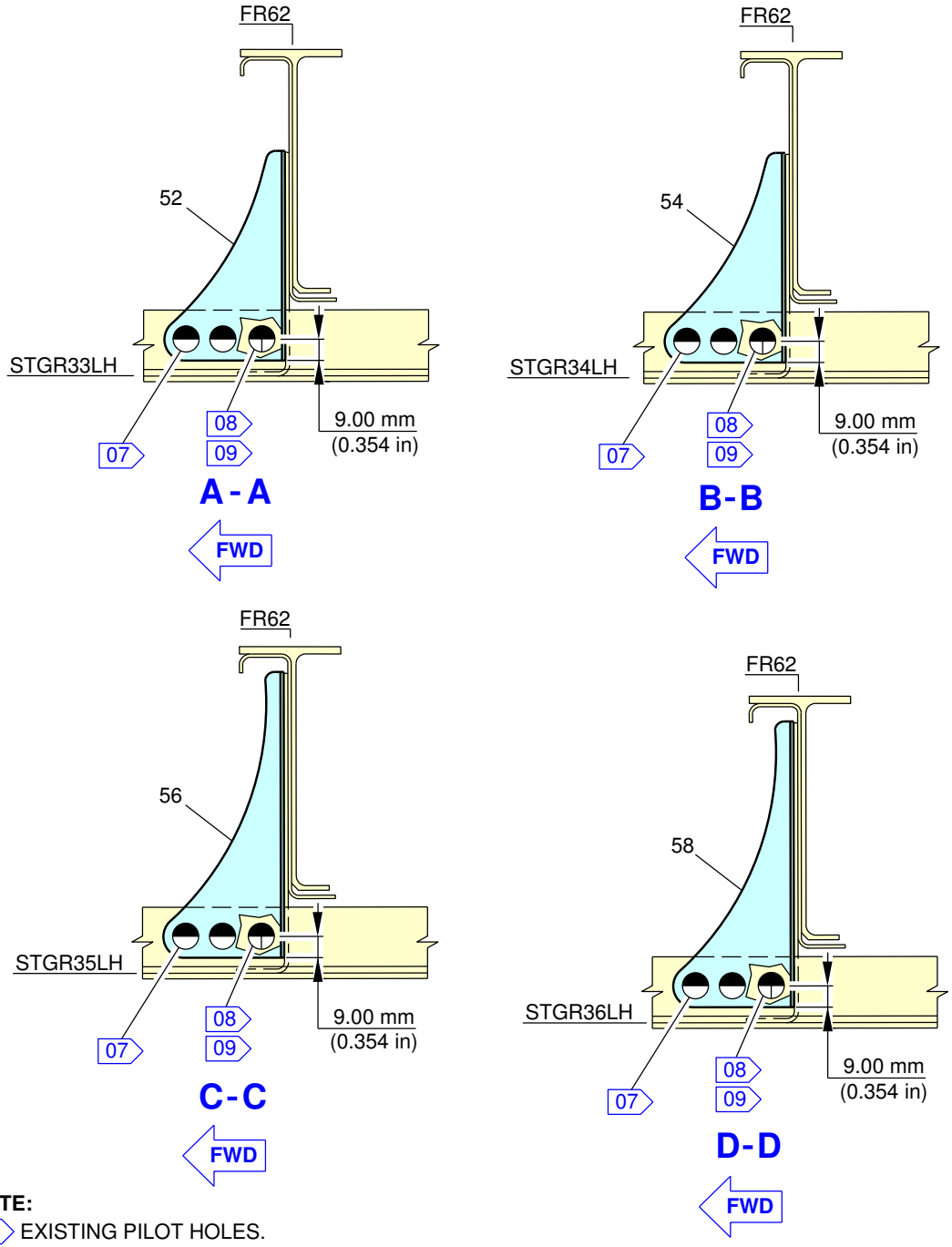
****CONF 004, 006**



NOTE:

07 EXISTING PILOT HOLES.

08 COUNTERSINK EXISTING HOLE IN THE STRINGER.

09 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BNAD_04_01

Figure A-GBNAD - Sheet 04
Replacement of Webs and Angles at Frame 62

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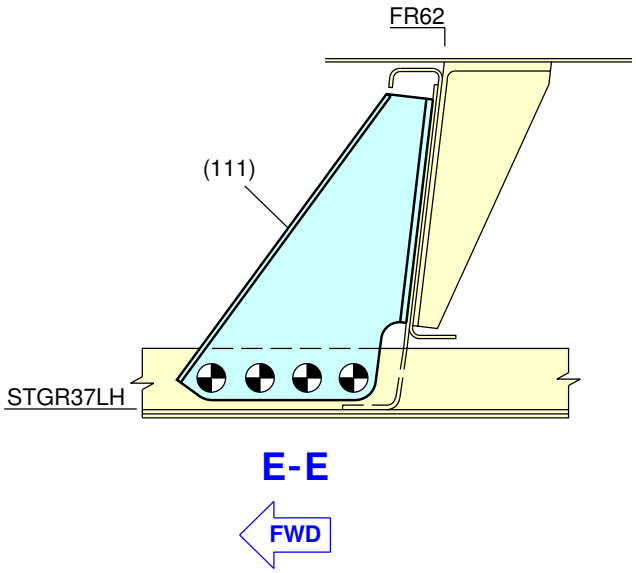
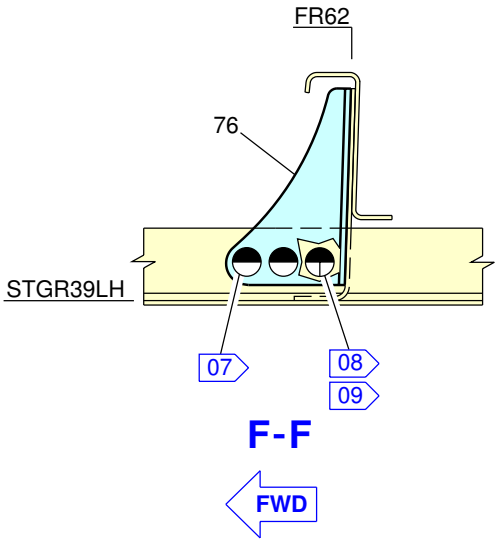
****CONF 004, 006**





NOTE:

07 EXISTING PILOT HOLES.

08 COUNTERSINK EXISTING HOLE IN THE STRINGER.

09 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BNAD_05_01

Figure A-GBNAD - Sheet 05
Replacement of Webs and Angles at Frame 62

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**CONF 004, 006

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	568	EN6069D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BNAD_06_01

Figure A-GBNAD - Sheet 06
Replacement of Webs and Angles at Frame 62

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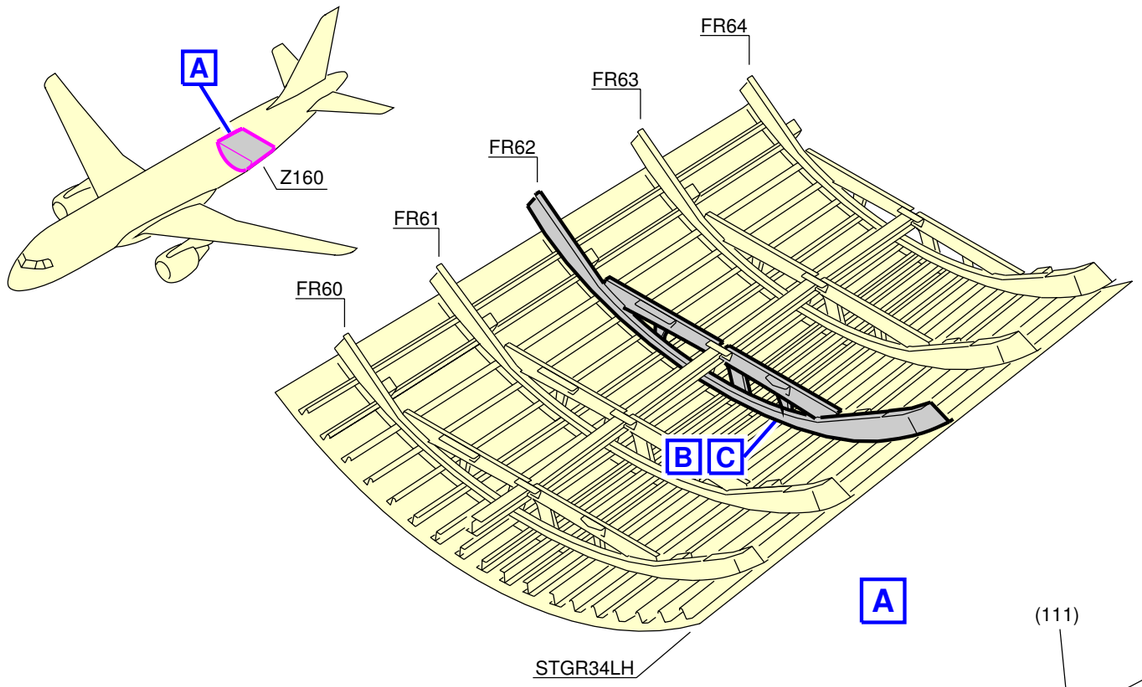
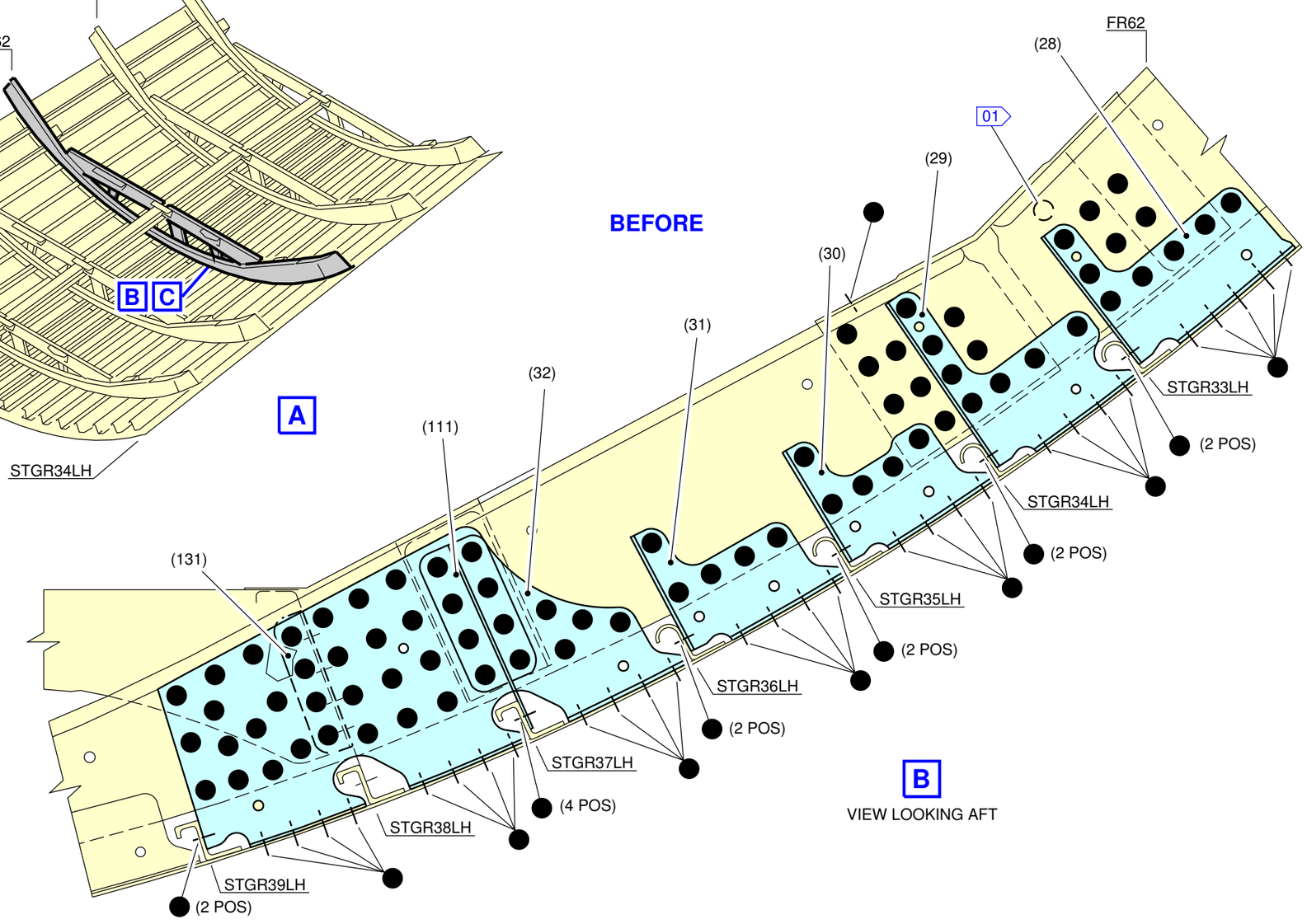
**CONF 005, 007





NOTE:

- REMOVE RIVETS, ITEM (100)
- 01 REMOVE RIVET IF INSTALLED, ITEM (100)

N_SB_531364_6_BNAE_01_00

Figure A-GBNAE - Sheet 01
Replacement of Webs and Angles at Frame 62

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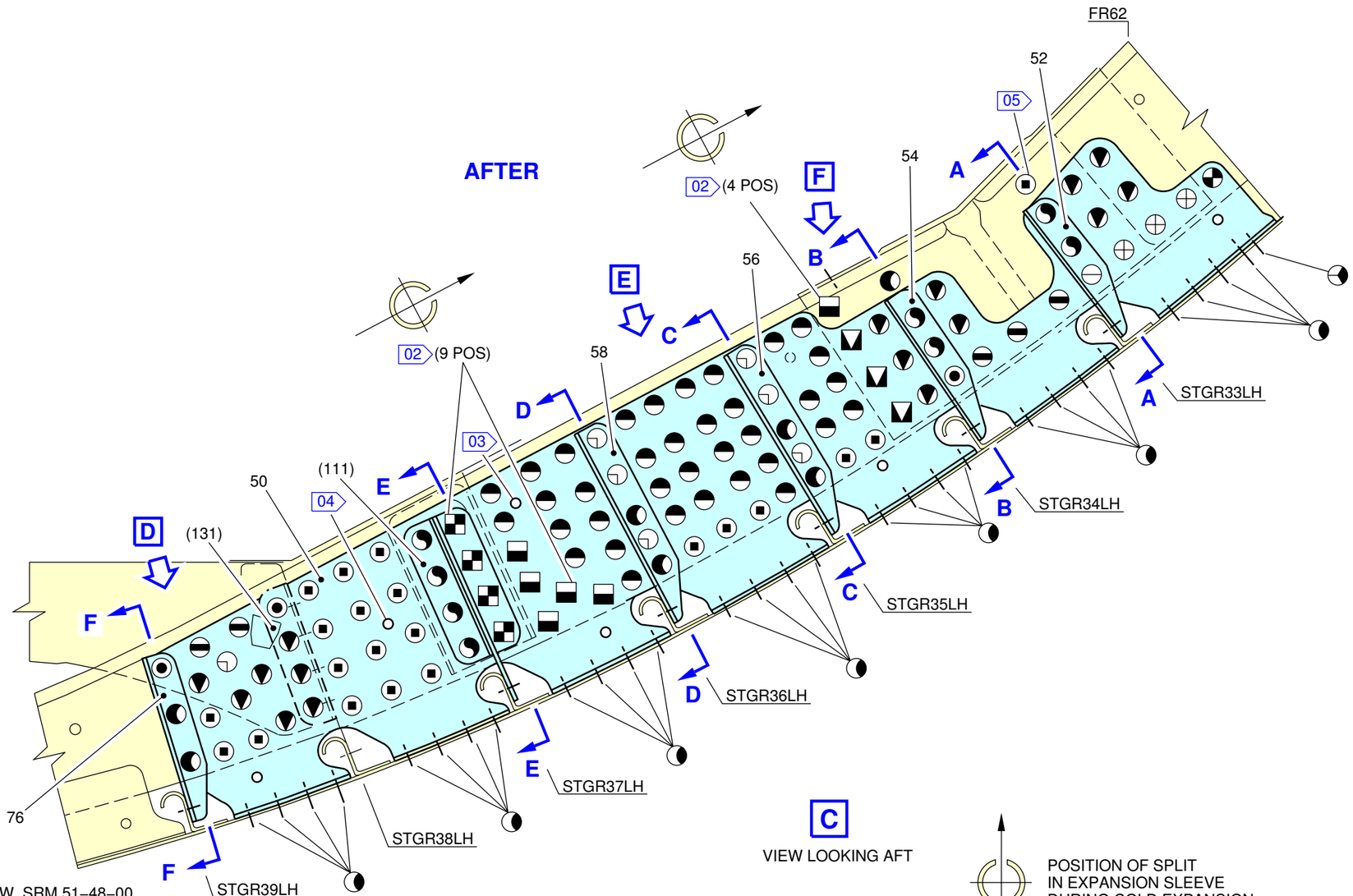
**CONF 005, 007



NOTE:

02 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in).

05 IF NECESSARY HOLE MUST BE CLOSED

Figure A-GBNAE - Sheet 02
Replacement of Webs and Angles at Frame 62

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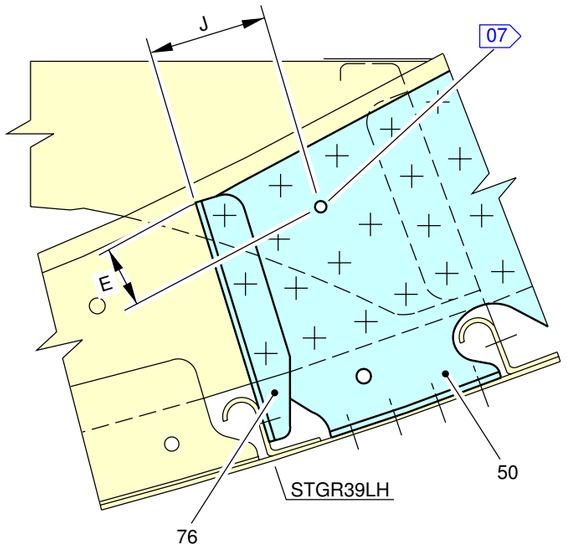
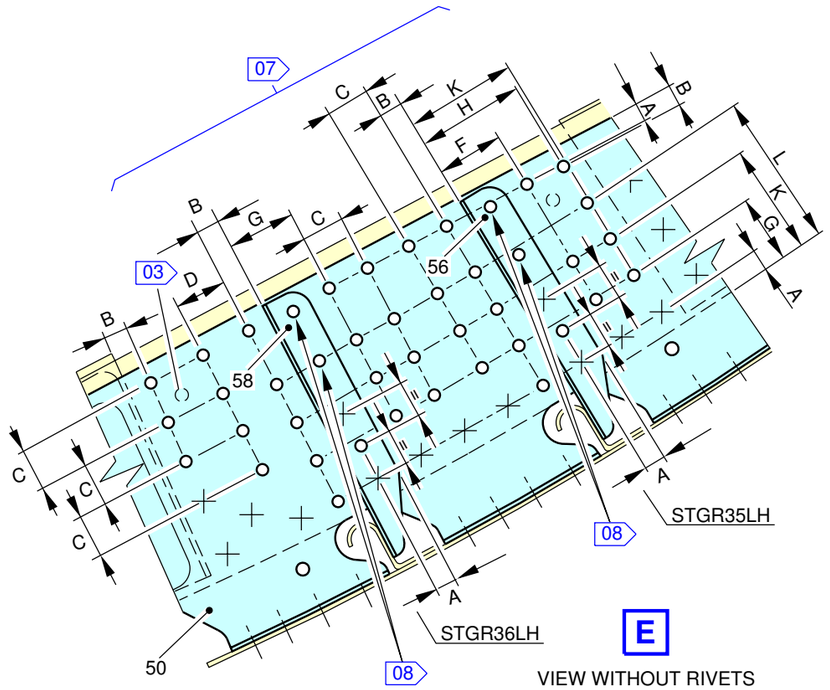
**CONF 005, 007



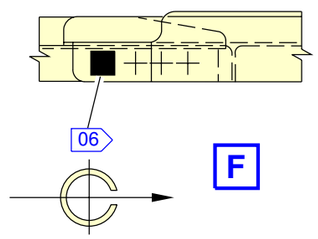
D

VIEW WITHOUT RIVETS



E

VIEW WITHOUT RIVETS



F

NOTE:

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

06 ■ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00

07 NEW HOLES

08 EXISTING PILOT HOLES

┼ EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 6

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	20.00	0.787
D	24.00	0.945
E	26.00	1.024
F	31.00	1.220
G	31.50	1.240
H	49.80	1.961
J	50.00	1.968
K	51.50	2.028
L	71.50	2.815

N_SB_531364_6_BNAE_03_01

Figure A-GBNAE - Sheet 03
Replacement of Webs and Angles at Frame 62

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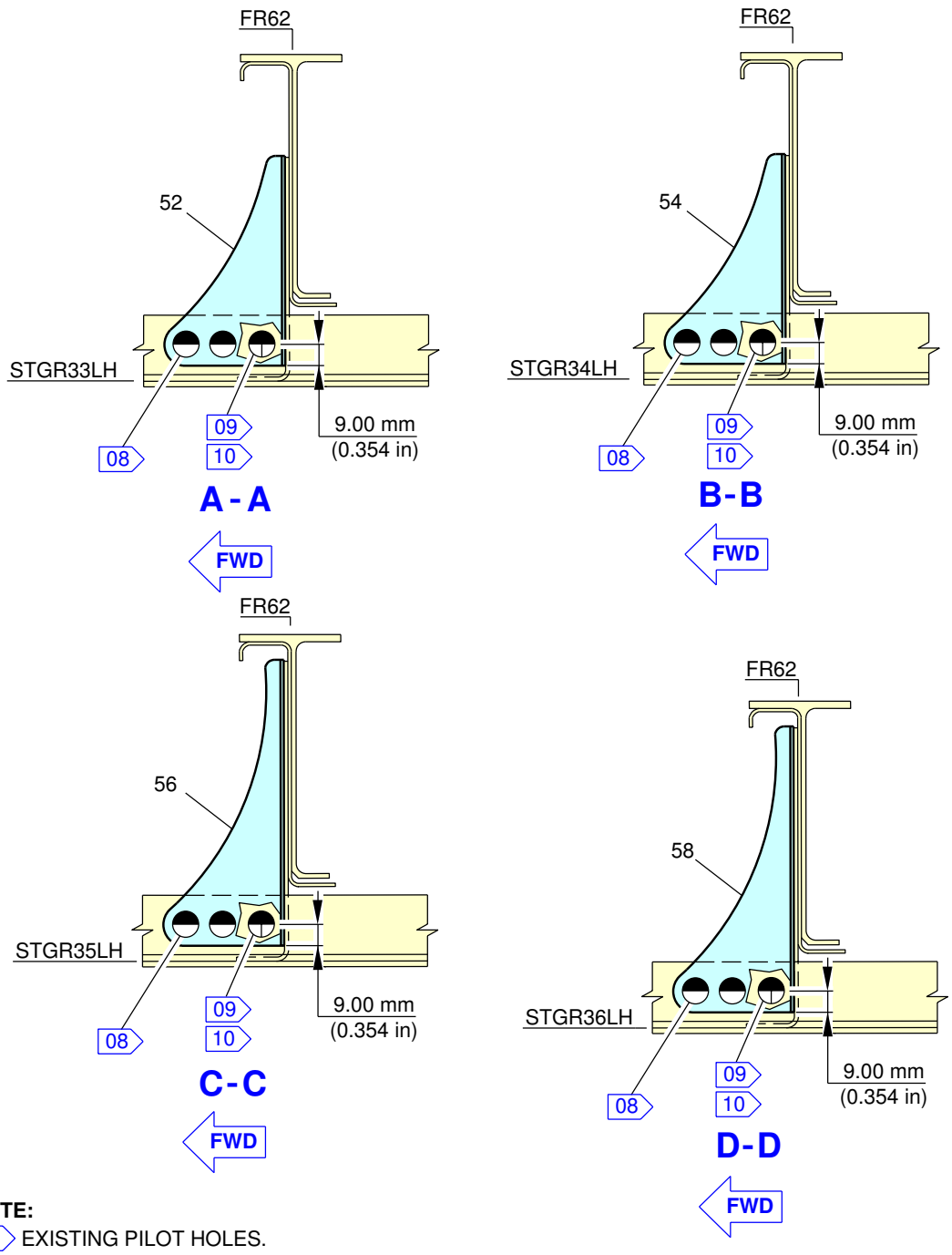
**CONF 005, 007



NOTE:

08 EXISTING PILOT HOLES.

09 COUNTERSINK EXISTING HOLE IN THE STRINGER.

10 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BNAE_04_01

Figure A-GBNAE - Sheet 04
Replacement of Webs and Angles at Frame 62

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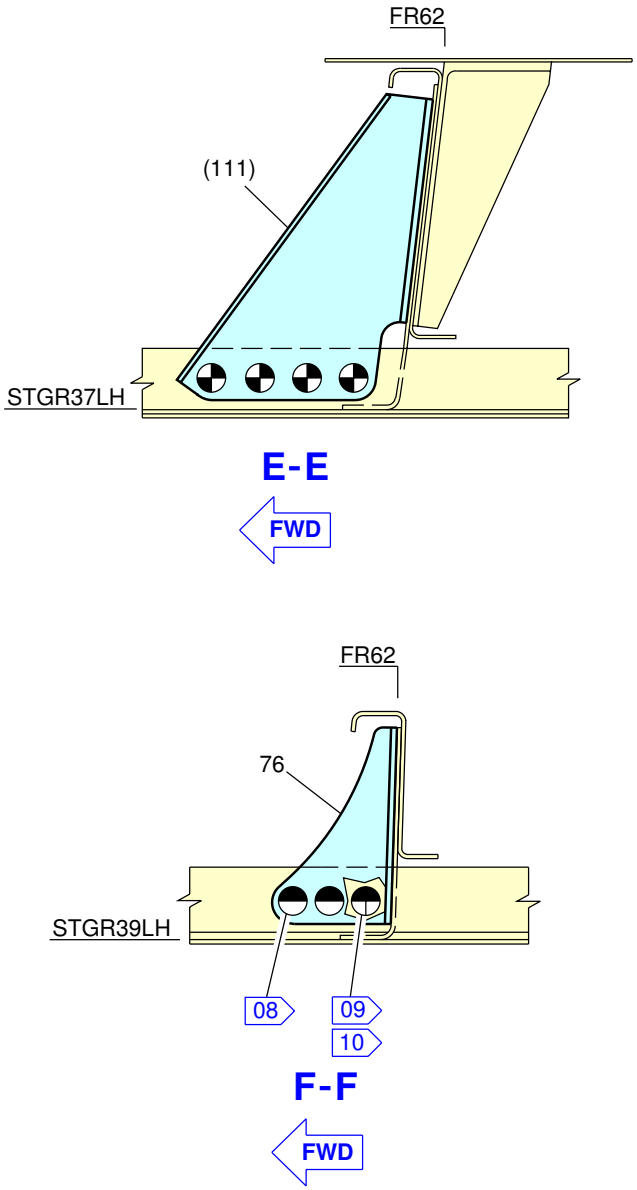
**CONF 005, 007



NOTE:

08 EXISTING PILOT HOLES.

09 COUNTERSINK EXISTING HOLE IN THE STRINGER.

10 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BNAE_05_01

Figure A-GBNAE - Sheet 05
Replacement of Webs and Angles at Frame 62

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**CONF 005, 007

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	568	EN6069D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BNAE_06_01

Figure A-GBNAE - Sheet 06
Replacement of Webs and Angles at Frame 62

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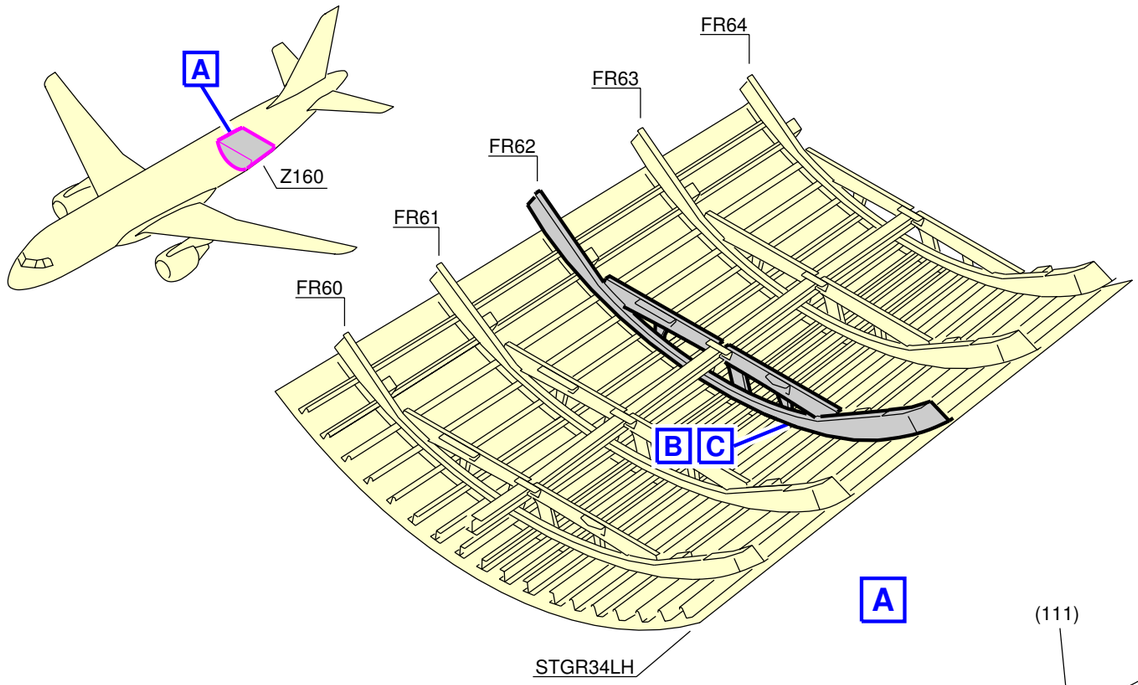
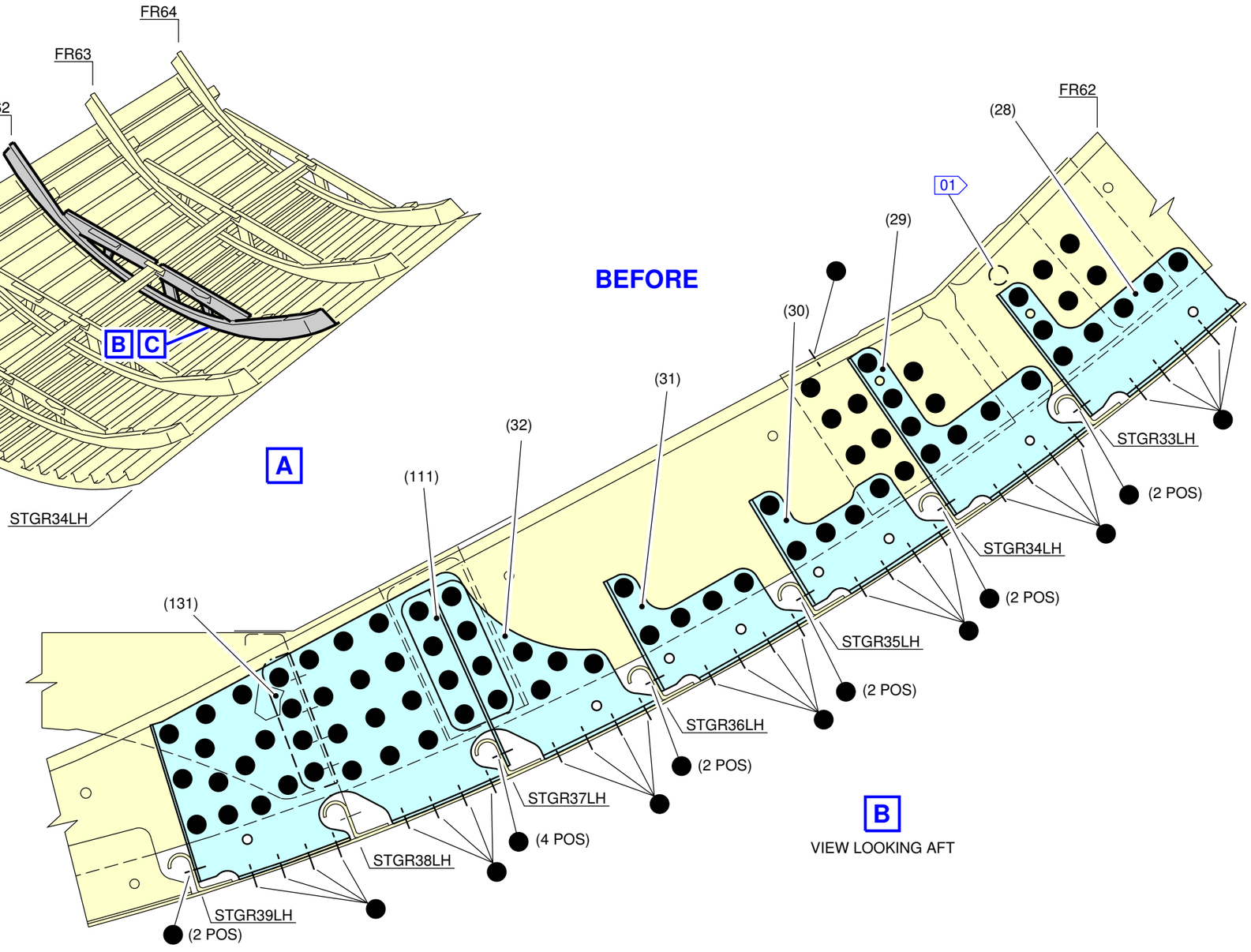
**CONF 008





NOTE:

- REMOVE RIVETS, ITEM (100)
- 01 REMOVE RIVET IF INSTALLED, ITEM (100)

N_SB_531364_6_BNAH_01_00

Figure A-GBNAH - Sheet 01
Replacement of Webs and Angles at Frame 62

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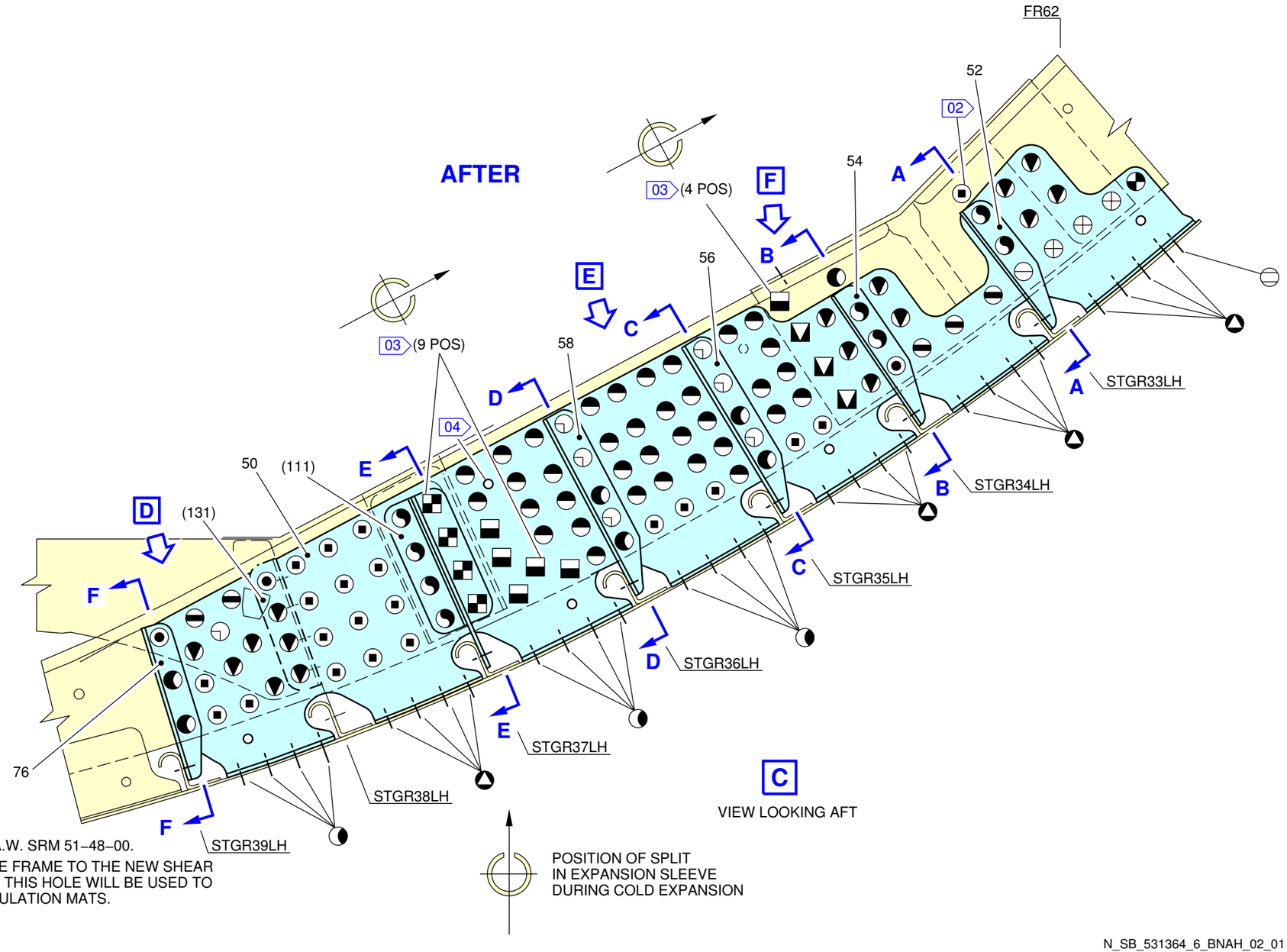
**CONF 008



NOTE:

02 IF NECESSARY HOLE MUST BE CLOSED.

03 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BNAH_02_01

Figure A-GBNAH - Sheet 02
Replacement of Webs and Angles at Frame 62

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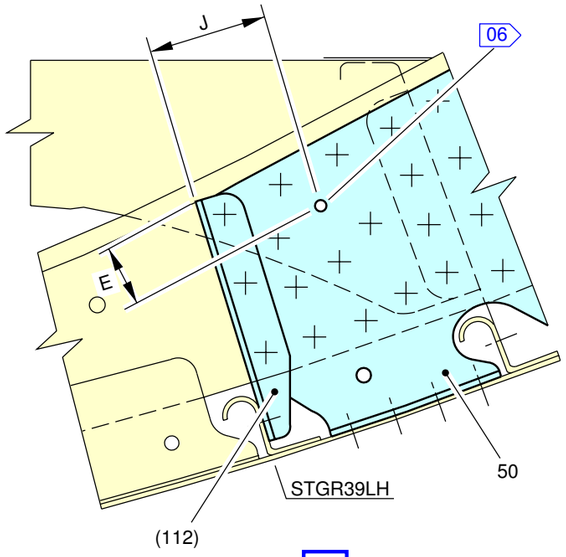
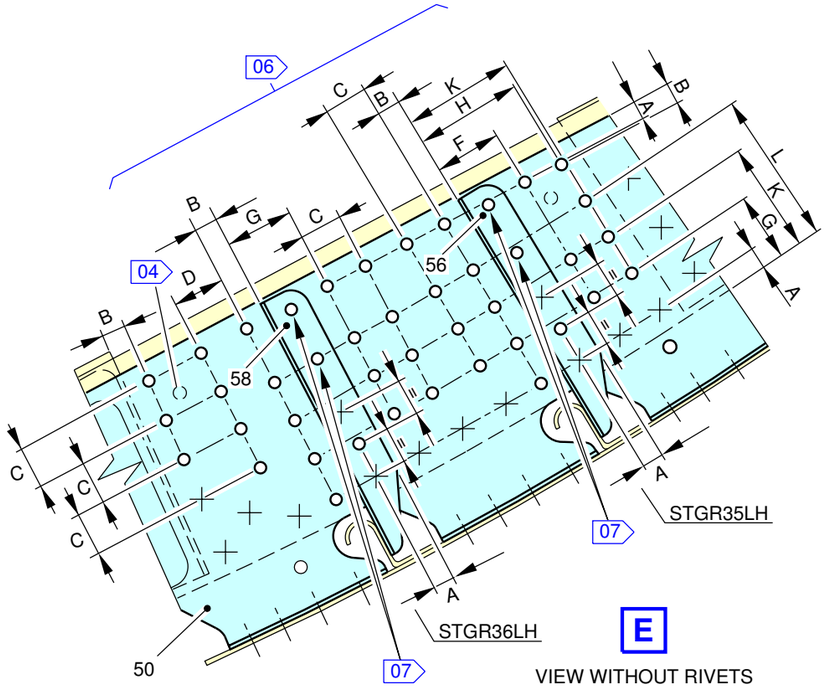
**CONF 008



D

VIEW WITHOUT RIVETS



E

VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	20.00	0.787
D	24.00	0.945
E	26.00	1.024
F	31.00	1.220
G	31.50	1.240
H	49.80	1.961
J	50.00	1.968
K	51.50	2.028
L	71.50	2.815

NOTE:

04 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

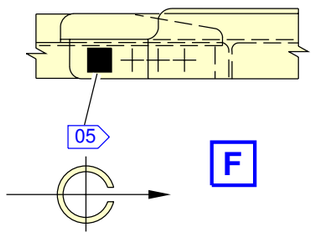
05 ■ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

06 NEW HOLES.

07 EXISTING PILOT HOLES.

┼ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.



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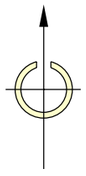

POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

N_SB_531364_6_BNAH_03_01

Figure A-GBNAH - Sheet 03
Replacement of Webs and Angles at Frame 62

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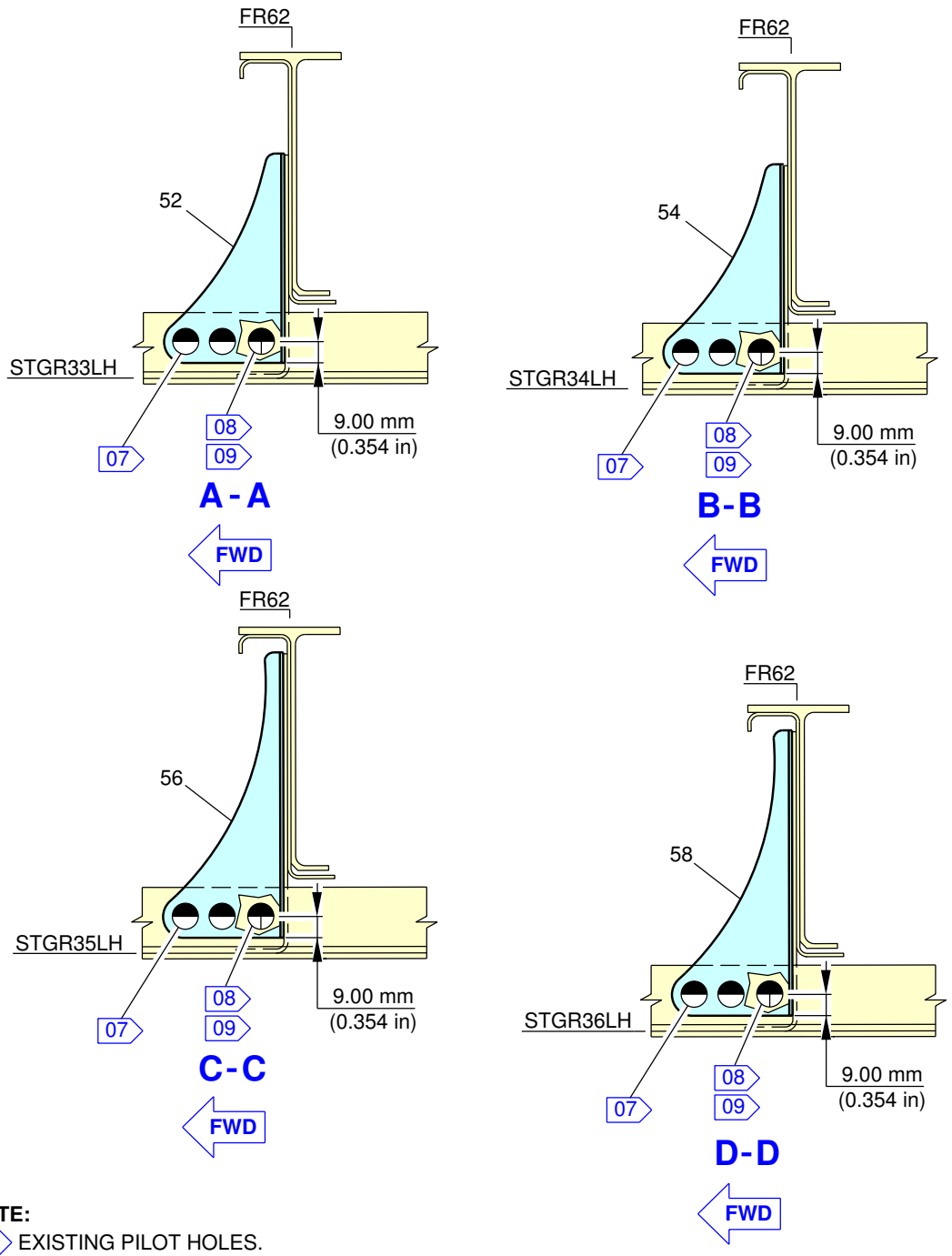
**CONF 008



NOTE:

07 EXISTING PILOT HOLES.

08 COUNTERSINK EXISTING HOLE IN THE STRINGER.

09 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BNAH_04_01

Figure A-GBNAH - Sheet 04
Replacement of Webs and Angles at Frame 62

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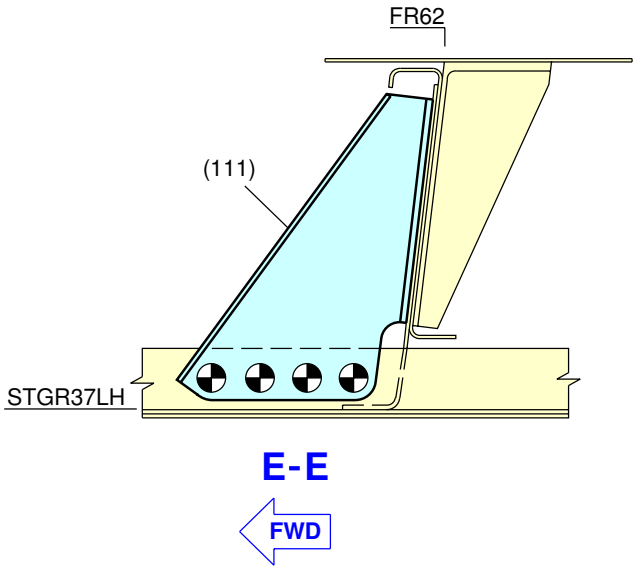
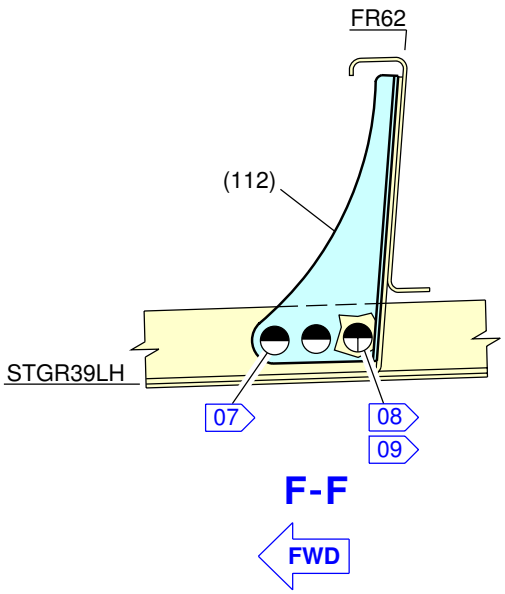
**CONF 008





NOTE:

07 EXISTING PILOT HOLES.

08 COUNTERSINK EXISTING HOLE IN THE STRINGER.

09 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BNAH_05_01

Figure A-GBNAH - Sheet 05
Replacement of Webs and Angles at Frame 62

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**CONF 008

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	568	EN6069D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	864	DAN6–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BNAH_06_01

Figure A-GBNAH - Sheet 06
Replacement of Webs and Angles at Frame 62

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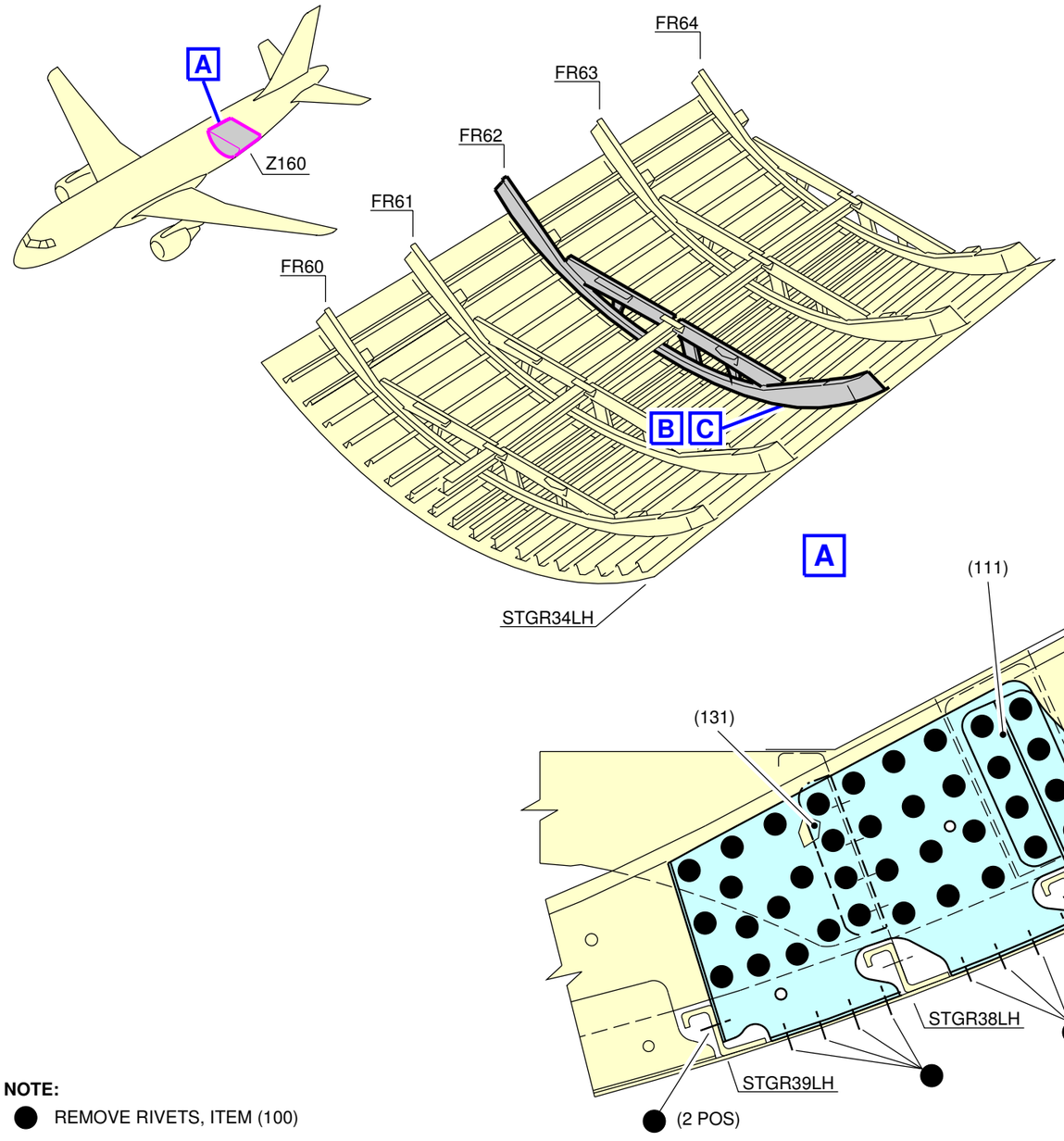
**CONF 009



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BNAJ_01_00

Figure A-GBNAJ - Sheet 01
Replacement of Webs and Angles at Frame 62

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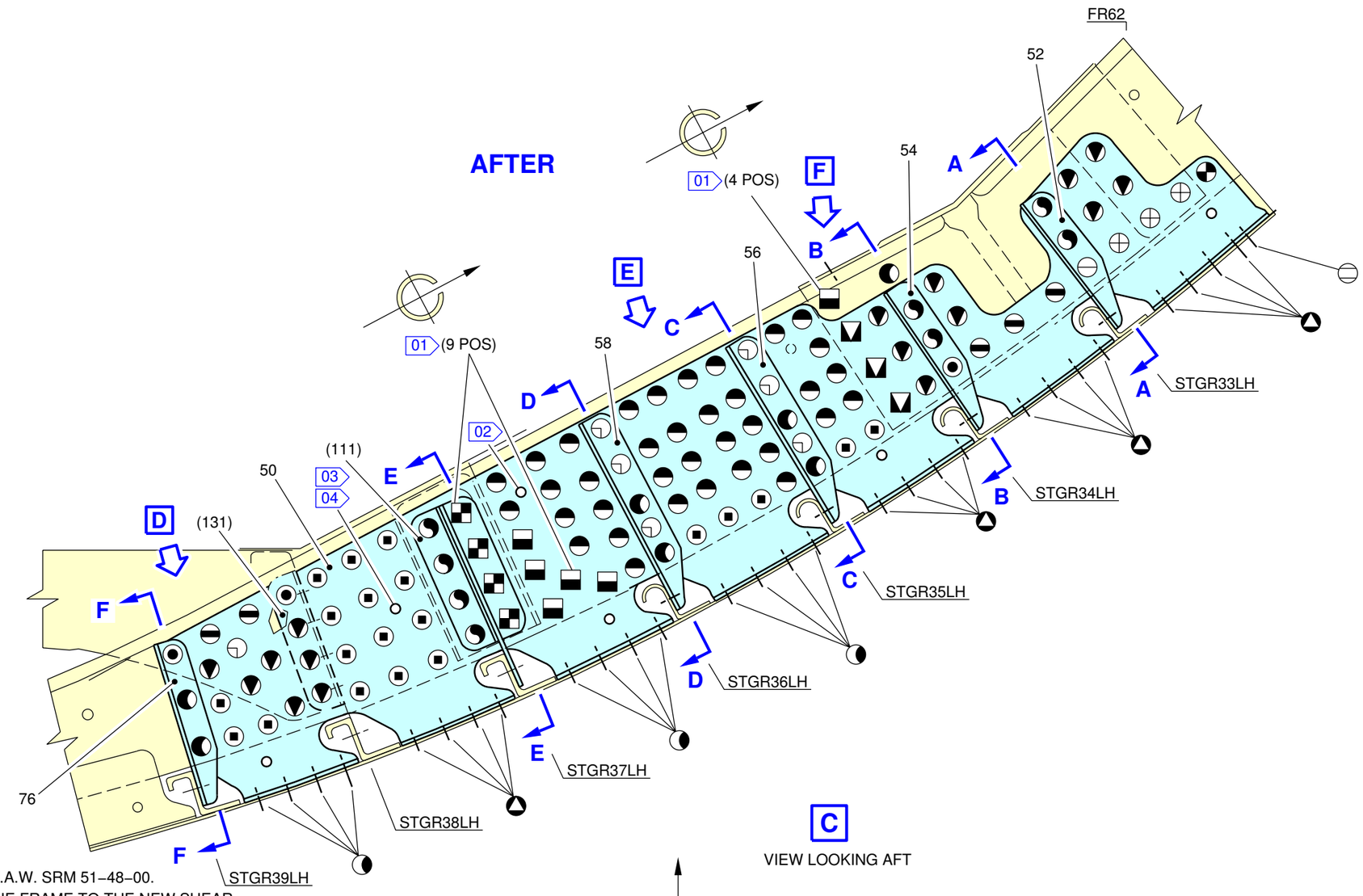
**CONF 009



NOTE:

01 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

02 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in).

04 VALID FOR MSN 4005 AND SUBSEQUENT.

+ EXISTING HOLE POSITION MUST BE USED FOR FASTENER SYMBOLS, REFER TO SHEET 6.

C
VIEW LOOKING AFT

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

N_SB_531364_6_BNAJ_02_01

Figure A-GBNAJ - Sheet 02
Replacement of Webs and Angles at Frame 62

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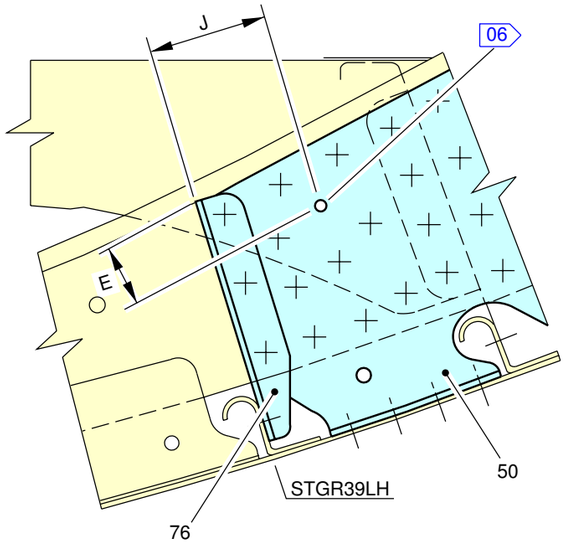
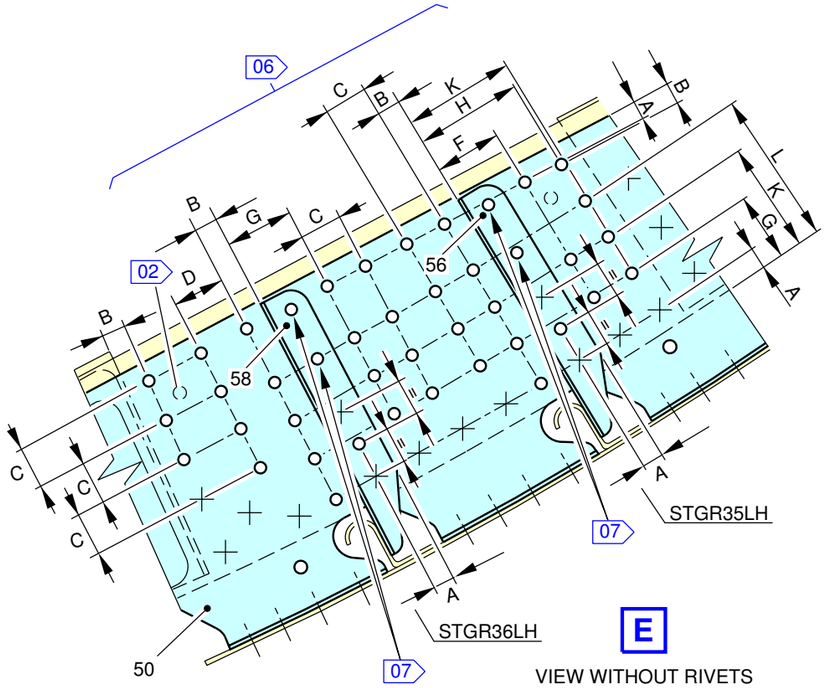
**CONF 009



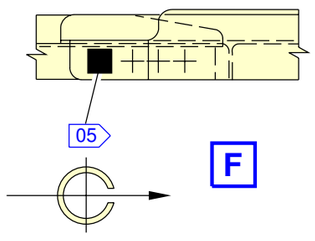
D

VIEW WITHOUT RIVETS



E

VIEW WITHOUT RIVETS



F

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	20.00	0.787
D	24.00	0.945
E	26.00	1.024
F	31.00	1.220
G	31.50	1.240
H	49.80	1.961
J	50.00	1.968
K	51.50	2.028
L	71.50	2.815

NOTE:

02 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

05 ■ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

06 NEW HOLES.

07 EXISTING PILOT HOLES.

┼ EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BNAJ_03_01

Figure A-GBNAJ - Sheet 03
Replacement of Webs and Angles at Frame 62

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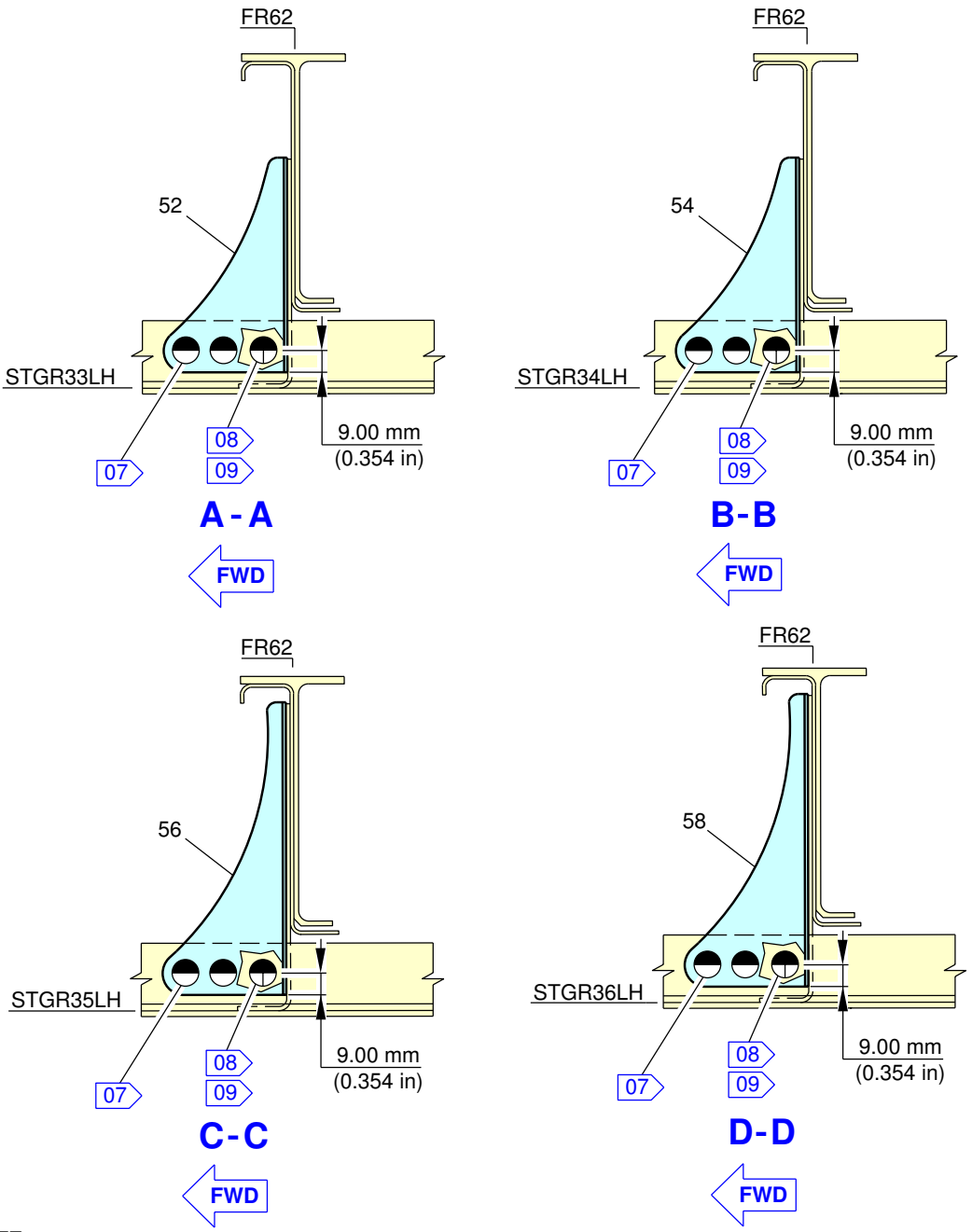
**CONF 009



NOTE:

07 EXISTING PILOT HOLES.

08 COUNTERSINK EXISTING HOLE IN THE STRINGER.

09 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BNAJ_04_01

Figure A-GBNAJ - Sheet 04
Replacement of Webs and Angles at Frame 62

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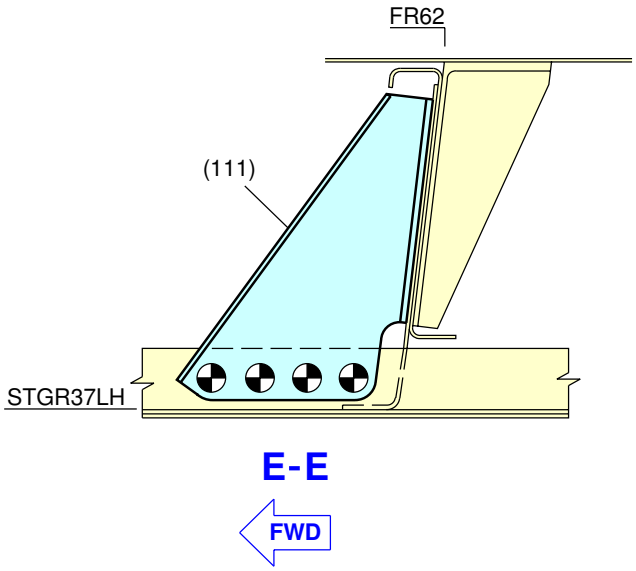
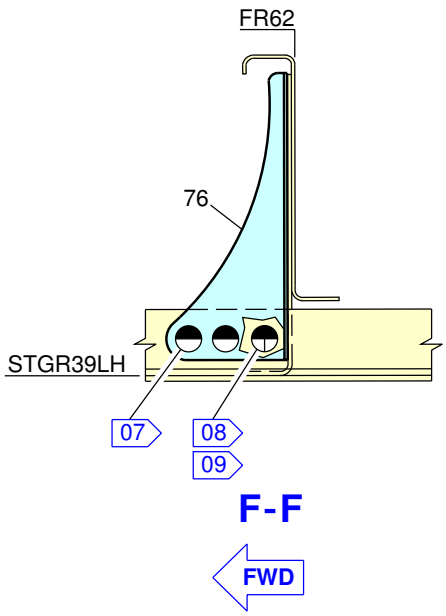
**CONF 009





NOTE:

07 EXISTING PILOT HOLES.

08 COUNTERSINK EXISTING HOLE IN THE STRINGER.

09 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BNAJ_05_01

Figure A-GBNAJ - Sheet 05
Replacement of Webs and Angles at Frame 62

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**CONF 009

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	364	EN6115K3–4	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	864	DAN6–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	964	DAN5–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	965	DAN5–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BNAJ_06_01

Figure A-GBNAJ - Sheet 06
Replacement of Webs and Angles at Frame 62

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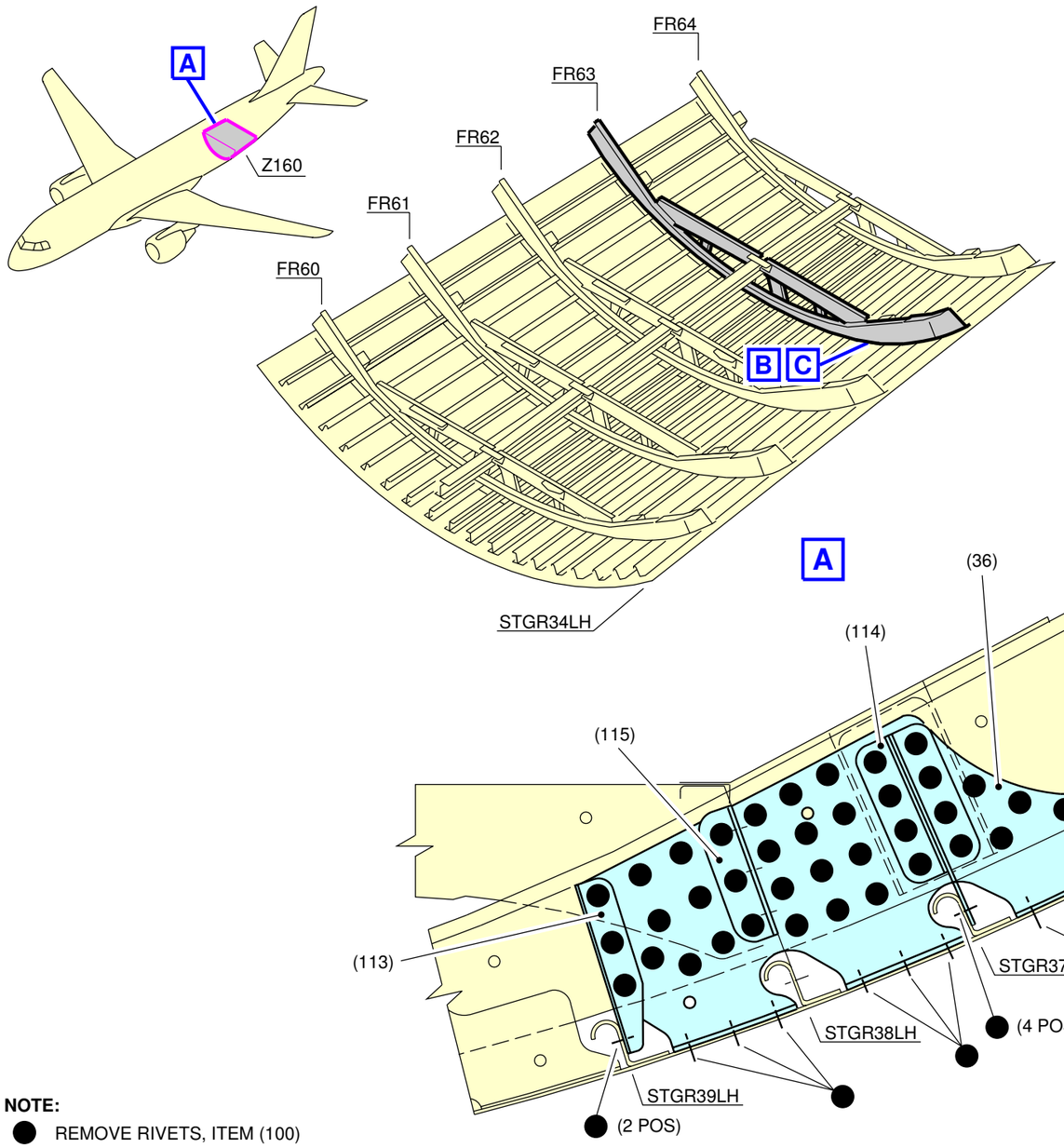
**CONF 001



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BPAA_01_00

Figure A-GBPAA - Sheet 01
Replacement of Webs and Angles at Frame 63

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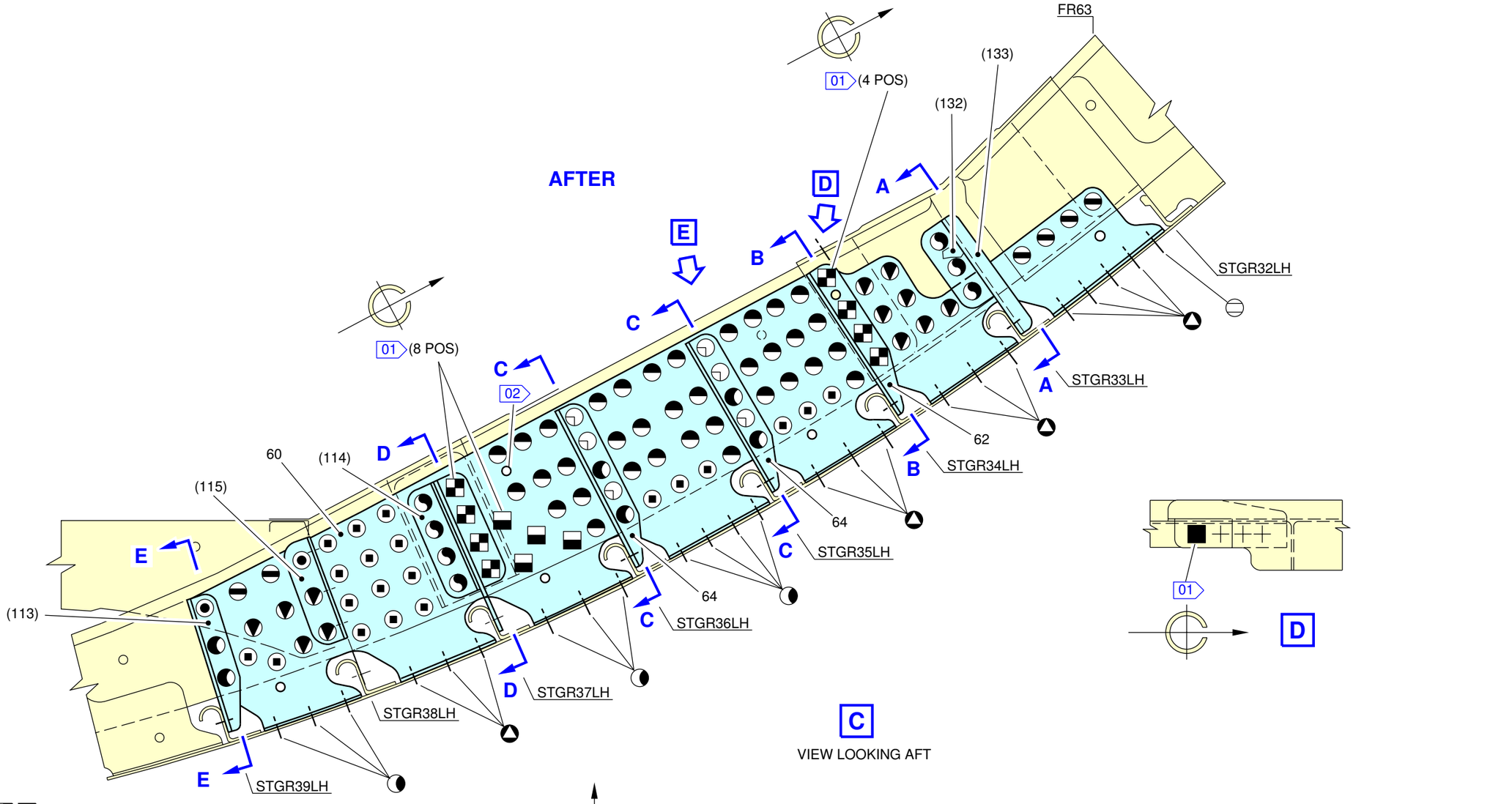
**CONF 001



NOTE:

01 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00

02 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

+ EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 6

N_SB_531364_6_BPAA_02_01

Figure A-GBPAA - Sheet 02
Replacement of Webs and Angles at Frame 63

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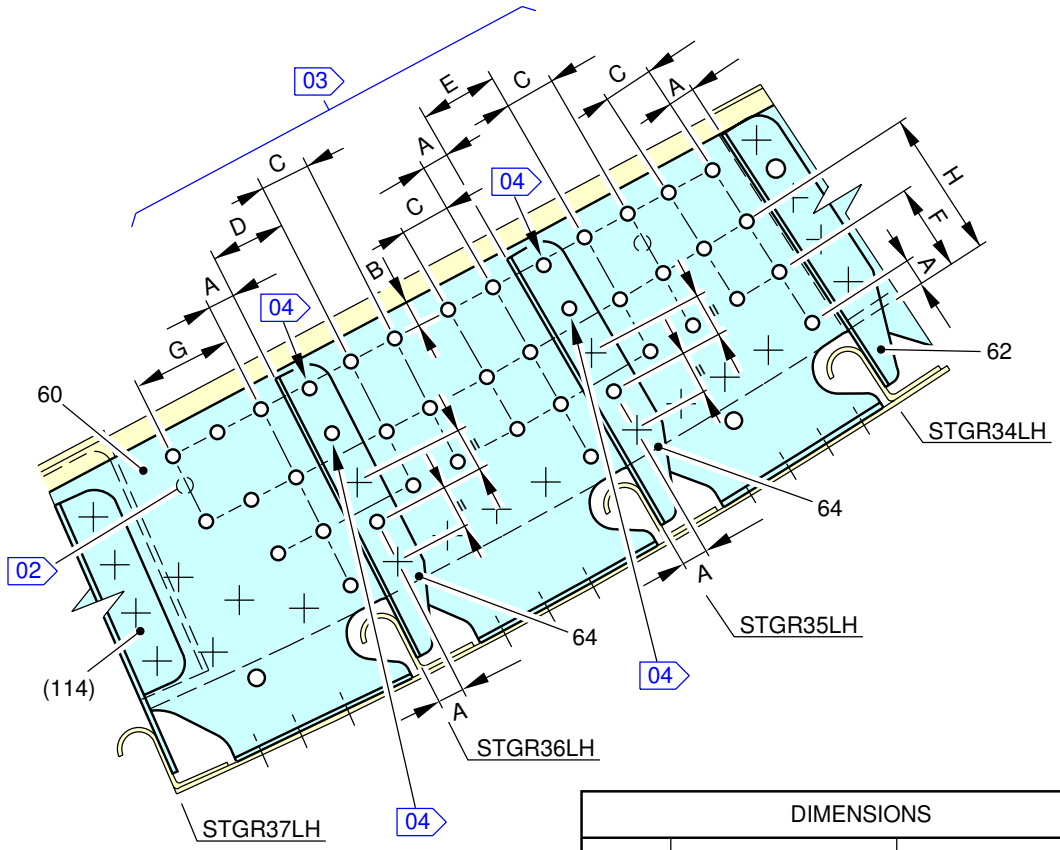
**CONF 001



E

VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	19.00	0.748
D	28.50	1.122
E	29.70	1.169
F	33.00	1.299
G	2 x 19.00	2 x 0.748
H	56.00	2.205

NOTE:

02 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

03 NEW HOLES

04 EXISTING PILOT HOLES

┼ EXISTING HOLE POSITION MUST BE USED

N_SB_531364_6_BPAA_03_01

Figure A-GBPAA - Sheet 03
Replacement of Webs and Angles at Frame 63

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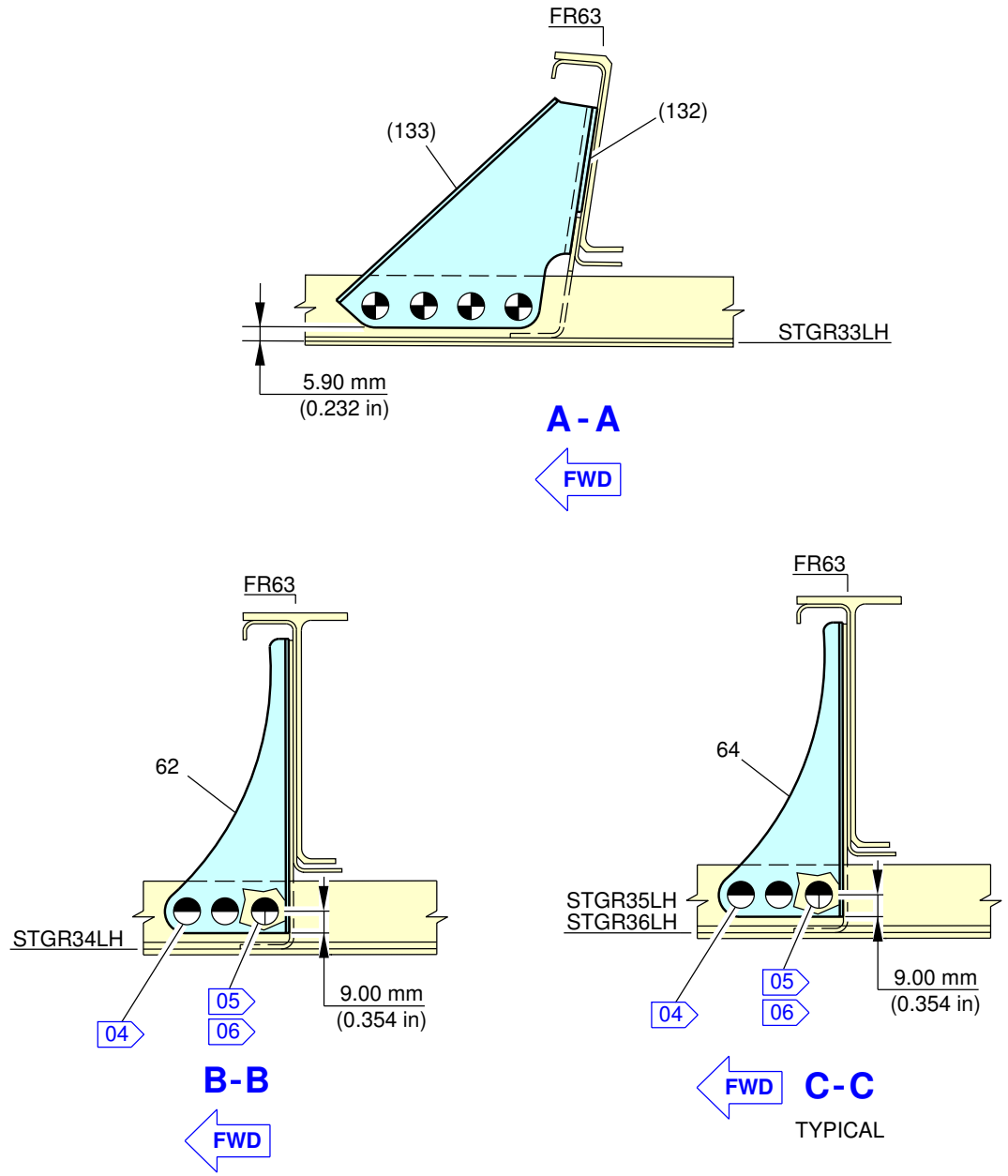
**CONF 001



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BPAA_04_01

Figure A-GBPAA - Sheet 04
Replacement of Webs and Angles at Frame 63

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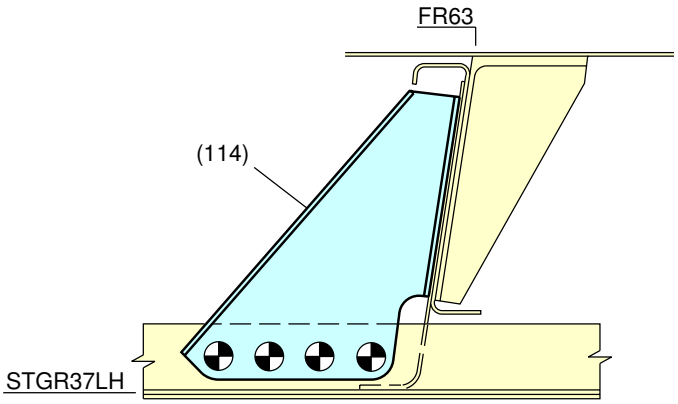
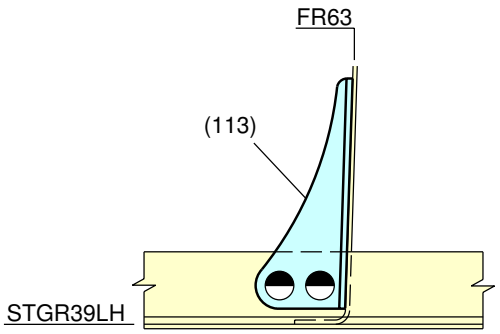
**CONF 001



D-D

FWD



E-E

FWD

NOTE:
FOR FASTENER SYMBOLS, REFER TO SHEET 6

N_SB_531364_6_BPAA_05_00

Figure A-GBPAA - Sheet 05
Replacement of Webs and Angles at Frame 63

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**CONF 001

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	864	DAN6–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BPAA_06_01

Figure A-GBPAA - Sheet 06
Replacement of Webs and Angles at Frame 63

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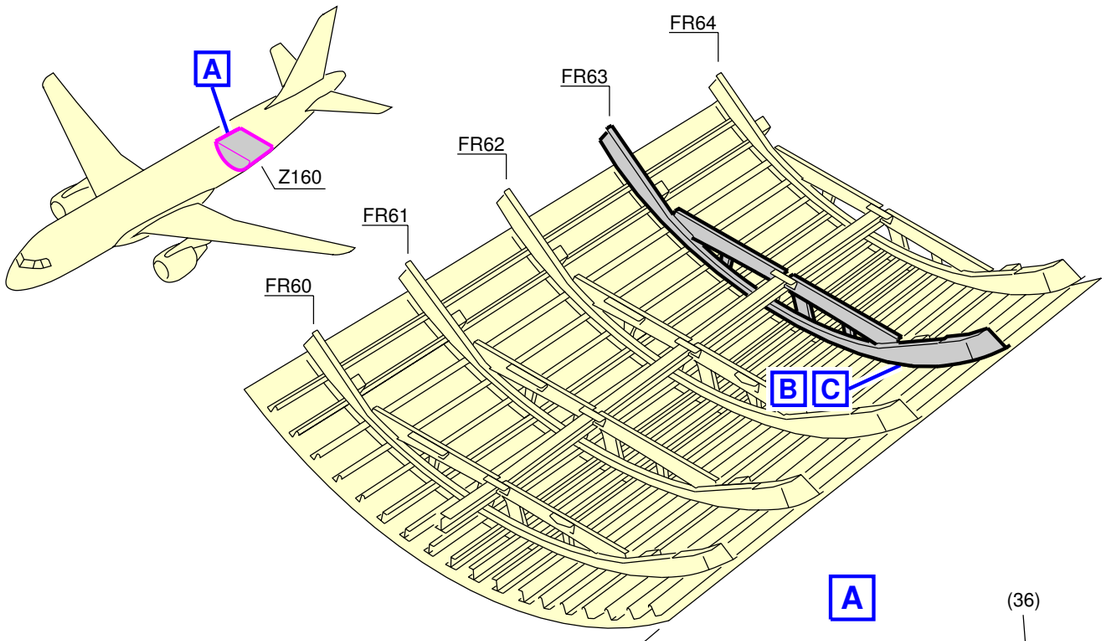
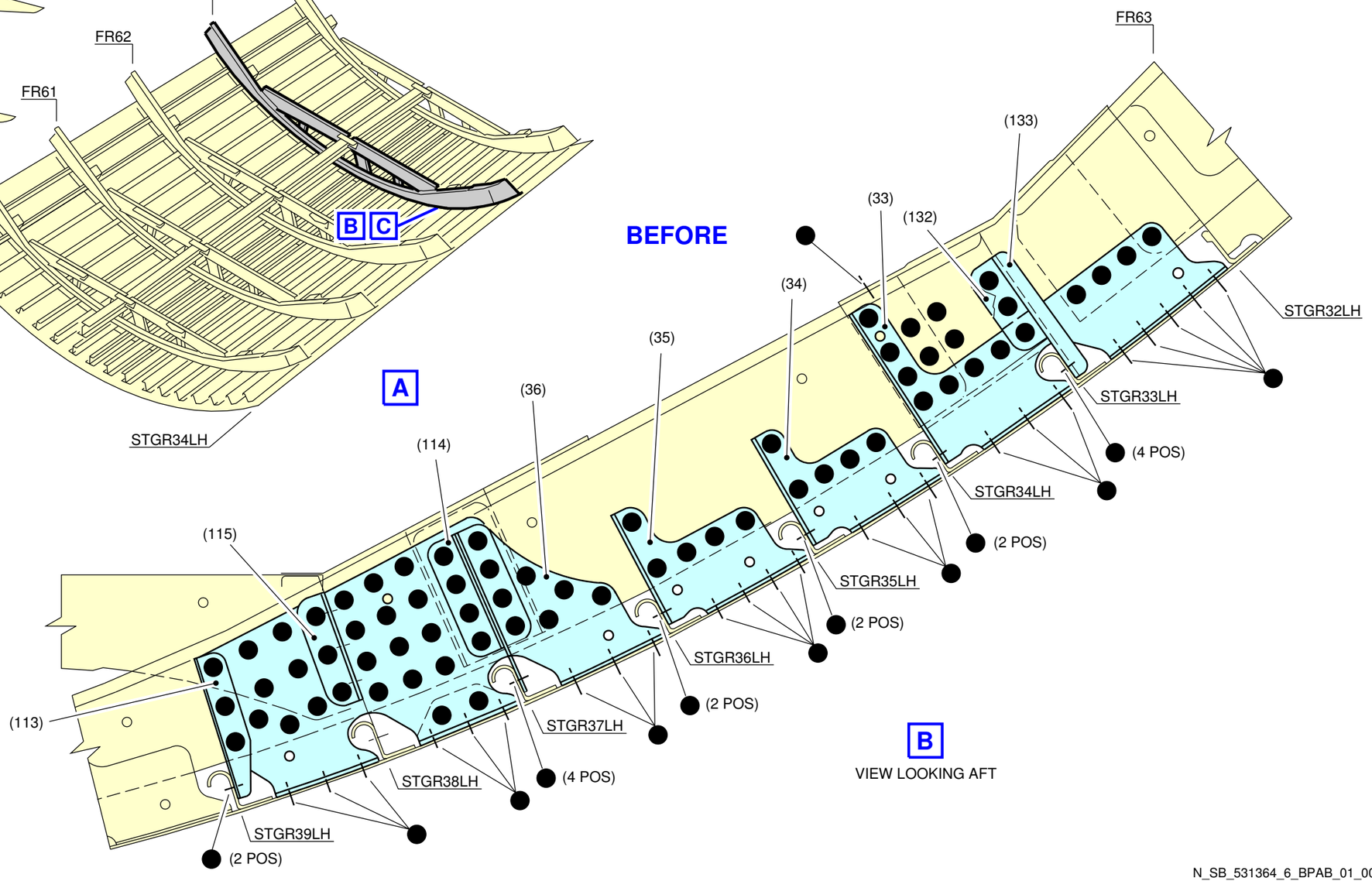
**CONF 002 thru 003





NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BPAB_01_00

Figure A-GBPAB - Sheet 01
Replacement of Webs and Angles at Frame 63

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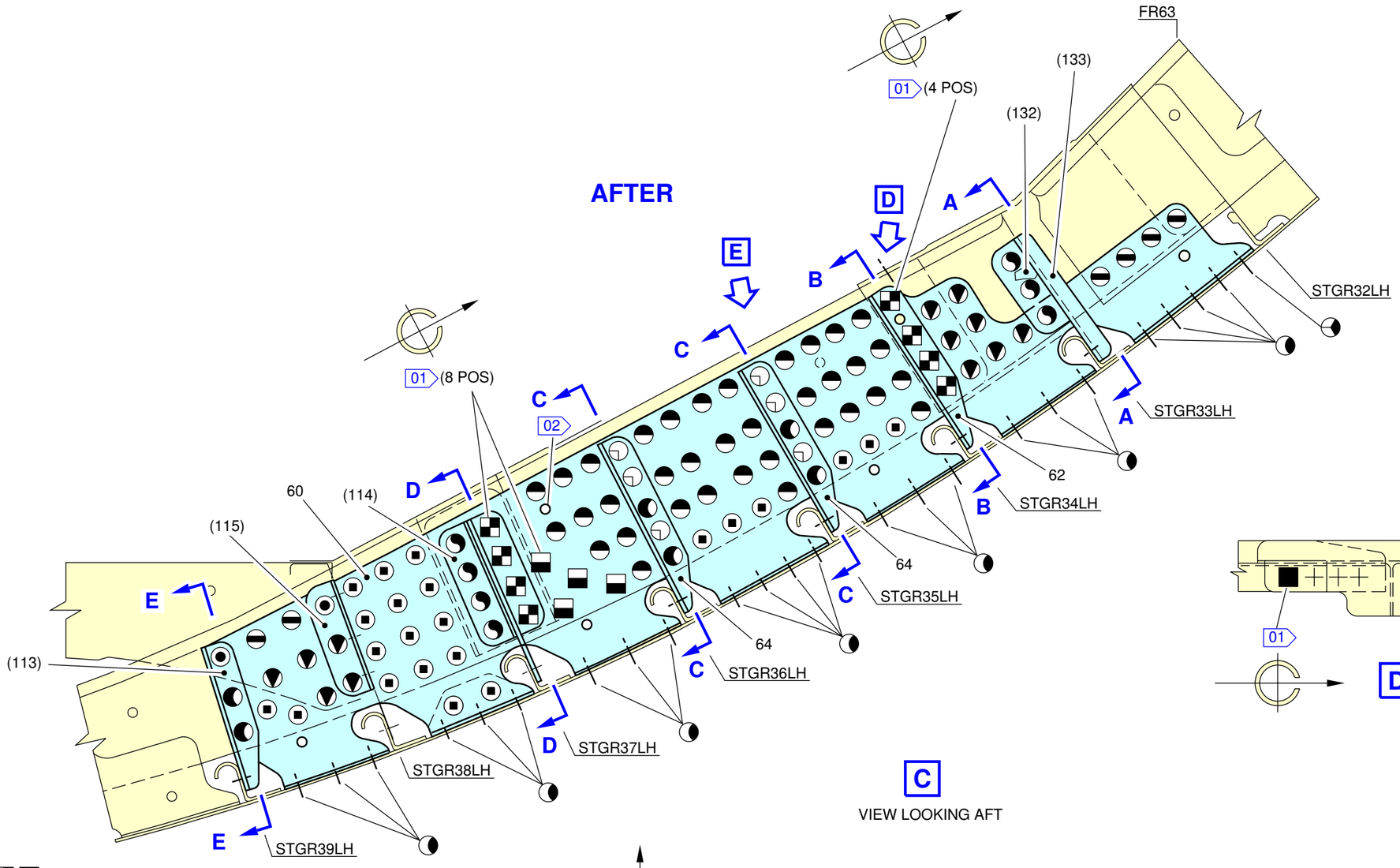
**CONF 002 thru 003



NOTE:

01 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

02 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BPAB_02_01

Figure A-GBPAB - Sheet 02
Replacement of Webs and Angles at Frame 63

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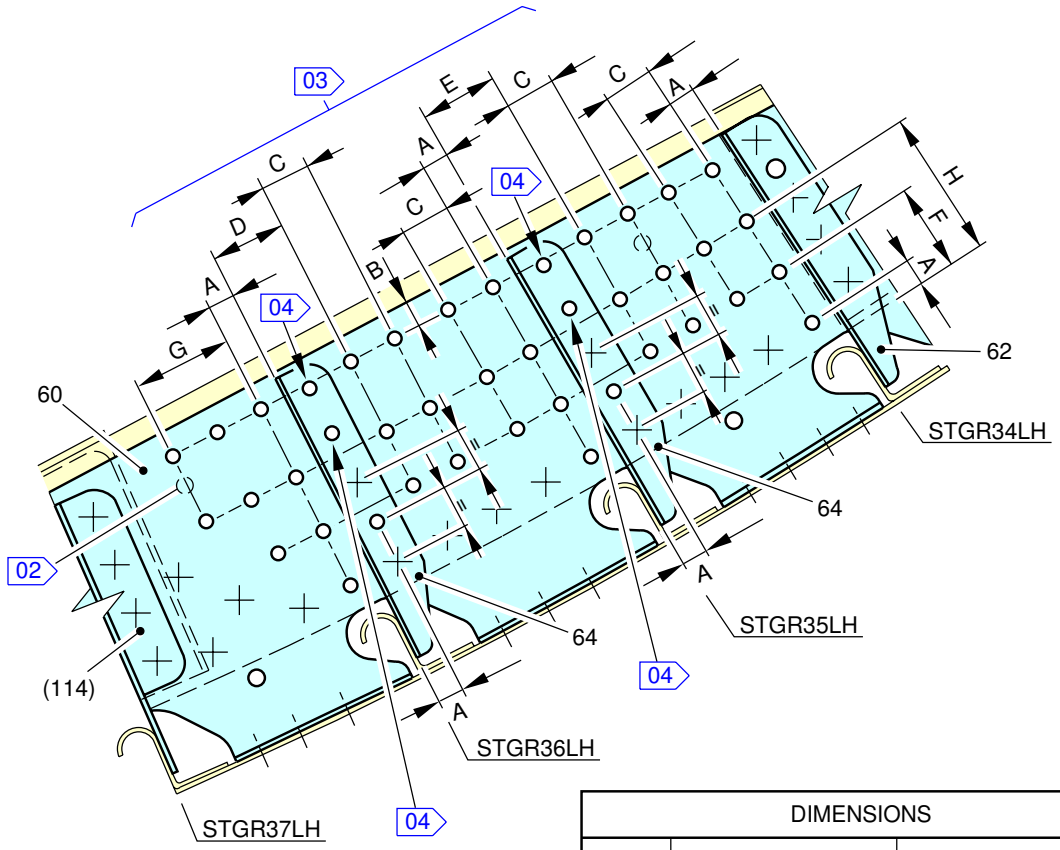
****CONF 002 thru 003**



E

VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	19.00	0.748
D	28.50	1.122
E	29.70	1.169
F	33.00	1.299
G	2 x 19.00	2 x 0.748
H	56.00	2.205

NOTE:

02 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

03 NEW HOLES.

04 EXISTING PILOT HOLES.

┼ EXISTING HOLE POSITION MUST BE USED.

N_SB_531364_6_BPAB_03_01

Figure A-GBPAB - Sheet 03
Replacement of Webs and Angles at Frame 63

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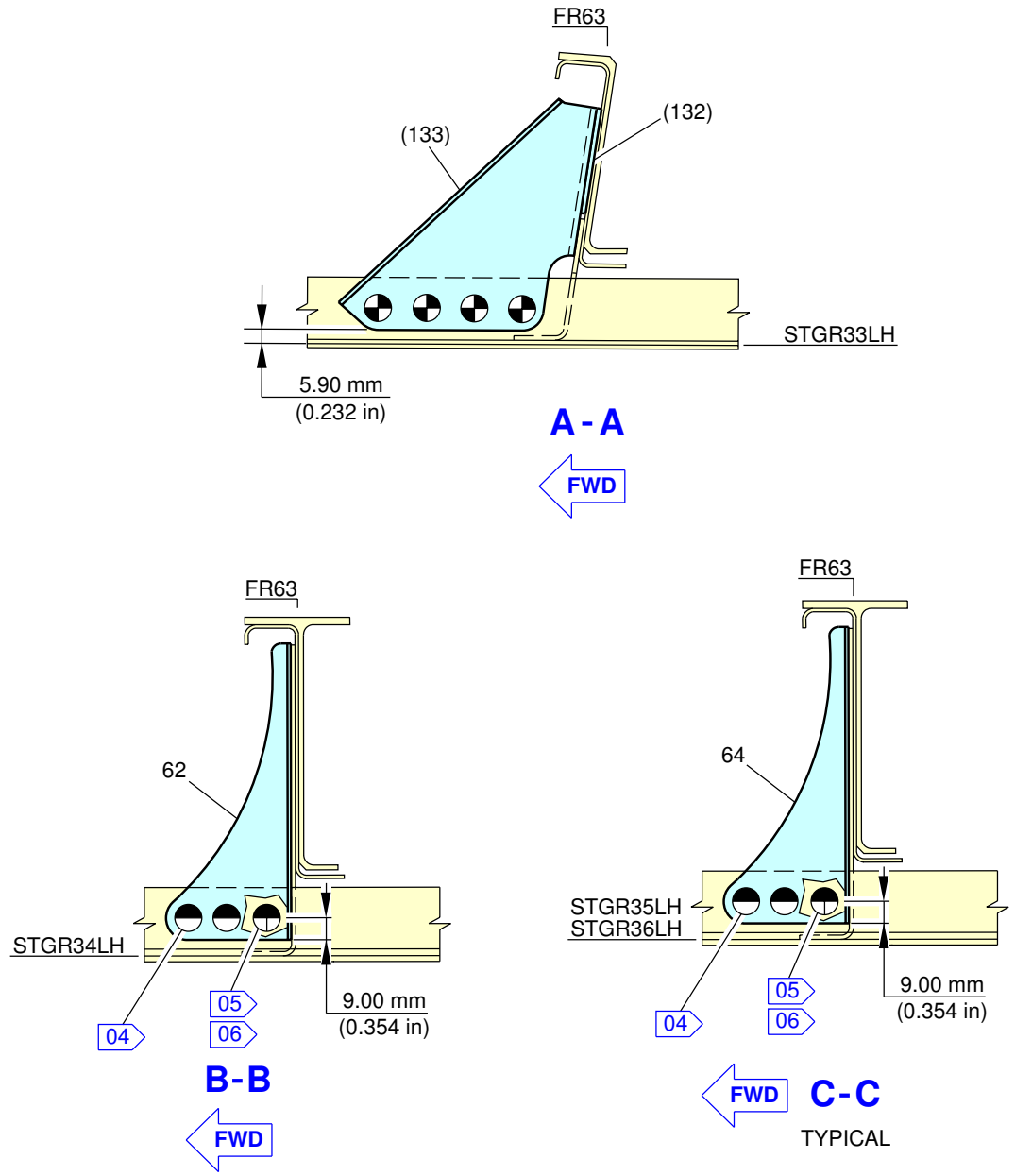
****CONF 002 thru 003**



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BPAB_04_01

Figure A-GBPAB - Sheet 04
Replacement of Webs and Angles at Frame 63

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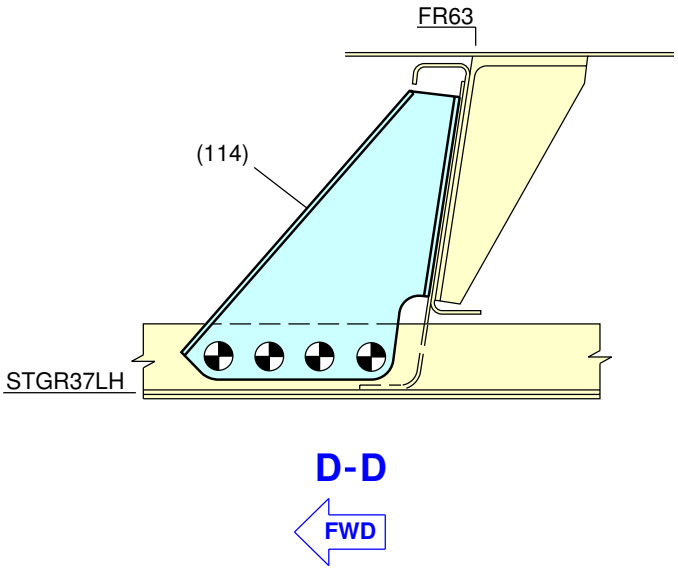
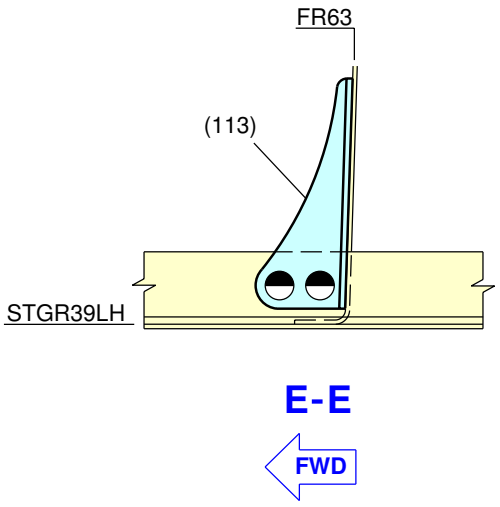
****CONF 002 thru 003**





NOTE:
FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BPAB_05_00

Figure A-GBPAB - Sheet 05
Replacement of Webs and Angles at Frame 63

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**CONF 002 thru 003

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	568	EN6069D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BPAB_06_01

Figure A-GBPAB - Sheet 06
Replacement of Webs and Angles at Frame 63

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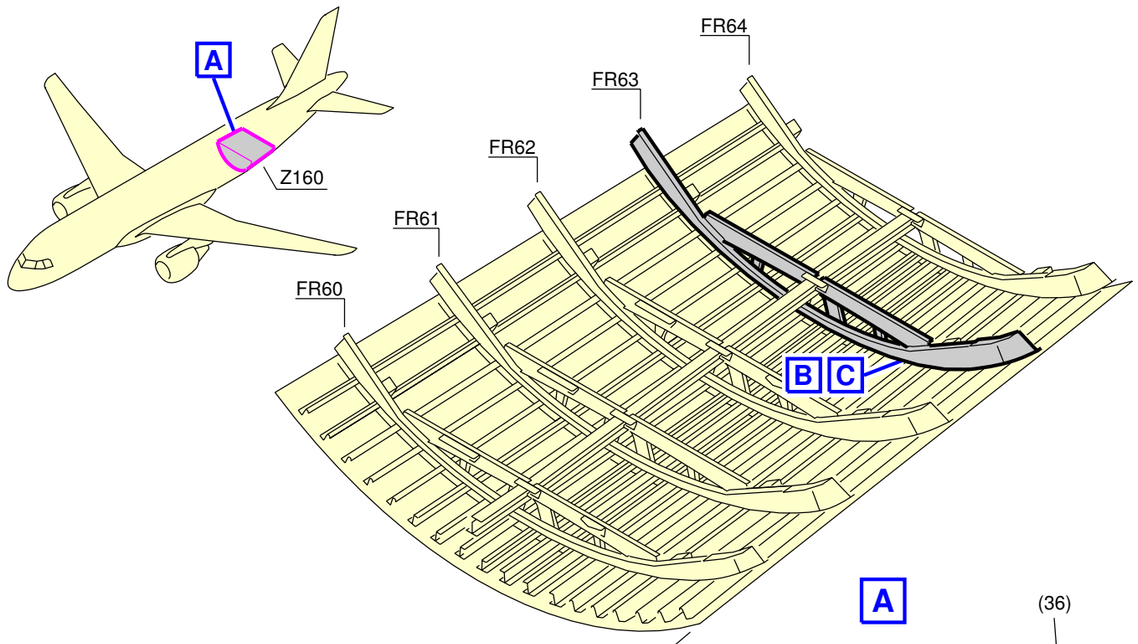
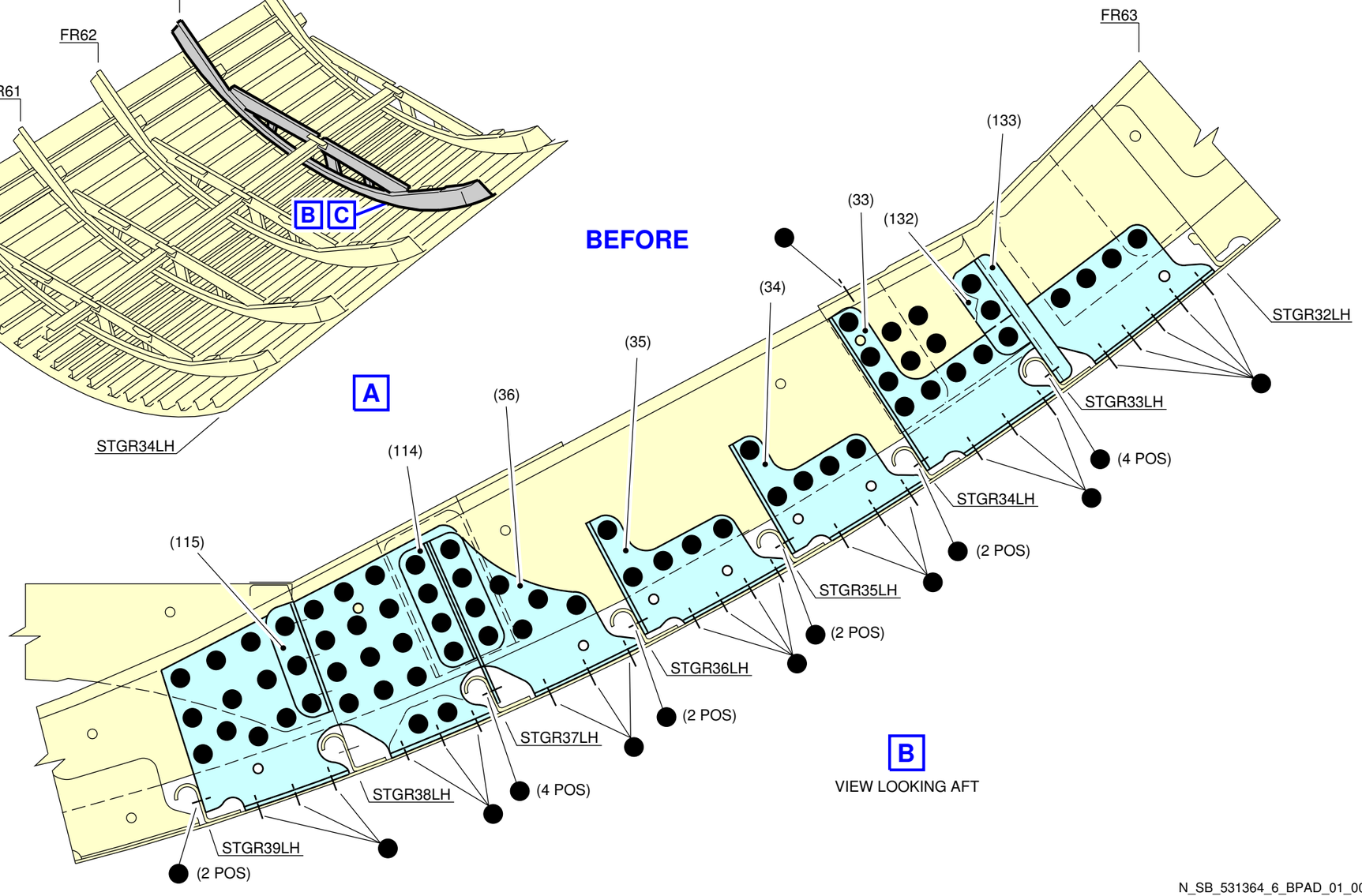
**CONF 004, 006



BEFORE



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BPAD_01_00

Figure A-GBPAD - Sheet 01
Replacement of Webs and Angles at Frame 63

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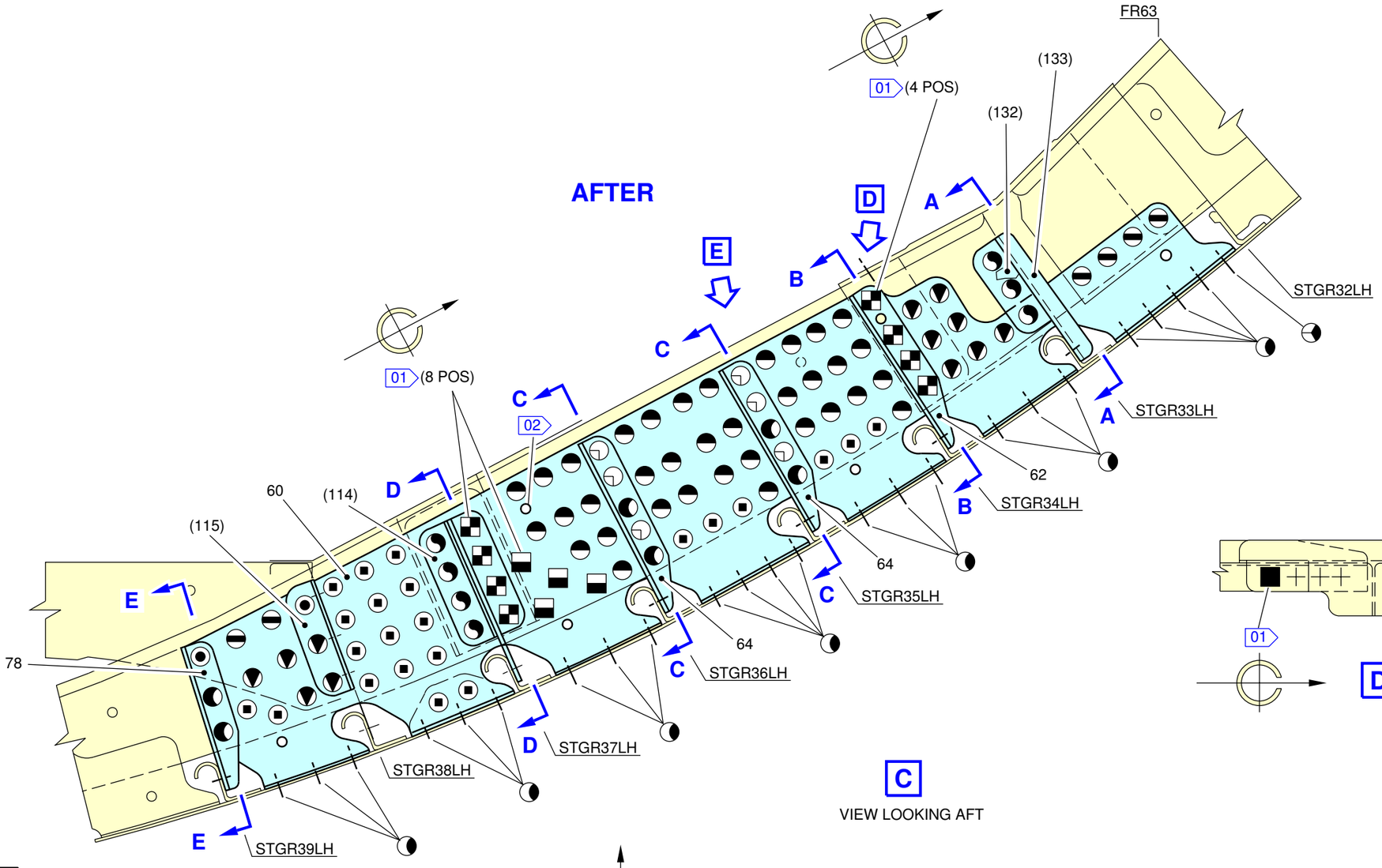
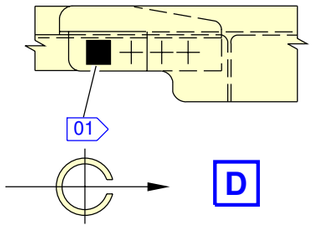
**CONF 004, 006





C
VIEW LOOKING AFT

NOTE:

01 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

02 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

EXISTING HOLE POSITION MUST BE USED

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

N_SB_531364_6_BPAD_02_01

Figure A-GBPAD - Sheet 02
Replacement of Webs and Angles at Frame 63

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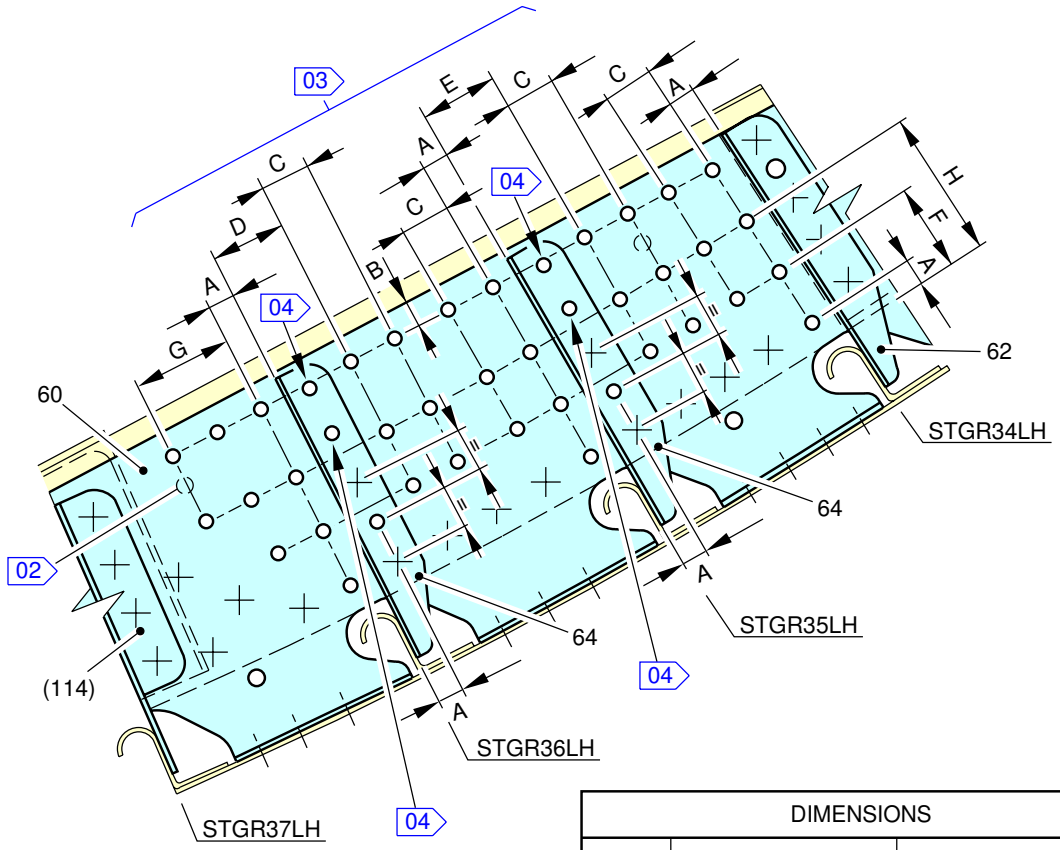
**CONF 004, 006



E

VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	19.00	0.748
D	28.50	1.122
E	29.70	1.169
F	33.00	1.299
G	2 x 19.00	2 x 0.748
H	56.00	2.205

NOTE:

02 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

03 NEW HOLES

04 EXISTING PILOT HOLES

EXISTING HOLE POSITION MUST BE USED

N_SB_531364_6_BPAD_03_01

Figure A-GBPAD - Sheet 03
Replacement of Webs and Angles at Frame 63

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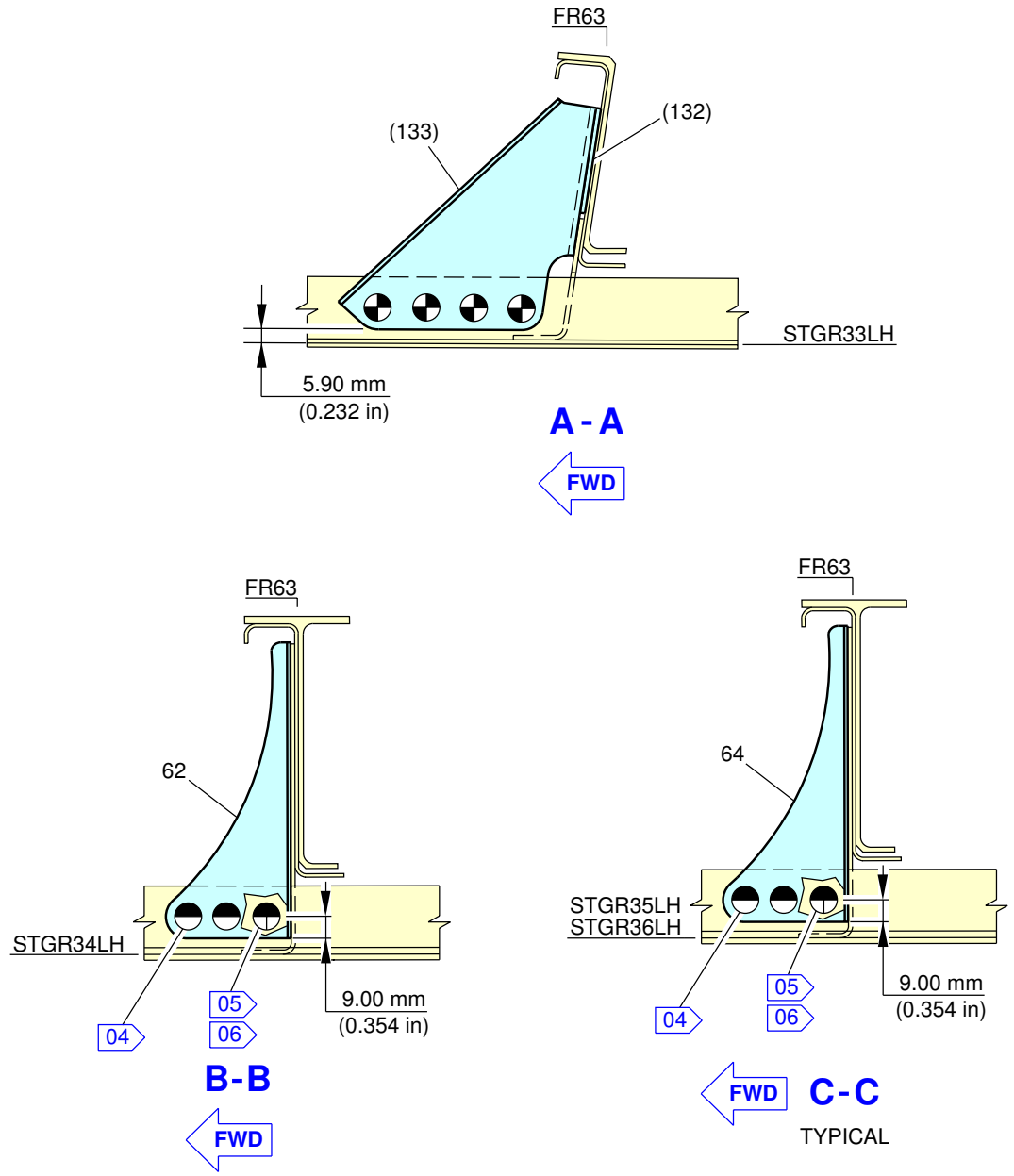
**CONF 004, 006



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BPAD_04_01

Figure A-GBPAD - Sheet 04
Replacement of Webs and Angles at Frame 63

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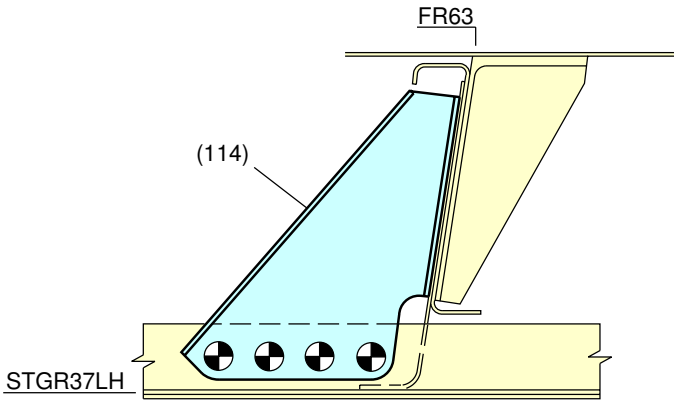
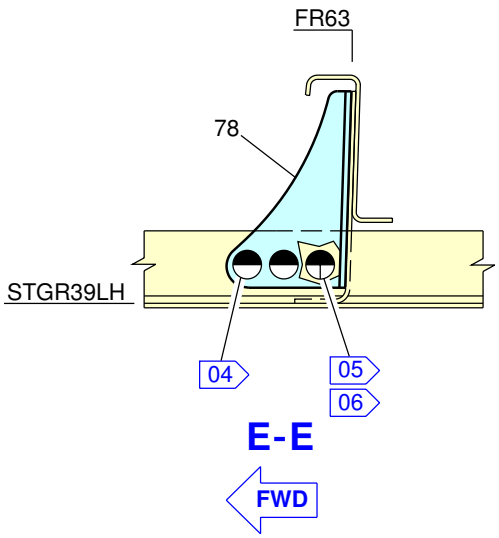
**CONF 004, 006



D-D

FWD



E-E

FWD

NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BPAD_05_01

Figure A-GBPAD - Sheet 05
Replacement of Webs and Angles at Frame 63

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**CONF 004, 006

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	568	EN6069D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BPAD_06_01

Figure A-GBPAD - Sheet 06
Replacement of Webs and Angles at Frame 63

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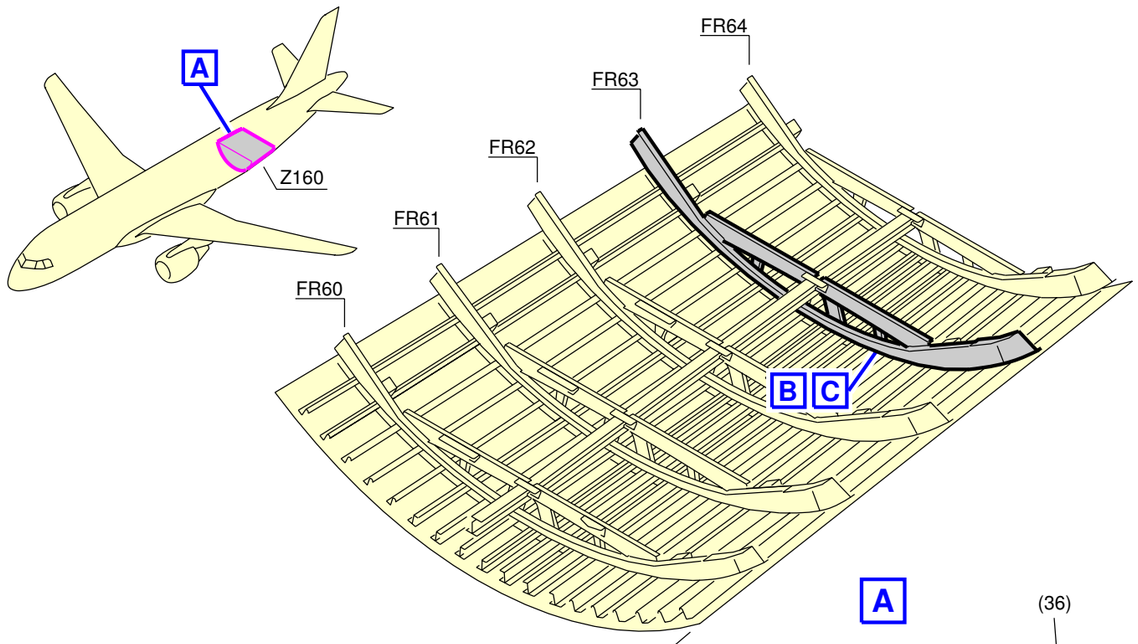
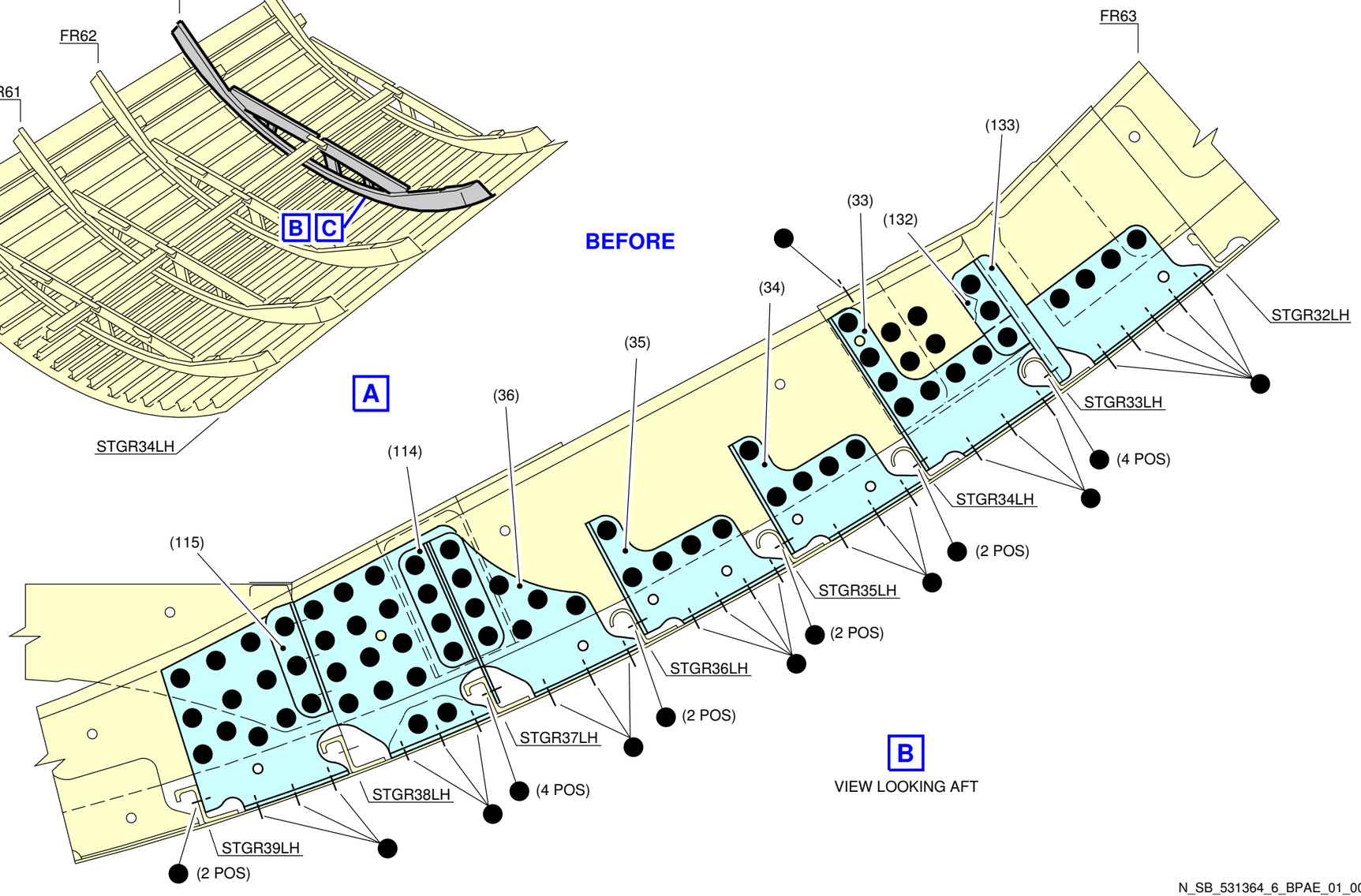
**CONF 005, 007



BEFORE



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BPAE_01_00

Figure A-GBPAE - Sheet 01
Replacement of Webs and Angles at Frame 63

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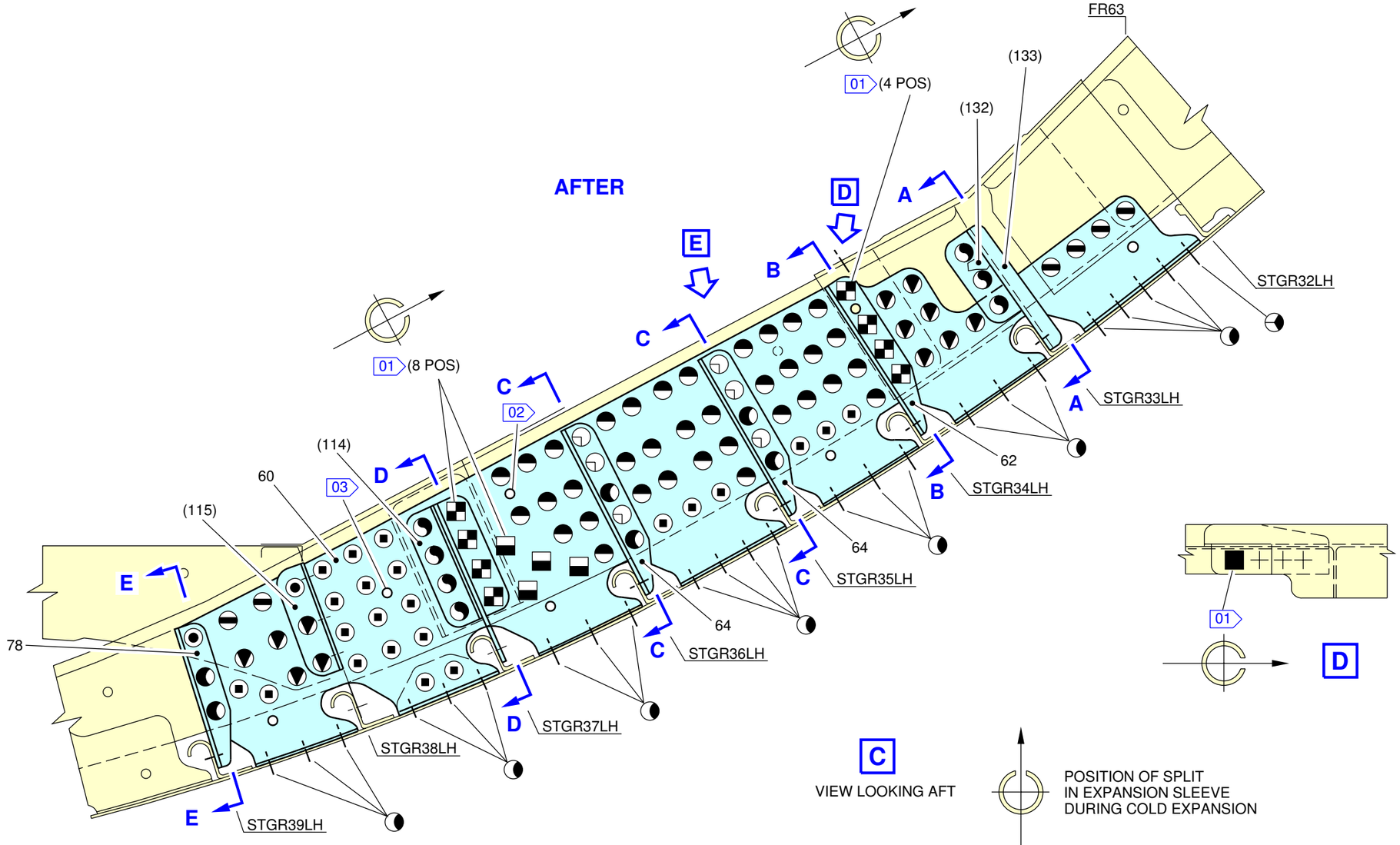
**CONF 005, 007



NOTE:

01 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00

02 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in), FOR MSN 3999 AND SUBSEQUENT.

Figure A-GBPAE - Sheet 02
Replacement of Webs and Angles at Frame 63

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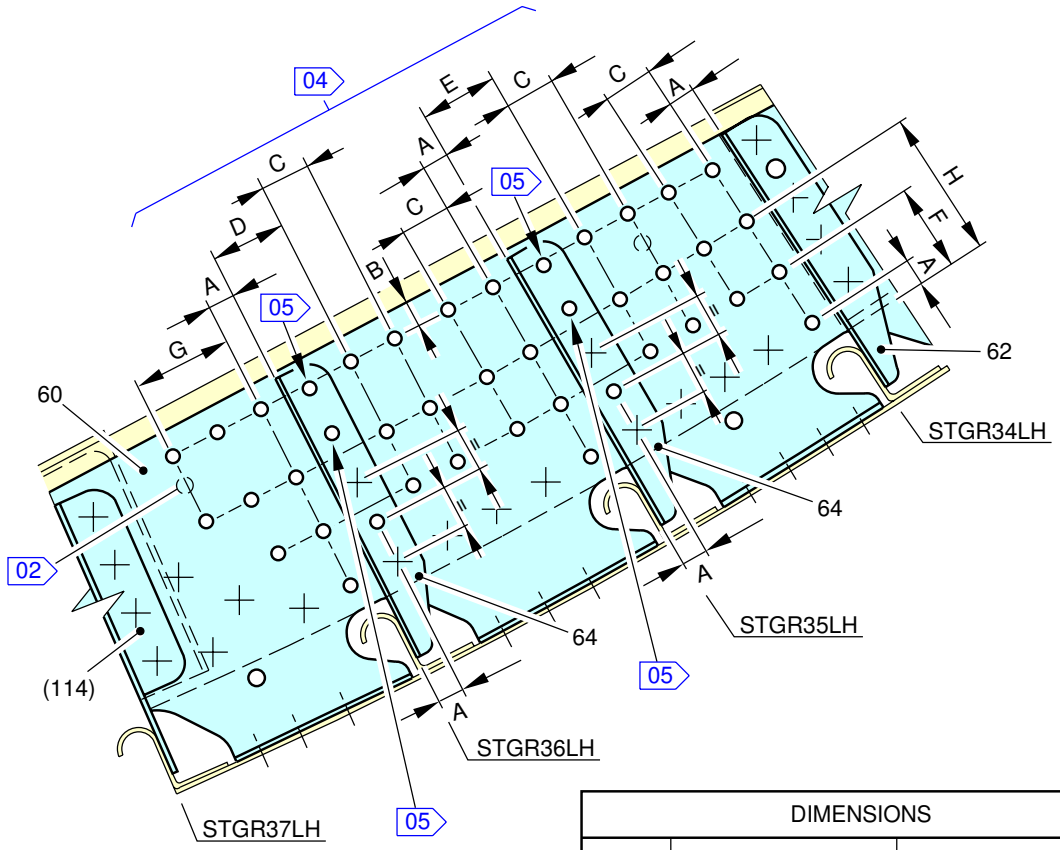
**CONF 005, 007



E

VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	19.00	0.748
D	28.50	1.122
E	29.70	1.169
F	33.00	1.299
G	2 x 19.00	2 x 0.748
H	56.00	2.205

NOTE:

02 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

04 NEW HOLES

05 EXISTING PILOT HOLES

┼ EXISTING HOLE POSITION MUST BE USED

N_SB_531364_6_BPAE_03_01

Figure A-GBPAE - Sheet 03
Replacement of Webs and Angles at Frame 63

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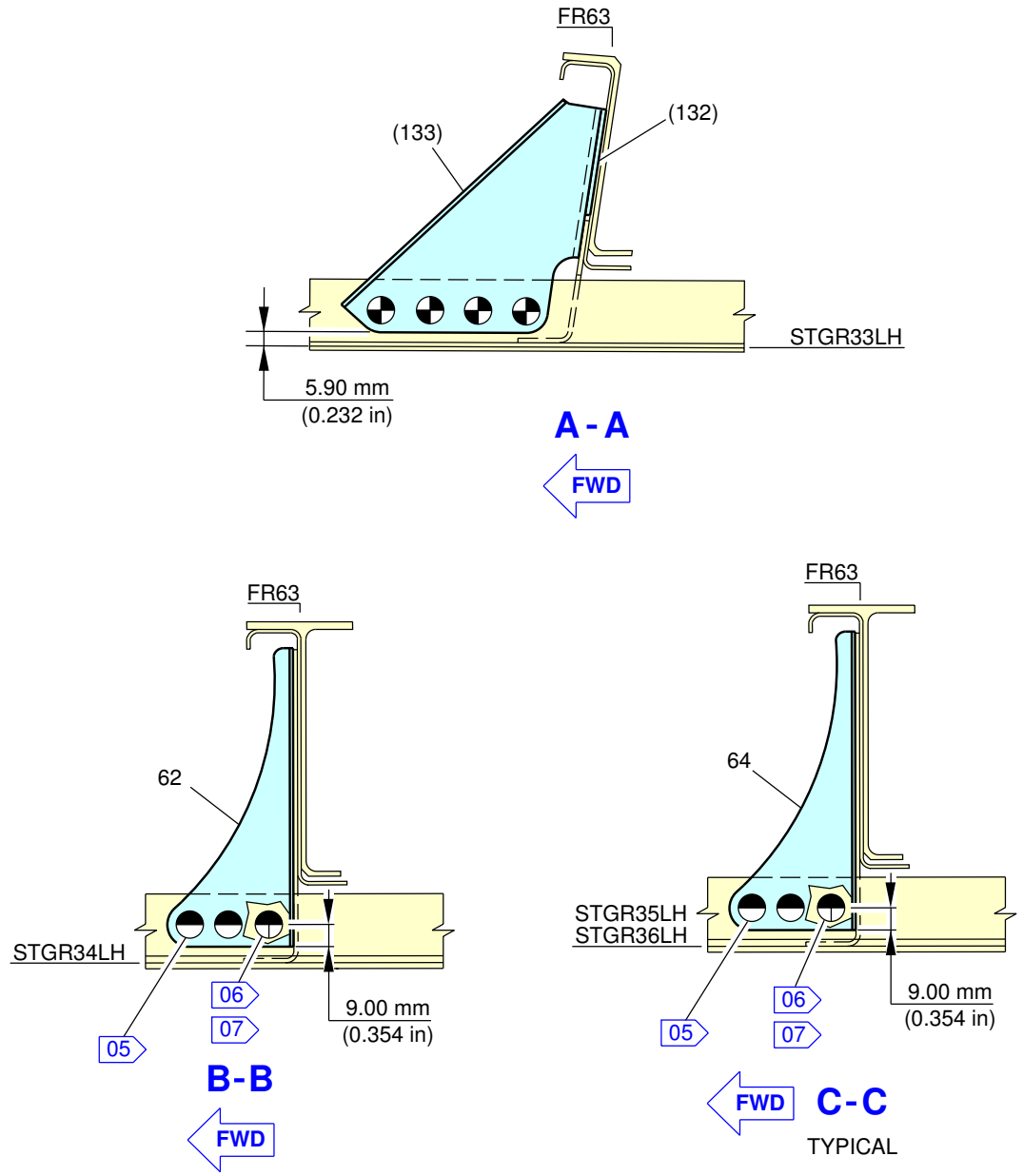
****CONF 005, 007**



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BPAE_04_01

Figure A-GBPAE - Sheet 04
Replacement of Webs and Angles at Frame 63

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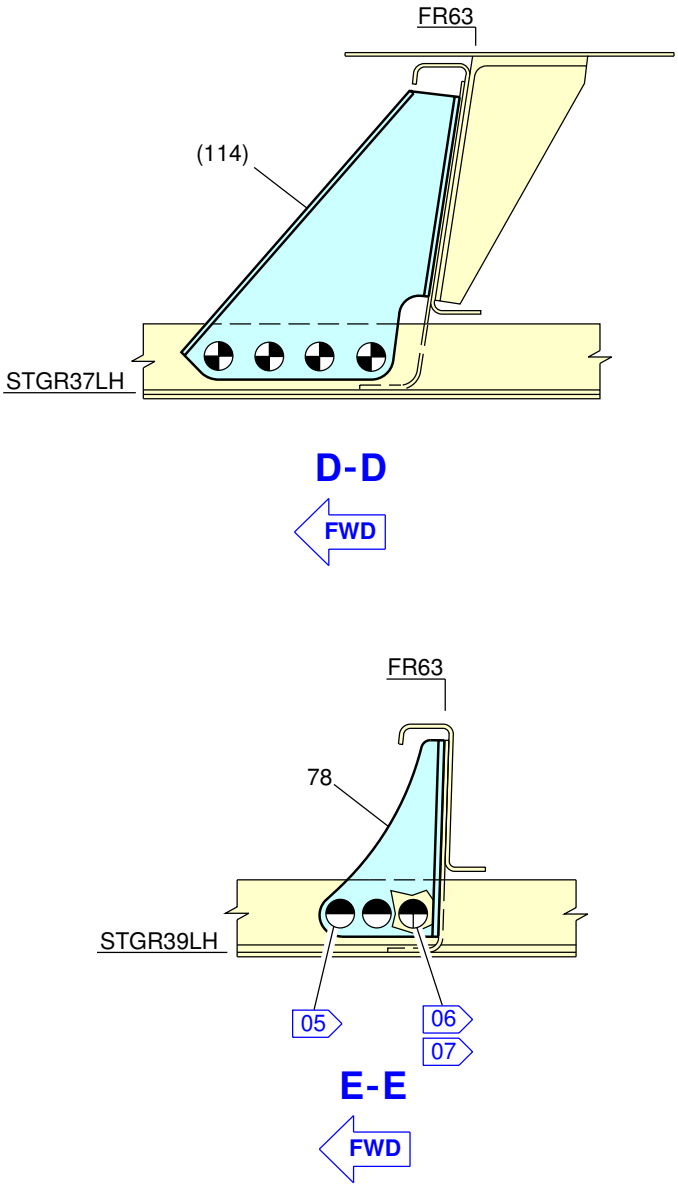
**CONF 005, 007



NOTE:

05 EXISTING PILOT HOLES.

06 COUNTERSINK EXISTING HOLE IN THE STRINGER.

07 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BPAE_05_01

Figure A-GBPAE - Sheet 05
Replacement of Webs and Angles at Frame 63

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**CONF 005, 007

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	568	EN6069D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BPAE_06_01

Figure A-GBPAE - Sheet 06
Replacement of Webs and Angles at Frame 63

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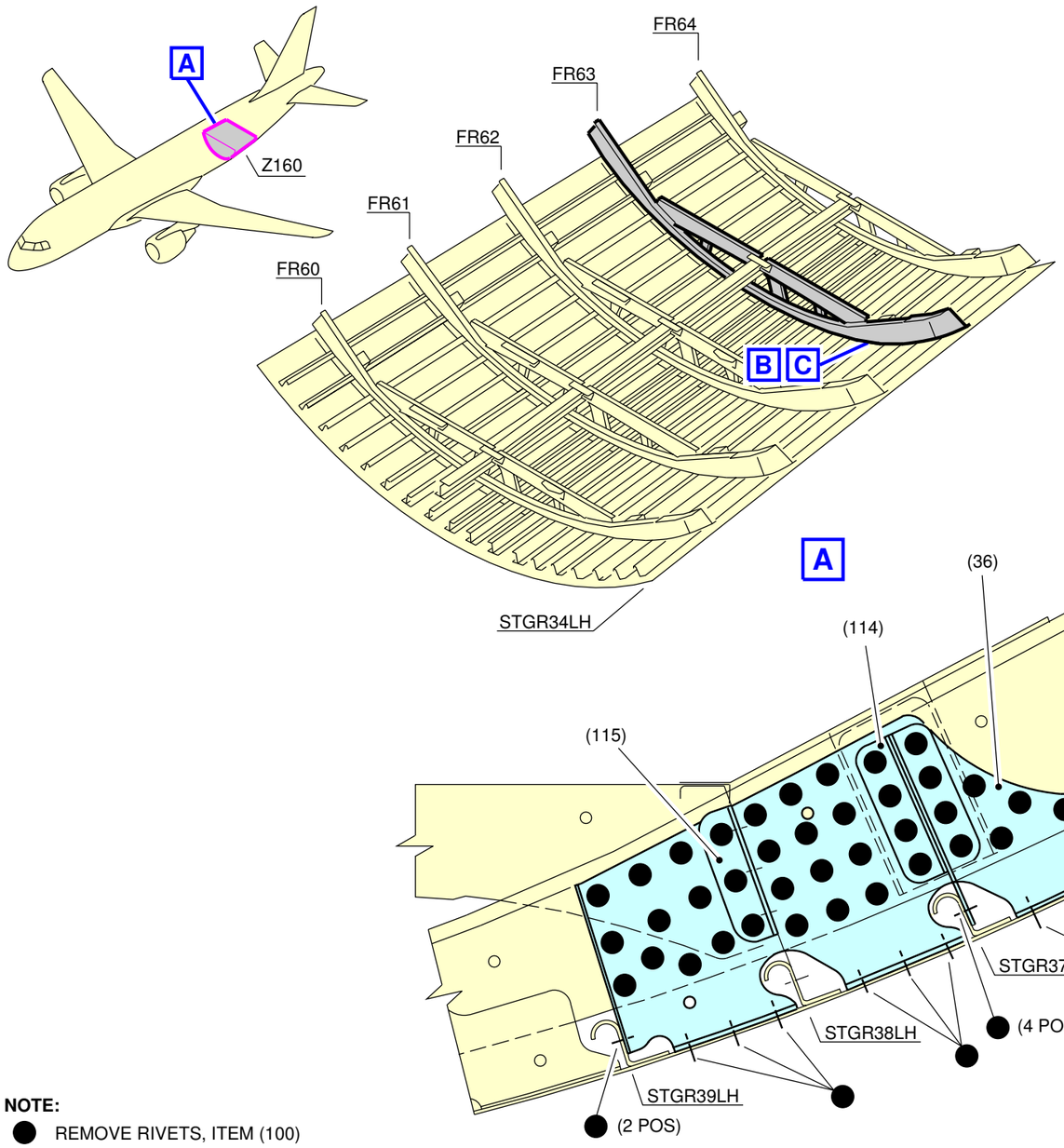
**CONF 008



BEFORE

NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BPAH_01_00

Figure A-GBPAH - Sheet 01
Replacement of Webs and Angles at Frame 63

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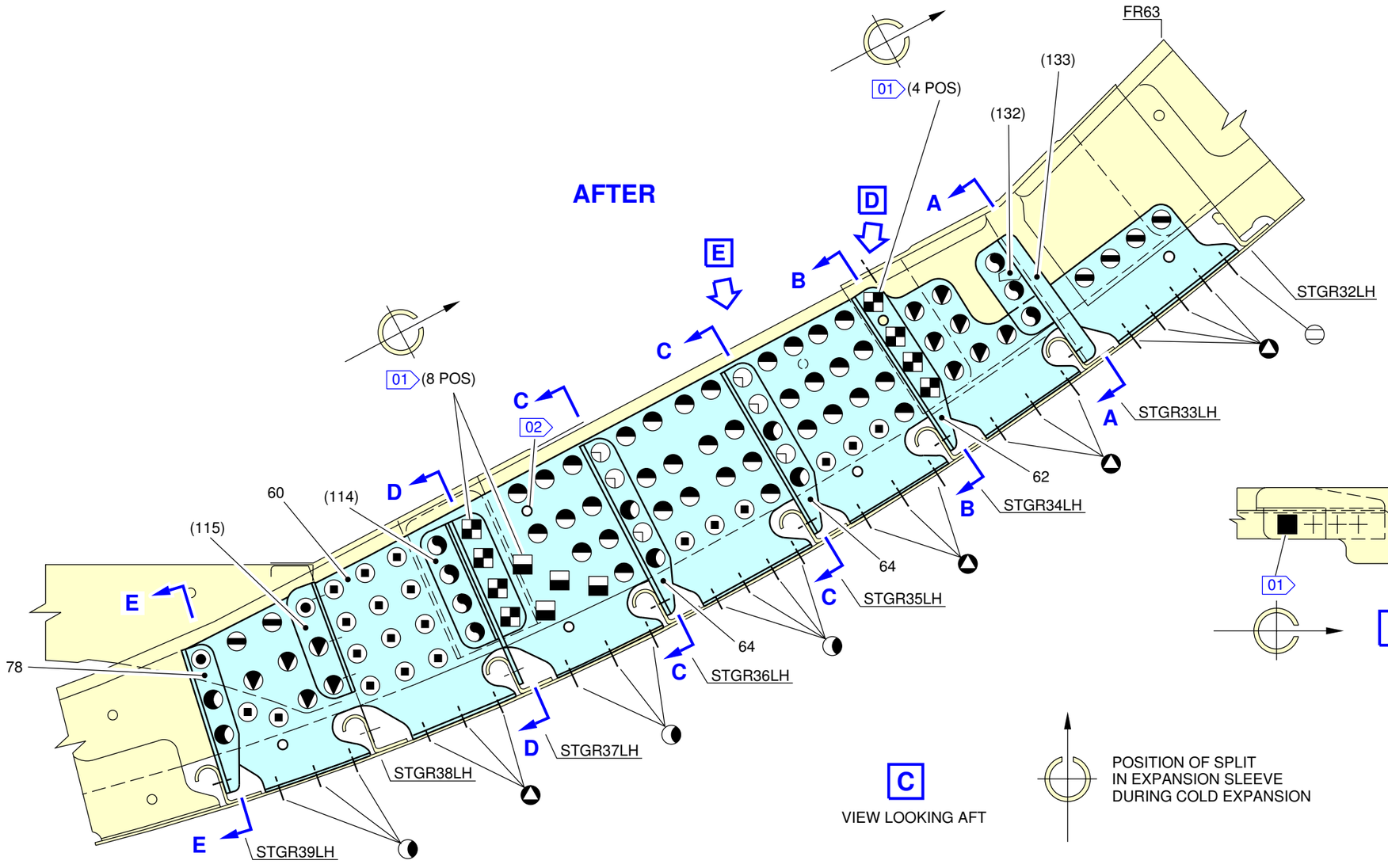
**CONF 008



NOTE:

01 COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

02 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

+ EXISTING HOLE POSITION MUST BE USED.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BPAH_02_01

Figure A-GBPAH - Sheet 02
Replacement of Webs and Angles at Frame 63

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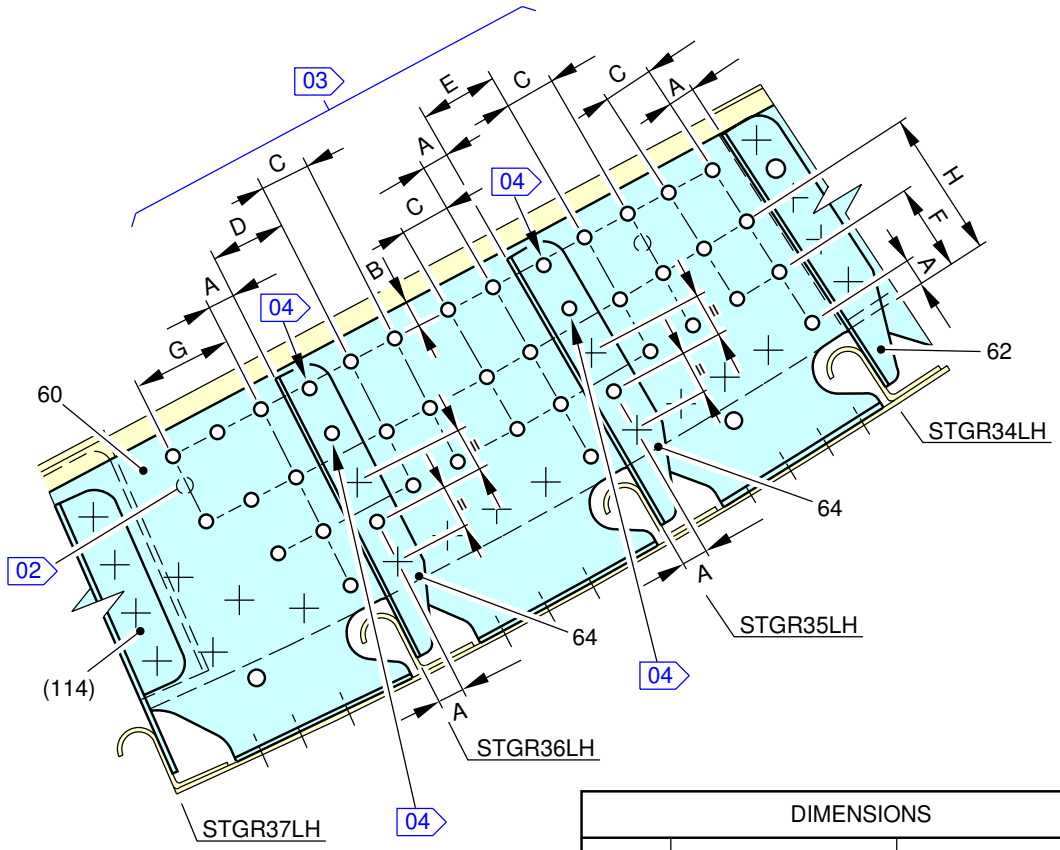
**CONF 008



E

VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	19.00	0.748
D	28.50	1.122
E	29.70	1.169
F	33.00	1.299
G	2 x 19.00	2 x 0.748
H	56.00	2.205

NOTE:

02 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

03 NEW HOLES.

04 EXISTING PILOT HOLES.

+ EXISTING HOLE POSITION MUST BE USED.

N_SB_531364_6_BPAH_03_01

Figure A-GBPAH - Sheet 03
Replacement of Webs and Angles at Frame 63

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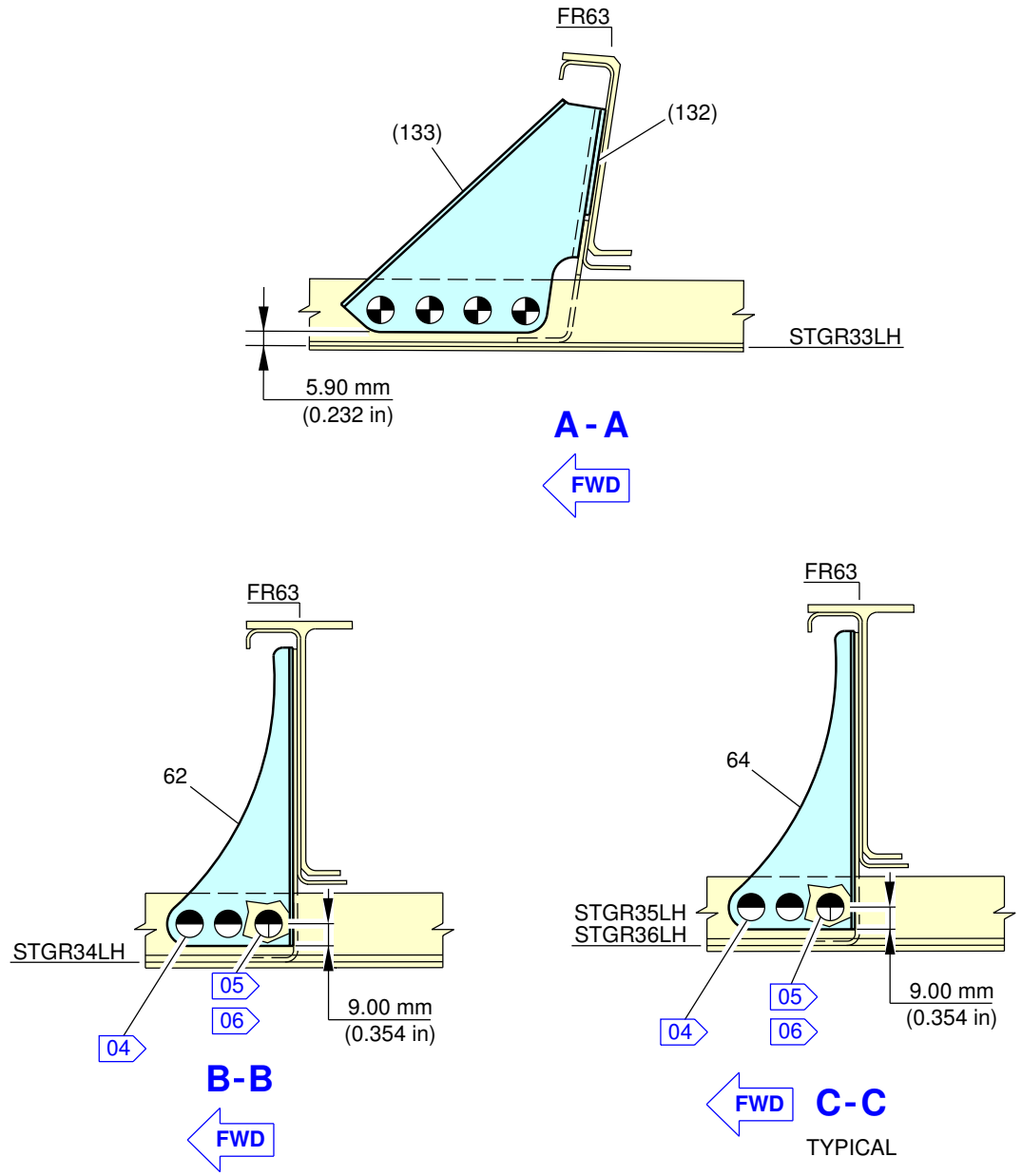
**CONF 008



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BPAH_04_01

Figure A-GBPAH - Sheet 04
Replacement of Webs and Angles at Frame 63

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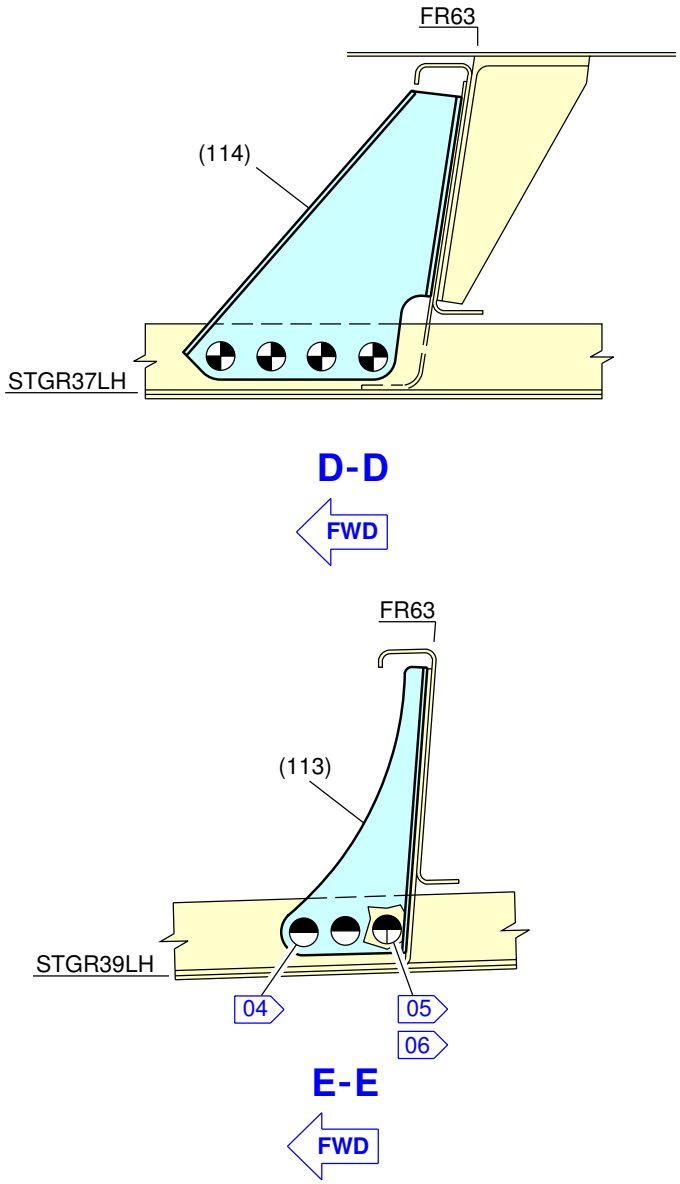
**CONF 008



NOTE:

04 EXISTING PILOT HOLES.

05 COUNTERSINK EXISTING HOLE IN THE STRINGER.

06 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BPAH_05_01

Figure A-GBPAH - Sheet 05
Replacement of Webs and Angles at Frame 63

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**CONF 008

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	864	DAN6–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BPAH_06_01

Figure A-GBPAH - Sheet 06
Replacement of Webs and Angles at Frame 63

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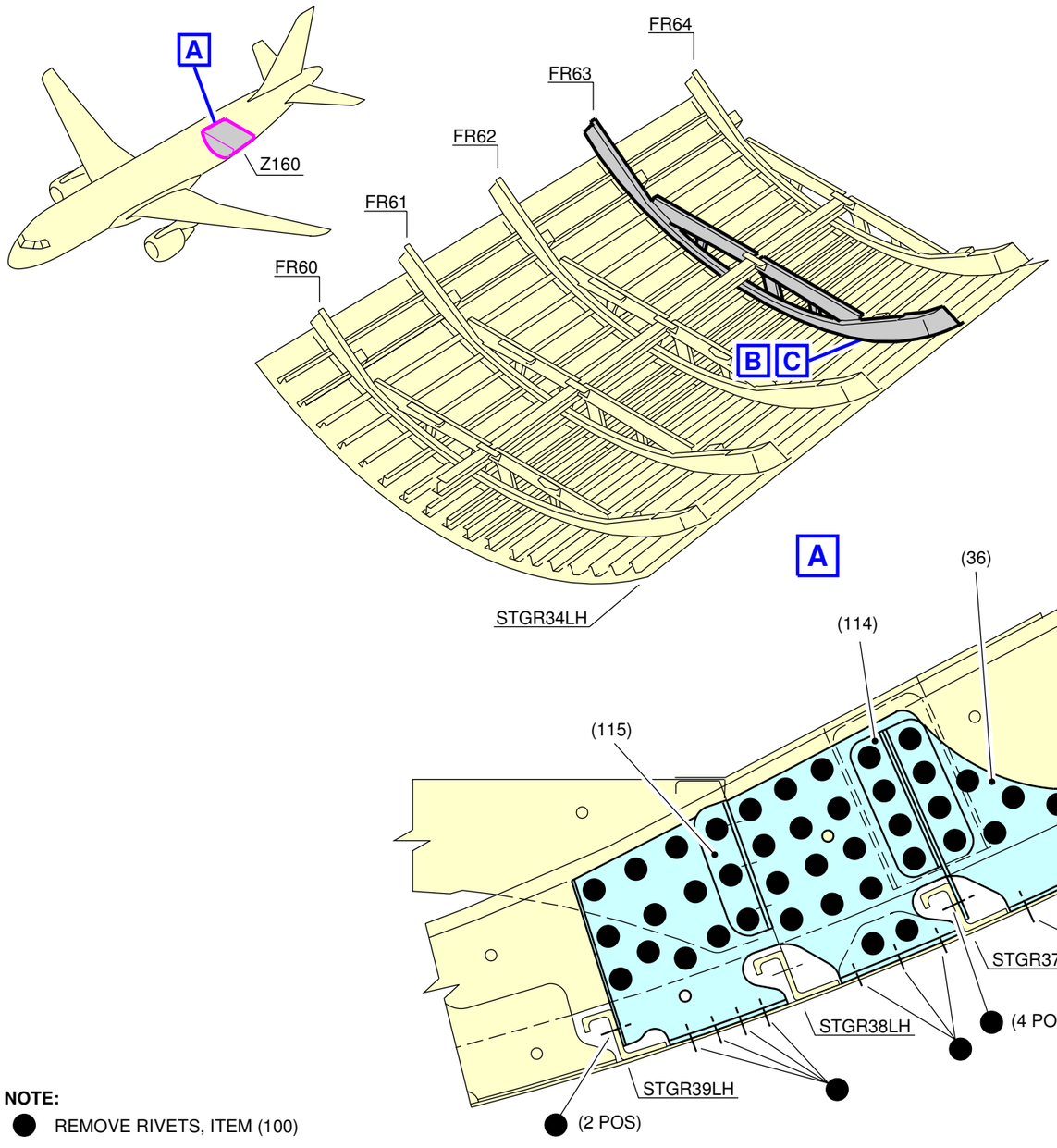
**CONF 009



NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BPAJ_01_00

Figure A-GBPAJ - Sheet 01
Replacement of Webs and Angles at Frame 63

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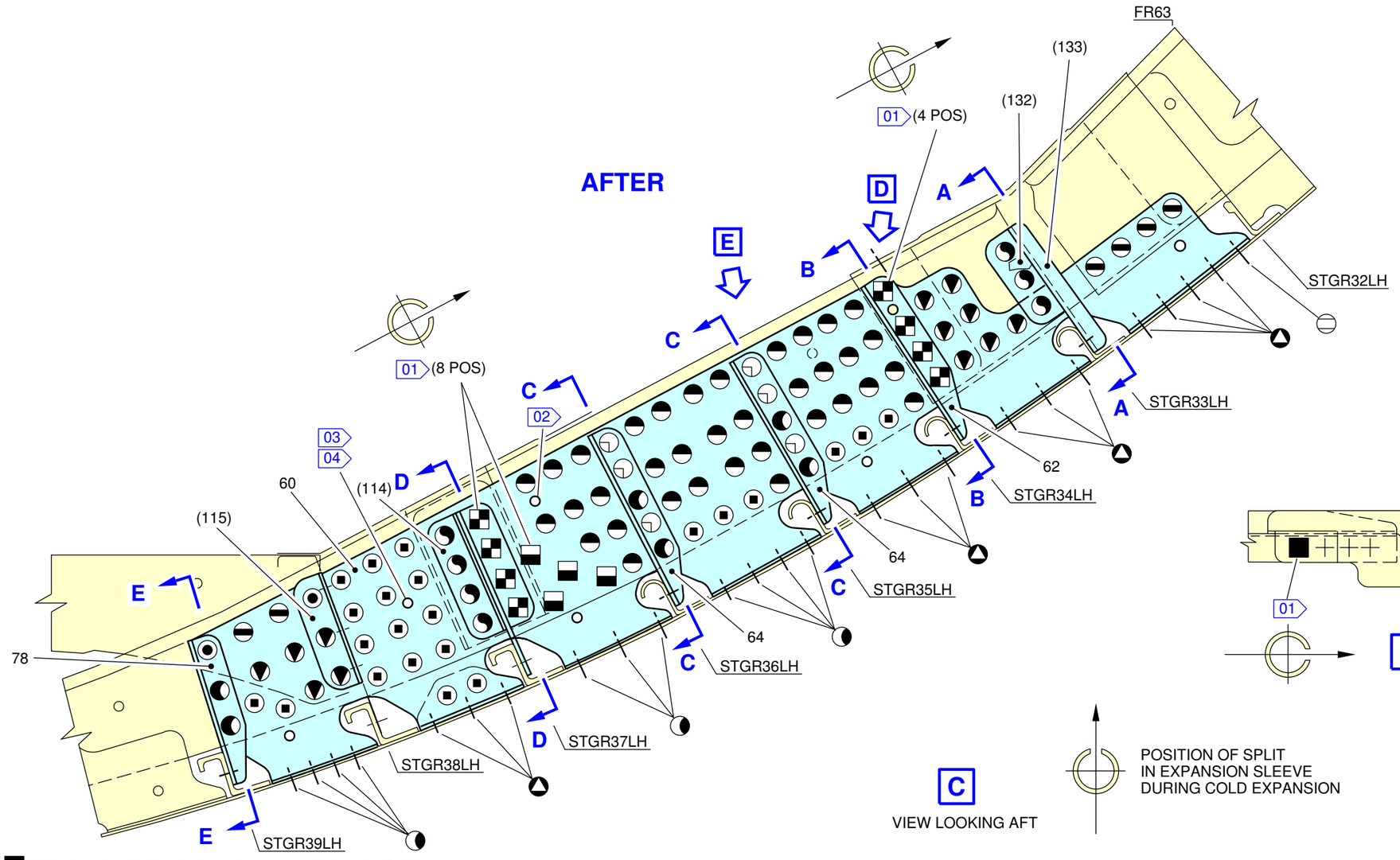
**CONF 009



NOTE:

01 ▬▪■ COLD EXPANSION STDN 4–4–N I.A.W. SRM 51–48–00.

02 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

03 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 4.300 mm (0.1692 in).

04 VALID FOR MSN 4005 AND SUBSEQUENT.

+ EXISTING HOLE POSITION MUST BE USED FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BPAJ_02_01

Figure A-GBPAJ - Sheet 02
Replacement of Webs and Angles at Frame 63

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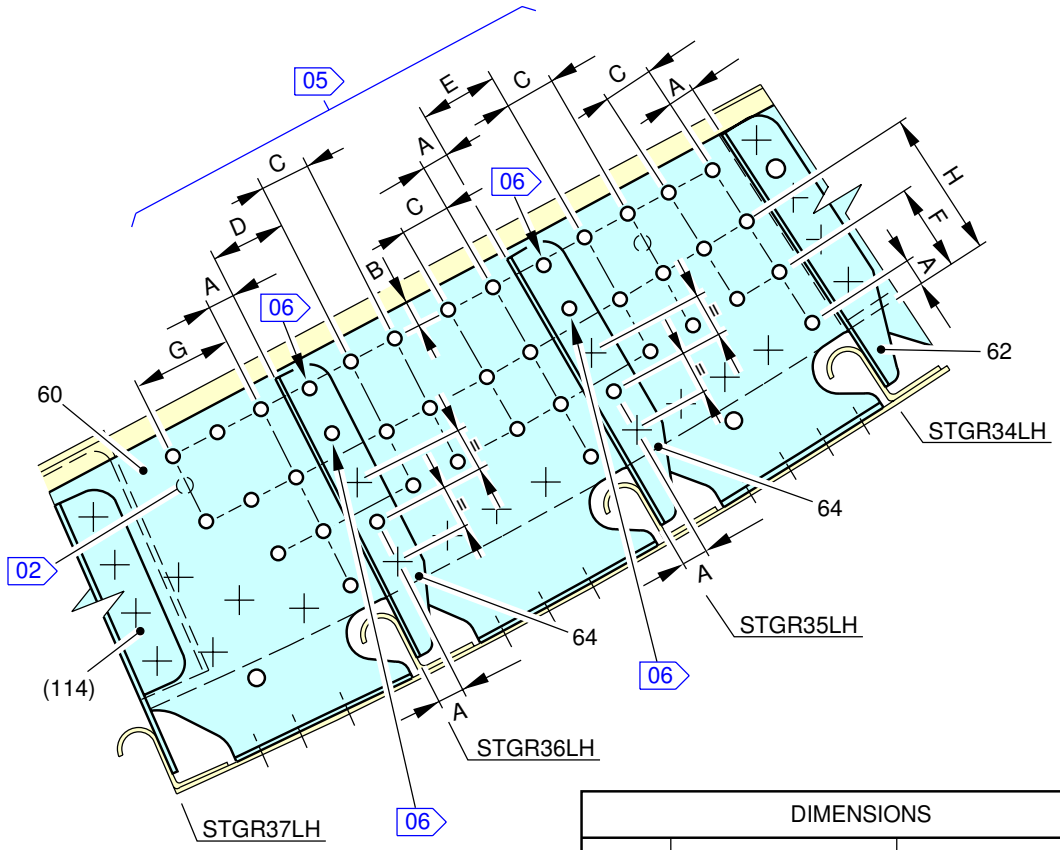
**CONF 009



E

VIEW WITHOUT RIVETS

DIMENSIONS		
	mm	(in)
A	10.00	0.394
B	11.00	0.433
C	19.00	0.748
D	28.50	1.122
E	29.70	1.169
F	33.00	1.299
G	2 x 19.00	2 x 0.748
H	56.00	2.205

NOTE:

02 TRANSFER DRILL THE TACK HOLE FROM THE FRAME TO THE NEW SHEAR WEB IN A DIAMETER OF 6.100 mm (0.2401 in). THIS HOLE WILL BE USED TO INSTALL A PLASTIC HOLDER TO FIX THE INSULATION MATS.

05 NEW HOLES.

06 EXISTING PILOT HOLES.

+ EXISTING HOLE POSITION MUST BE USED.

N_SB_531364_6_BPAJ_03_01

Figure A-GBPAJ - Sheet 03
Replacement of Webs and Angles at Frame 63

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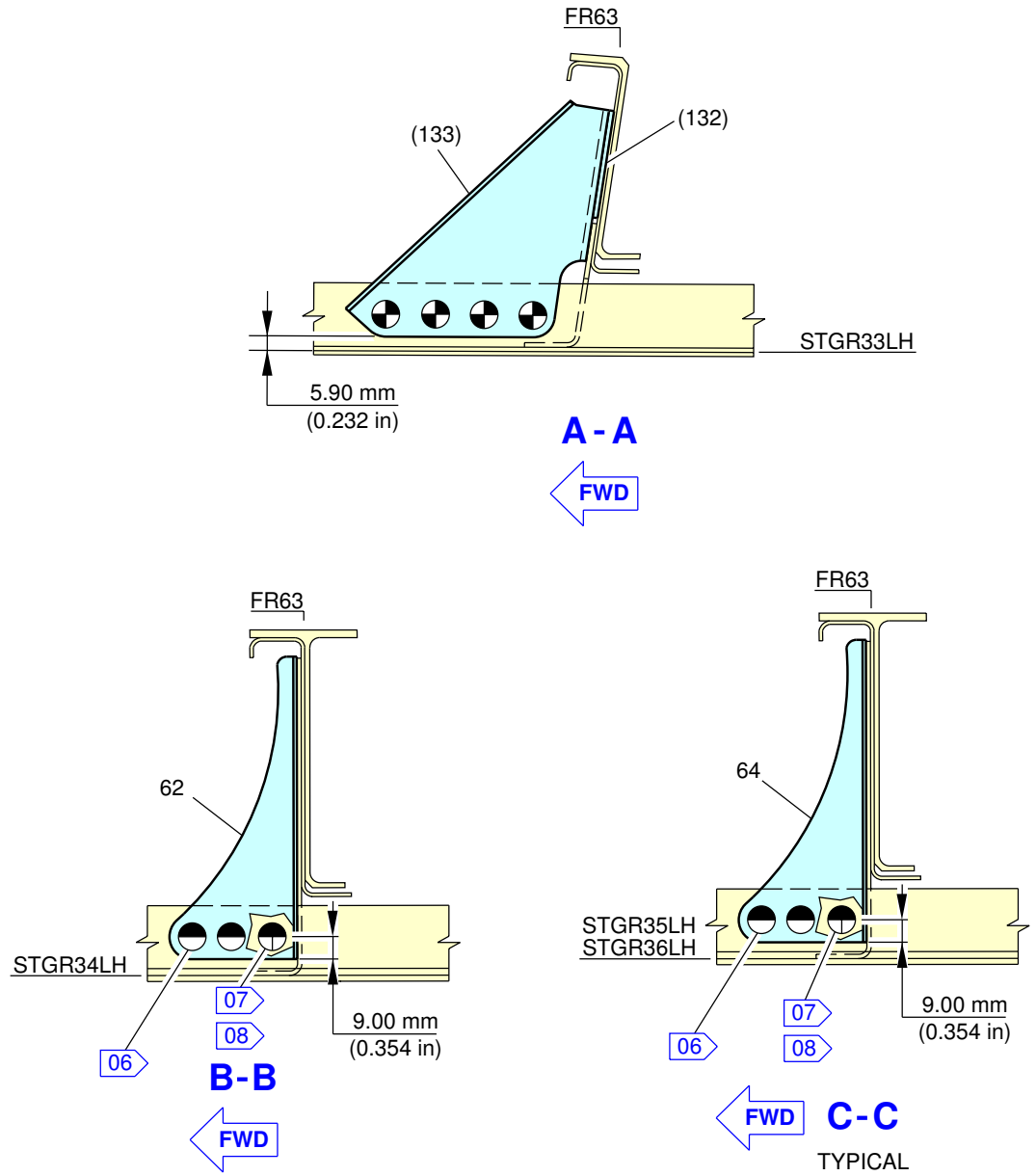
**CONF 009



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BPAJ_04_01

Figure A-GBPAJ - Sheet 04
Replacement of Webs and Angles at Frame 63

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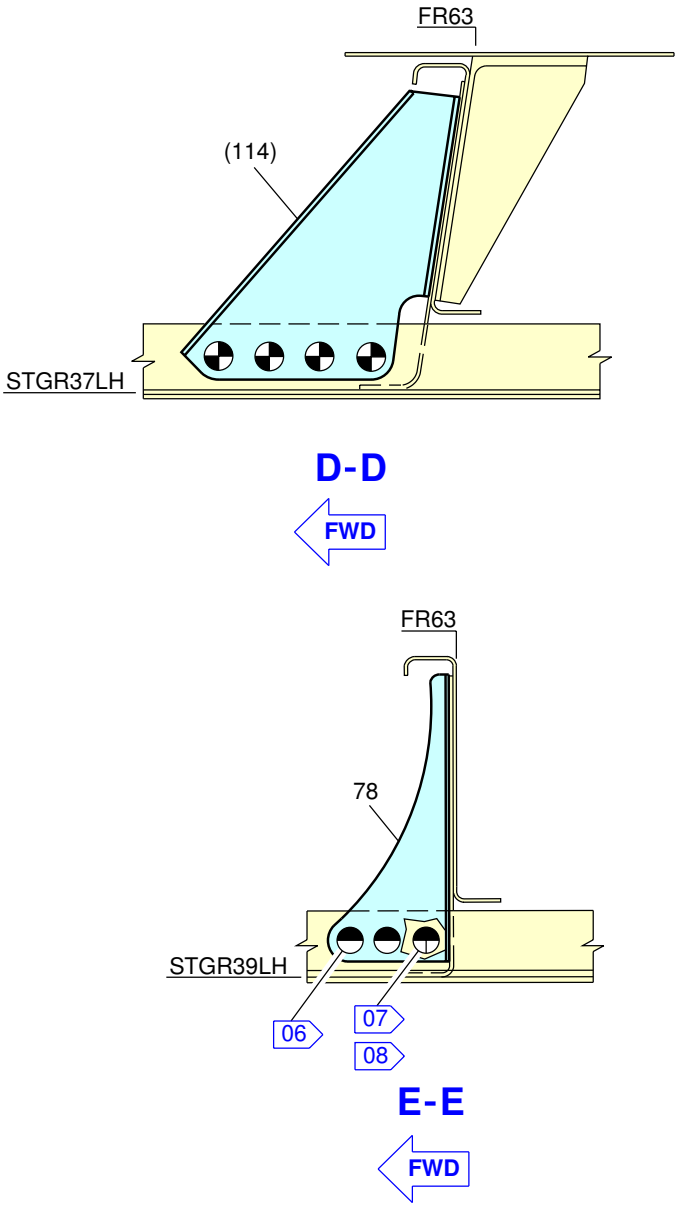
**CONF 009



NOTE:

06 EXISTING PILOT HOLES.

07 COUNTERSINK EXISTING HOLE IN THE STRINGER.

08 CLOSE EXISTING RIVET HOLE IN STRINGER ONLY.

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BPAJ_05_01

Figure A-GBPAJ - Sheet 05
Replacement of Webs and Angles at Frame 63

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**CONF 009

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		REMARKS
					MIN	MAX	MIN	MAX	
	363	EN6115K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	365	EN6115K3–5	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						
	463	EN6114K3–3	PIN	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.723 mm (0.1860 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT
	808	ASNA2528–3	COLLAR						

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER		REMARKS
				MIN	MAX	
	555	EN6069D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	567	EN6069D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	666	EN6081D6–06	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	667	EN6081D6–07	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	668	EN6081D6–08	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	669	EN6081D6–09	RIVET	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	863	DAN6–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	864	DAN6–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	963	DAN5–6–3	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			

N_SB_531364_6_BPAJ_06_01

Figure A-GBPAJ - Sheet 06
Replacement of Webs and Angles at Frame 63

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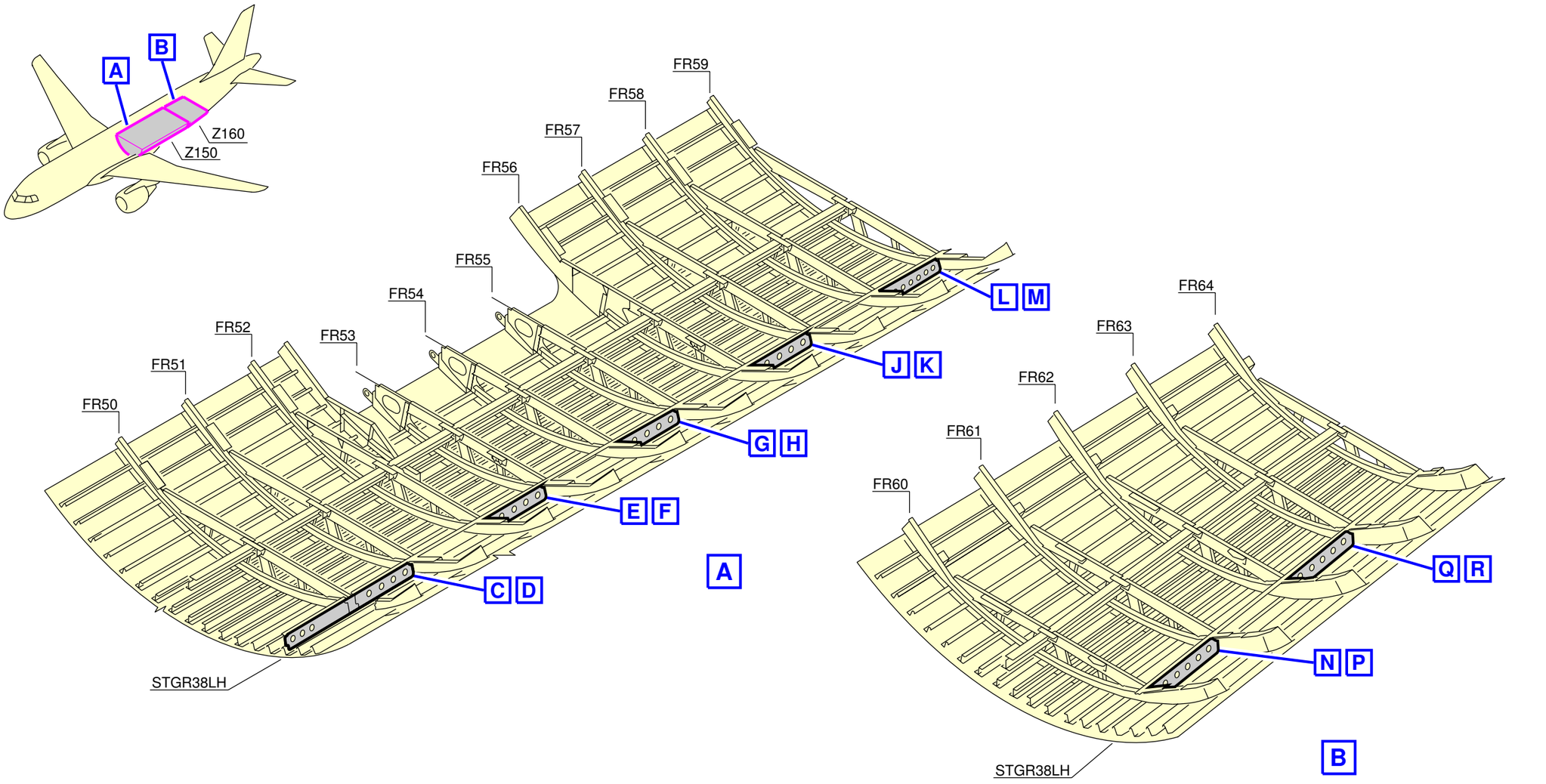
**CONF 001, 008



N_SB_531364_6_BQAA_01_00

Figure A-GBQAA - Sheet 01
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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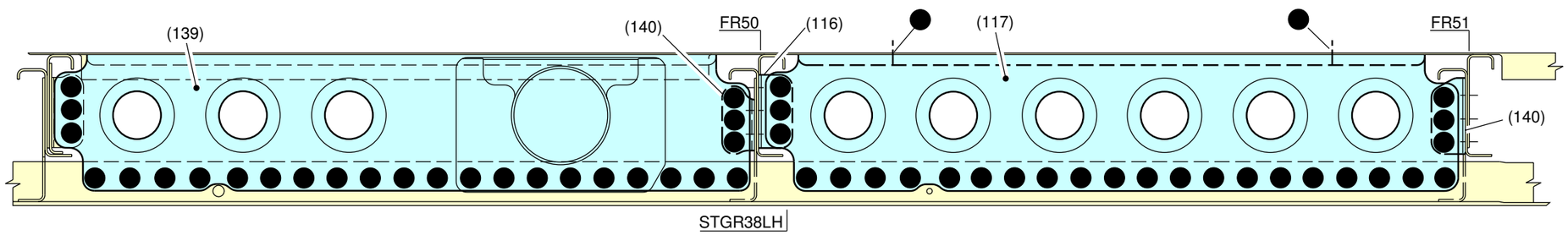
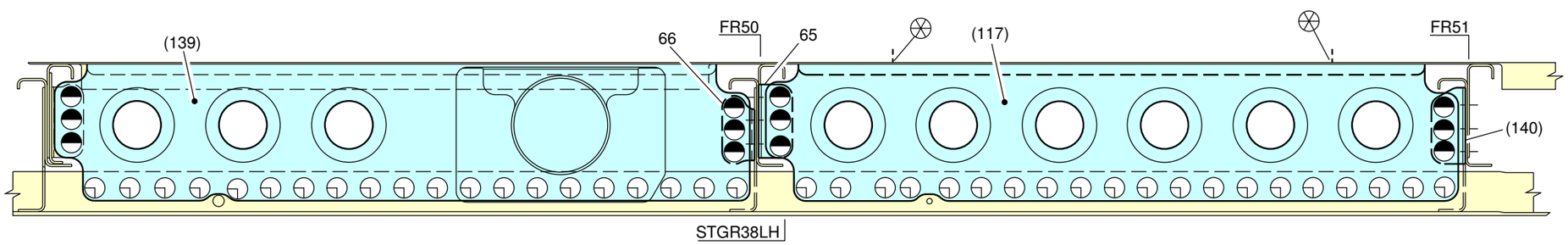
**CONF 001, 008

BEFORE



AFTER



NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6

N_SB_531364_6_BQAA_02_00

Figure A-GBQAA - Sheet 02
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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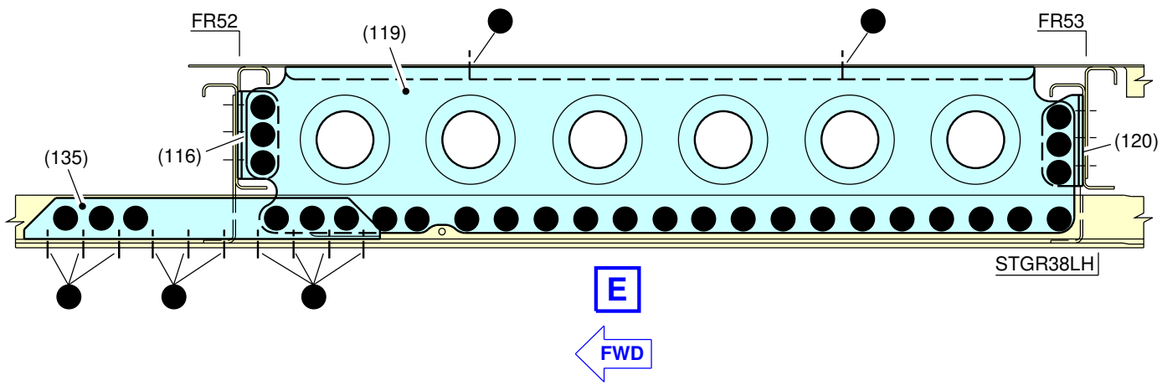
**CONF 001, 008

BEFORE



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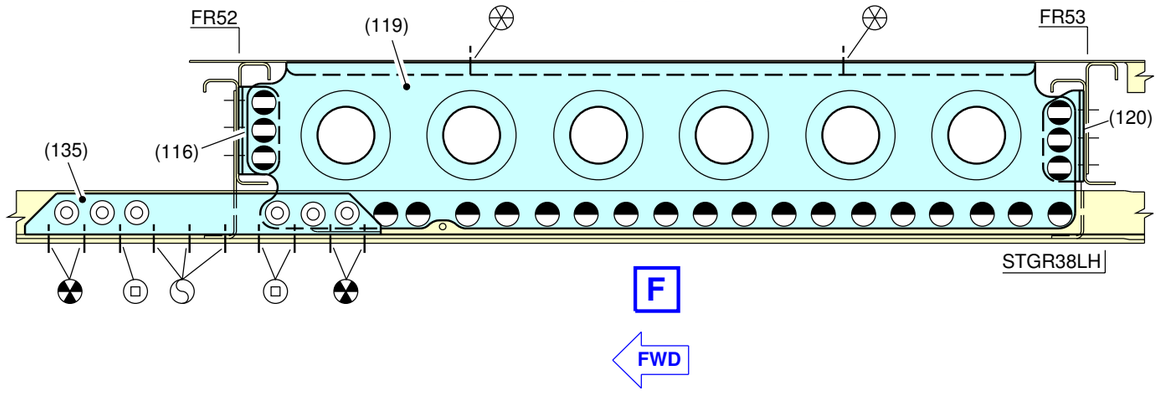

NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6

N_SB_531364_6_BQAA_03_00

Figure A-GBQAA - Sheet 03
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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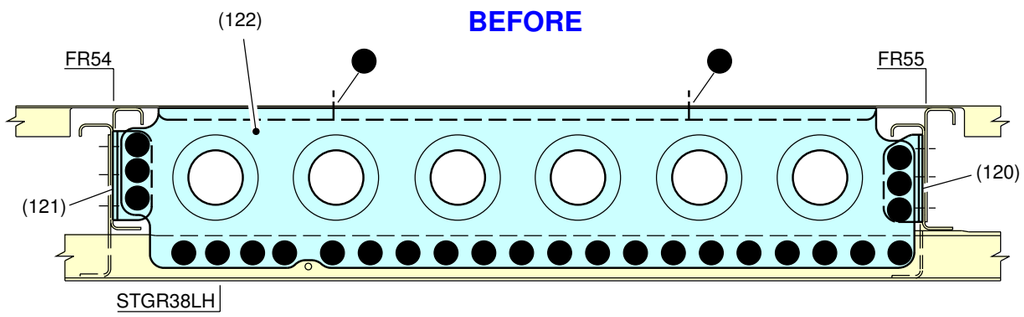
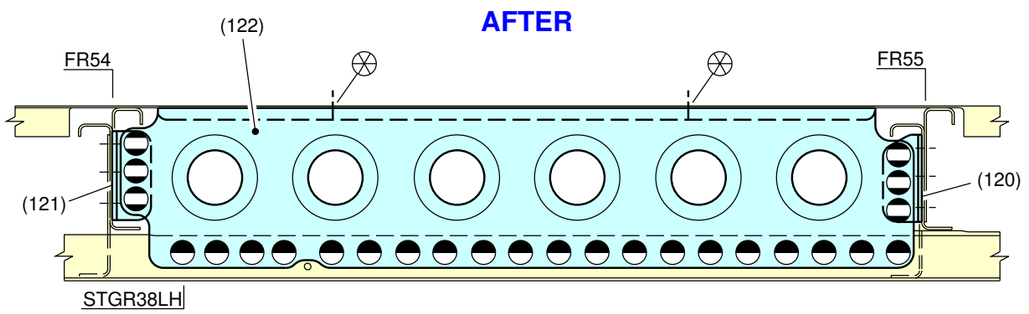
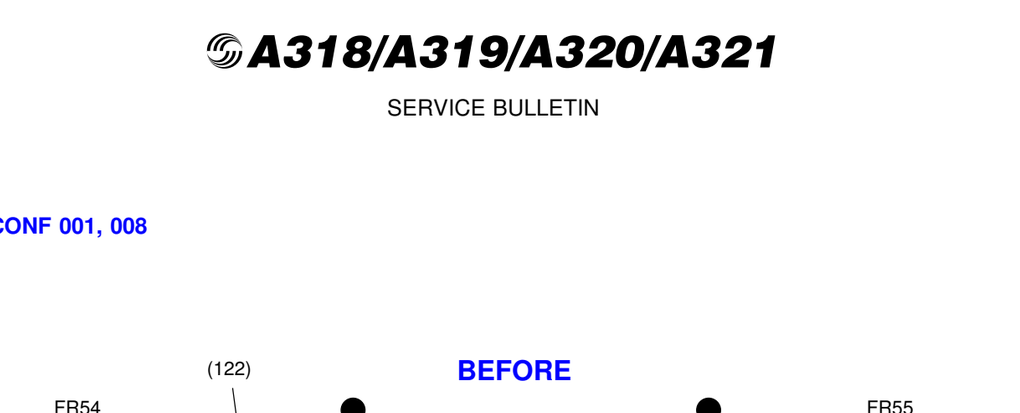
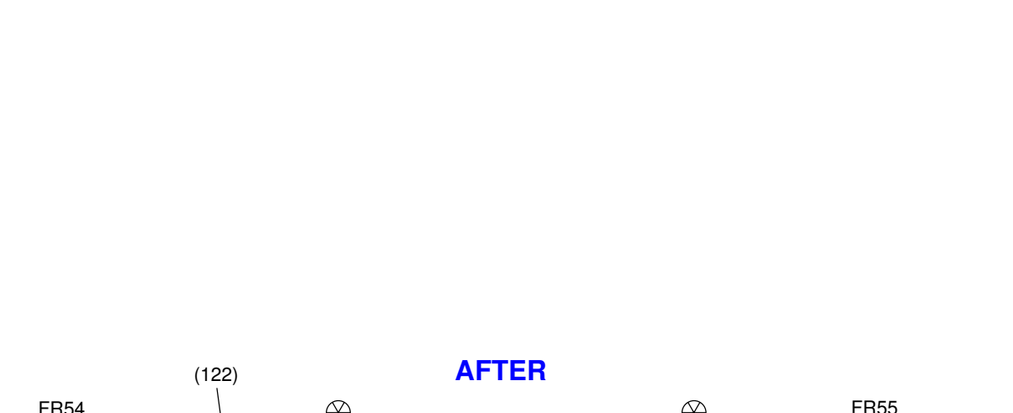
**CONF 001, 008









NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6

N_SB_531364_6_BQAA_04_00

Figure A-GBQAA - Sheet 04
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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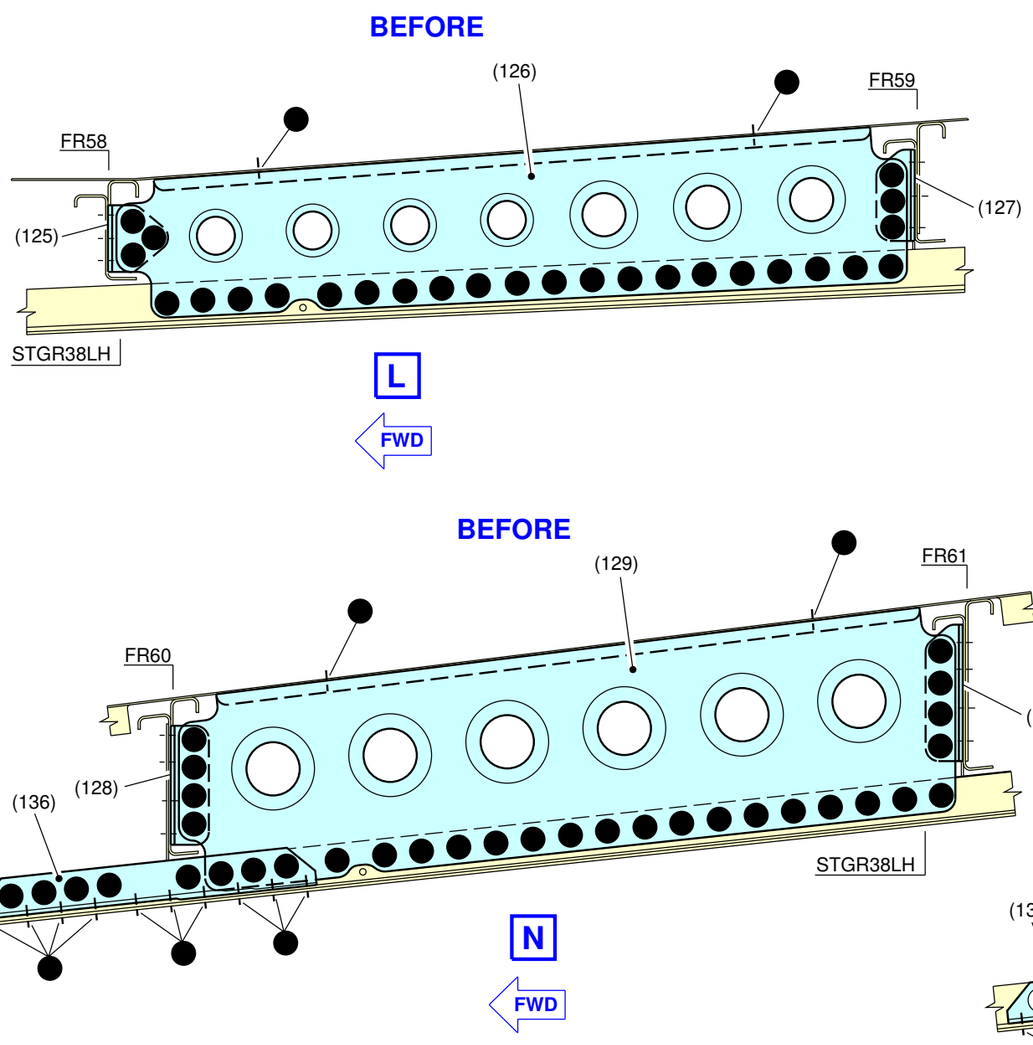
**CONF 001, 008



NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6

N_SB_531364_6_BQAA_05_00

Figure A-GBQAA - Sheet 05
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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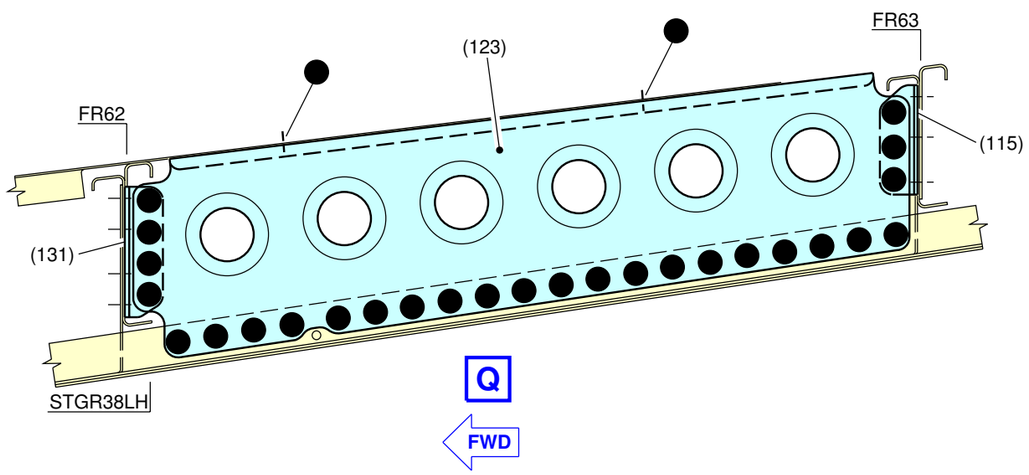
**CONF 001, 008

BEFORE



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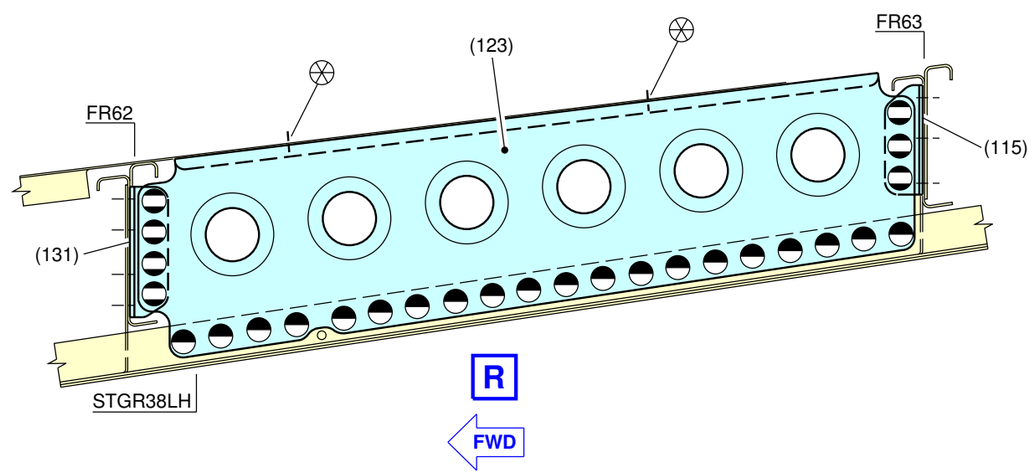

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	HOLE DIAMETER		REMARKS
				MIN	MAX	
⊗	544	EN6069D4–04	RIVET	3.250 mm (0.1280 in)	3.350 mm (0.1318 in)	NOMINAL SIZE
⊖	655	EN6081D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◒	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◵	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
⊖	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
◉	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	HOLE DIAMETER		REMARKS
				MIN	MAX	
◎	766	DAN5–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
⊜	864	DAN6–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
ⓥ	865	DAN6–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
☢	875	DAN6–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
⊡	876	DAN6–6–6X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
◵	877	DAN6–6–7X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			

NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BQAA_06_01

Figure A-GBQAA - Sheet 06
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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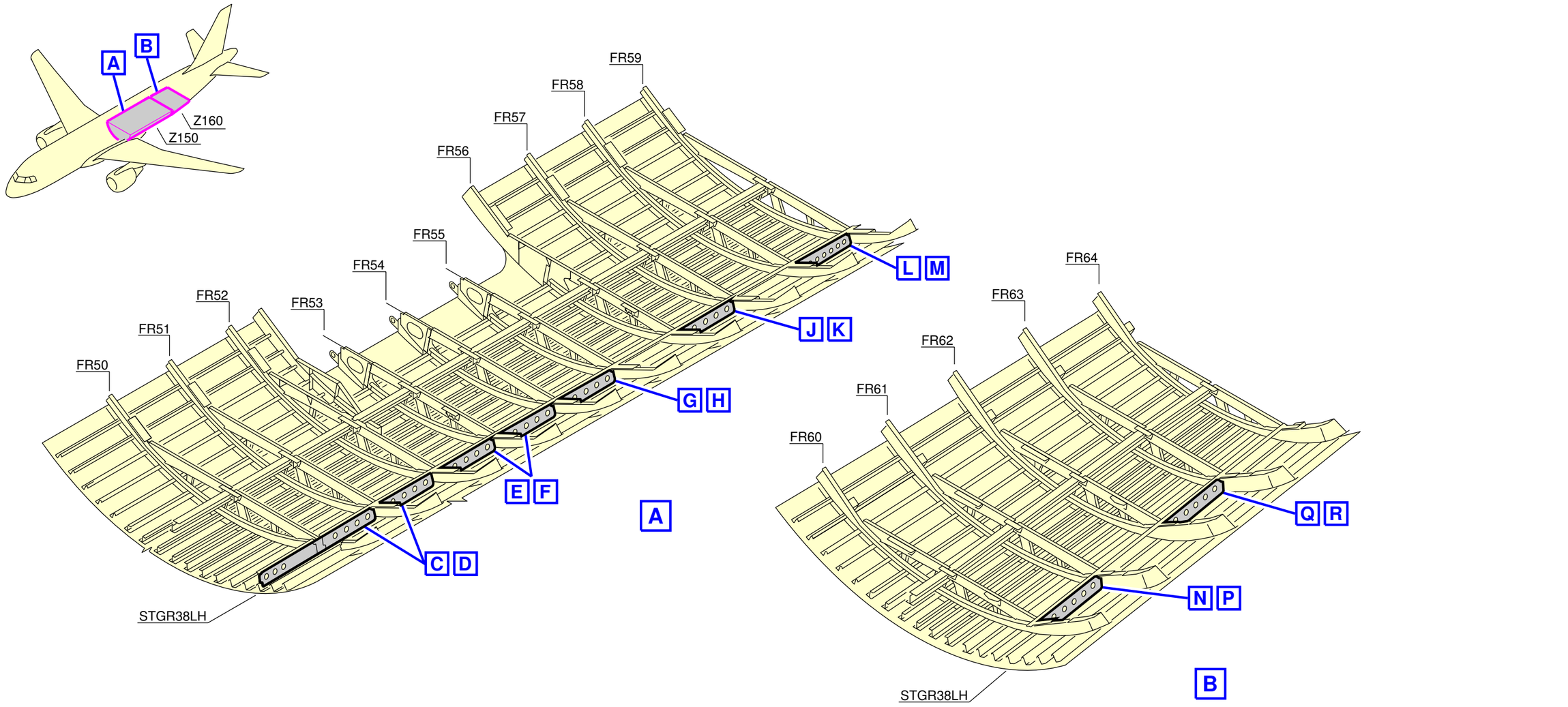
**CONF 002



N_SB_531364_6_BQAB_01_00

Figure A-GBQAB - Sheet 01
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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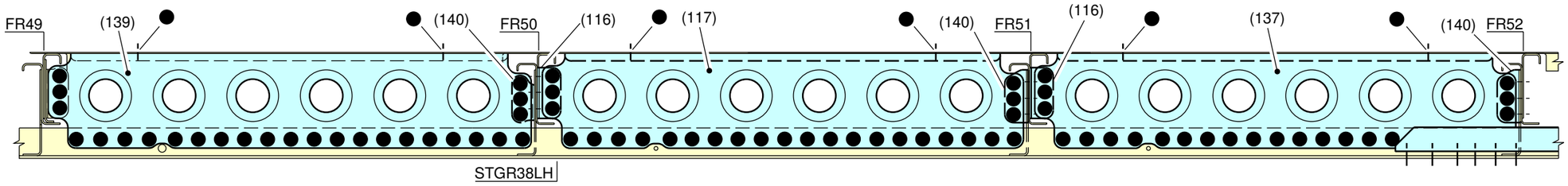
**CONF 002

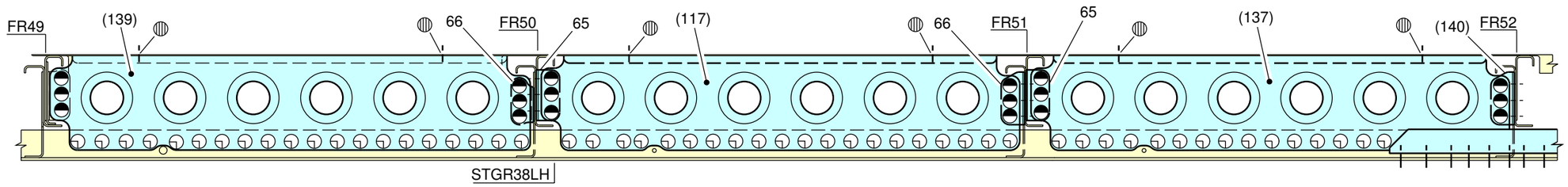
BEFORE



C

FWD

AFTER



D

FWD

NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6

N_SB_531364_6_BQAB_02_00

Figure A-GBQAB - Sheet 02
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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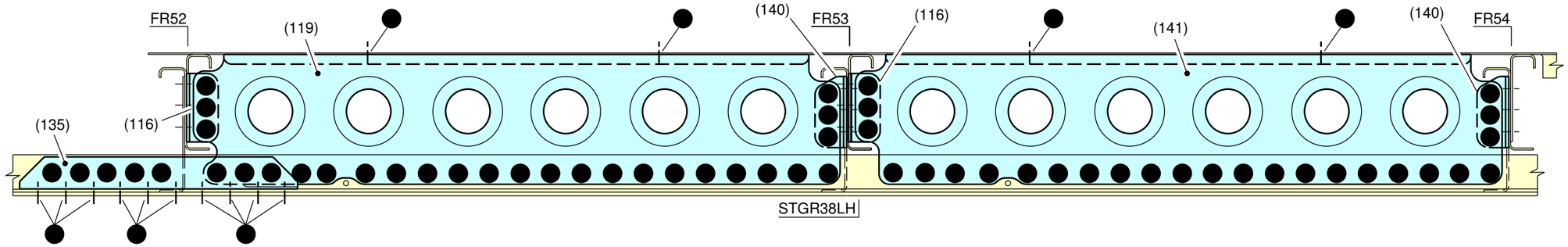
**CONF 002

BEFORE



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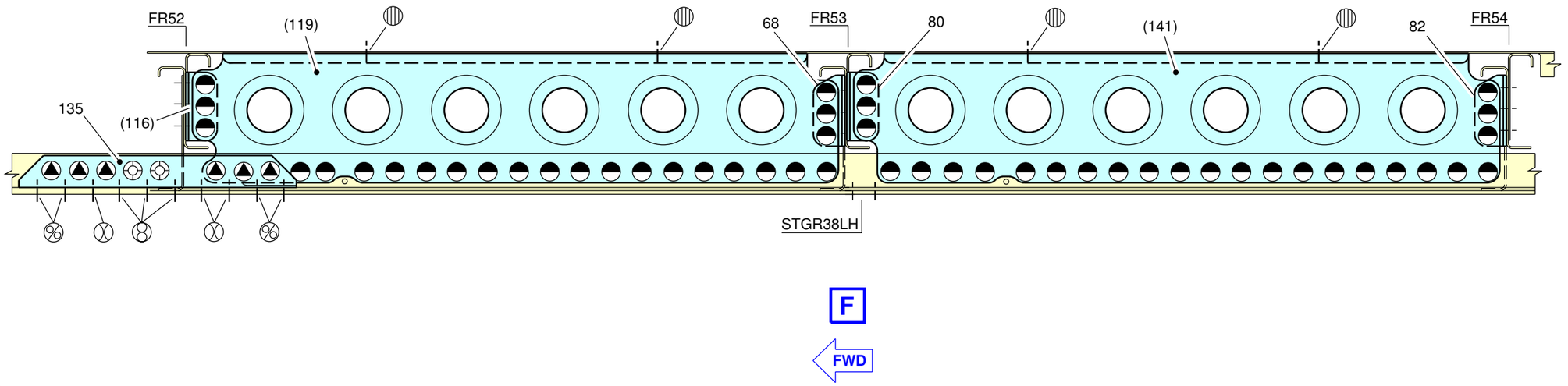

NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BQAB_03_00

Figure A-GBQAB - Sheet 03
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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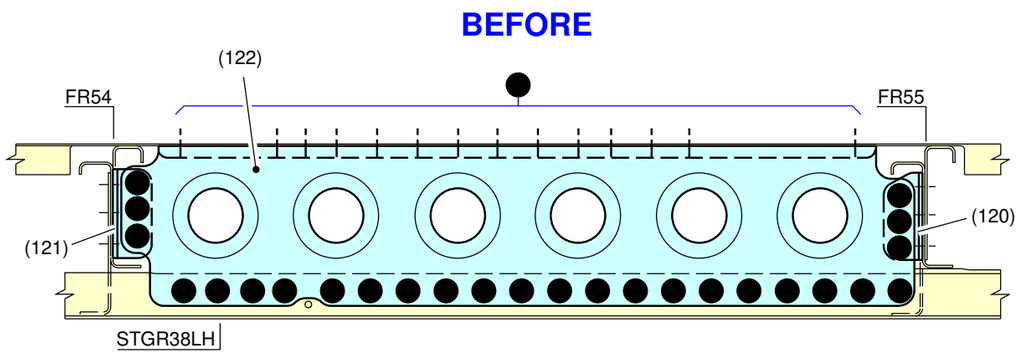
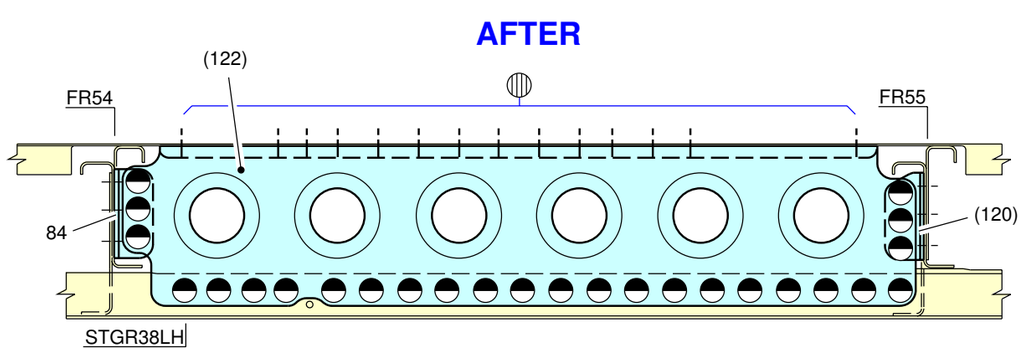
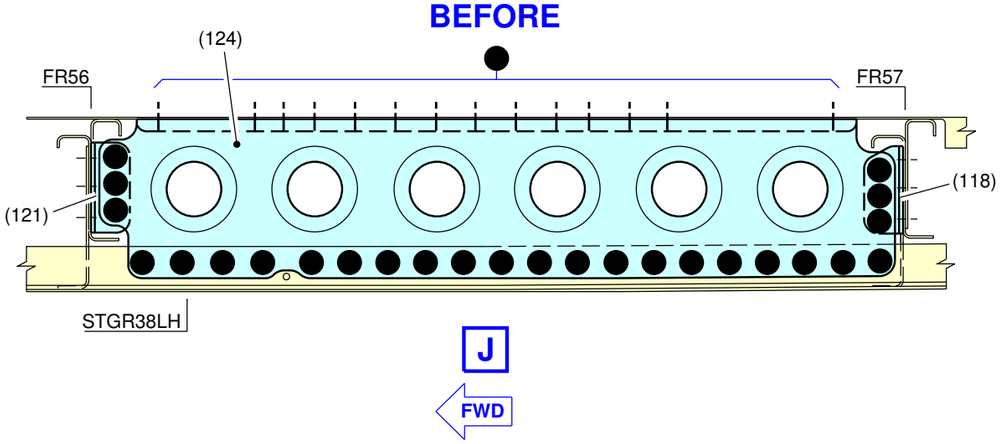
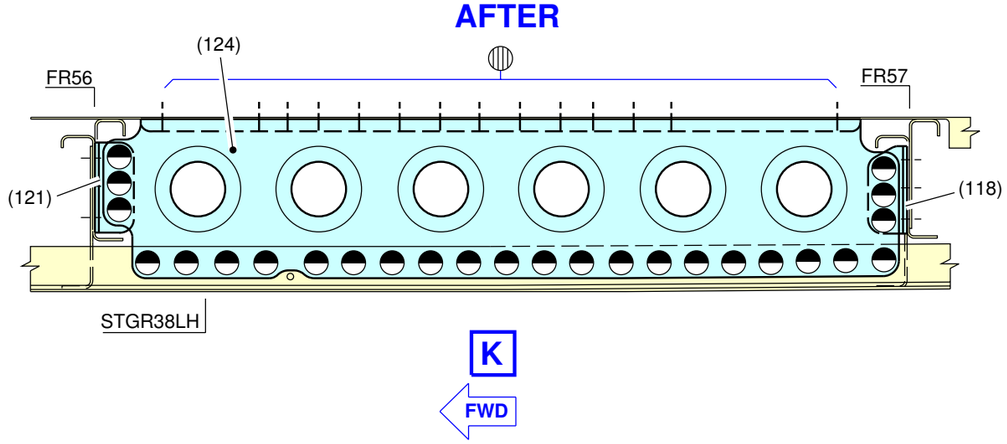
**CONF 002









NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BQAB_04_00

Figure A-GBQAB - Sheet 04
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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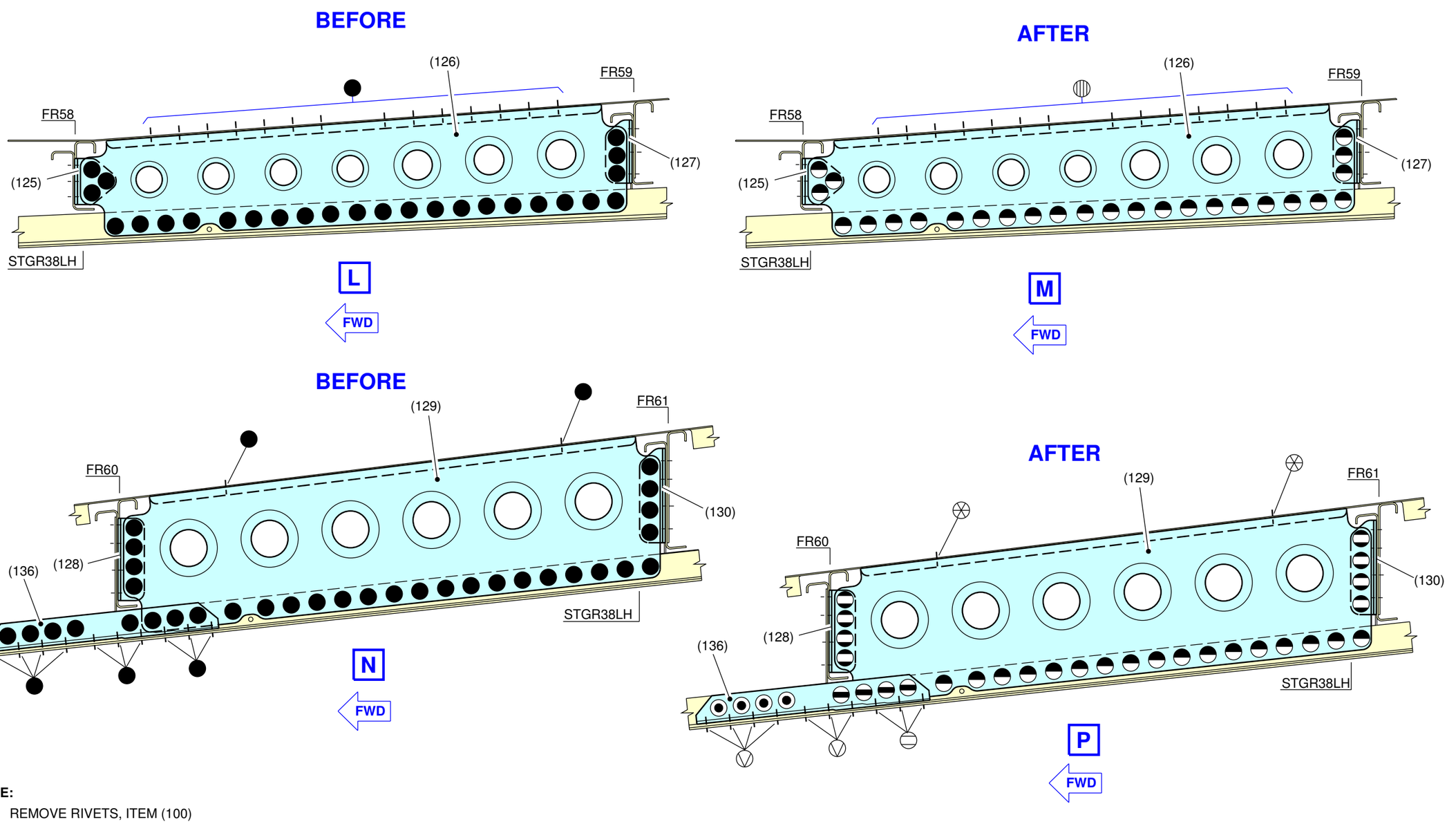
**CONF 002



NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BQAB_05_00

Figure A-GBQAB - Sheet 05
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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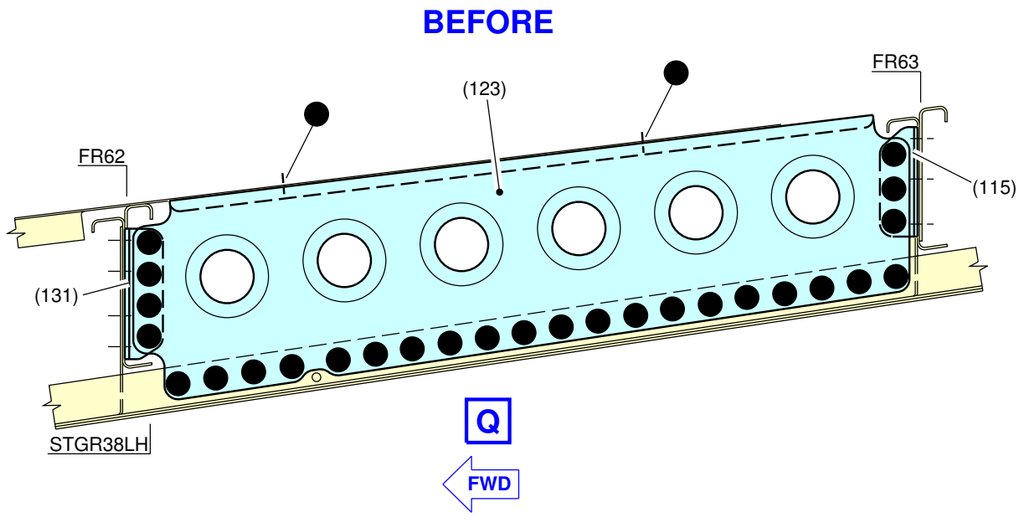
**CONF 002



HOLE SYMBOL	ITEM	P/N	DESCRIPTION	HOLE DIAMETER		REMARKS
				MIN	MAX	
	544	EN6069D4–04	RIVET	3.250 mm (0.1280 in)	3.350 mm (0.1318 in)	NOMINAL SIZE
	655	EN6081D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	545	EN6069D4–05	RIVET	3.250 mm (0.1280 in)	3.350 mm (0.1318 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	HOLE DIAMETER		REMARKS
				MIN	MAX	
	784	DAN5–6–4Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	786	DAN5–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	864	DAN6–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	865	DAN6–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	885	DAN6–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	886	DAN6–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	887	DAN6–6–7Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			

NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BQAB_06_01

Figure A-GBQAB - Sheet 06
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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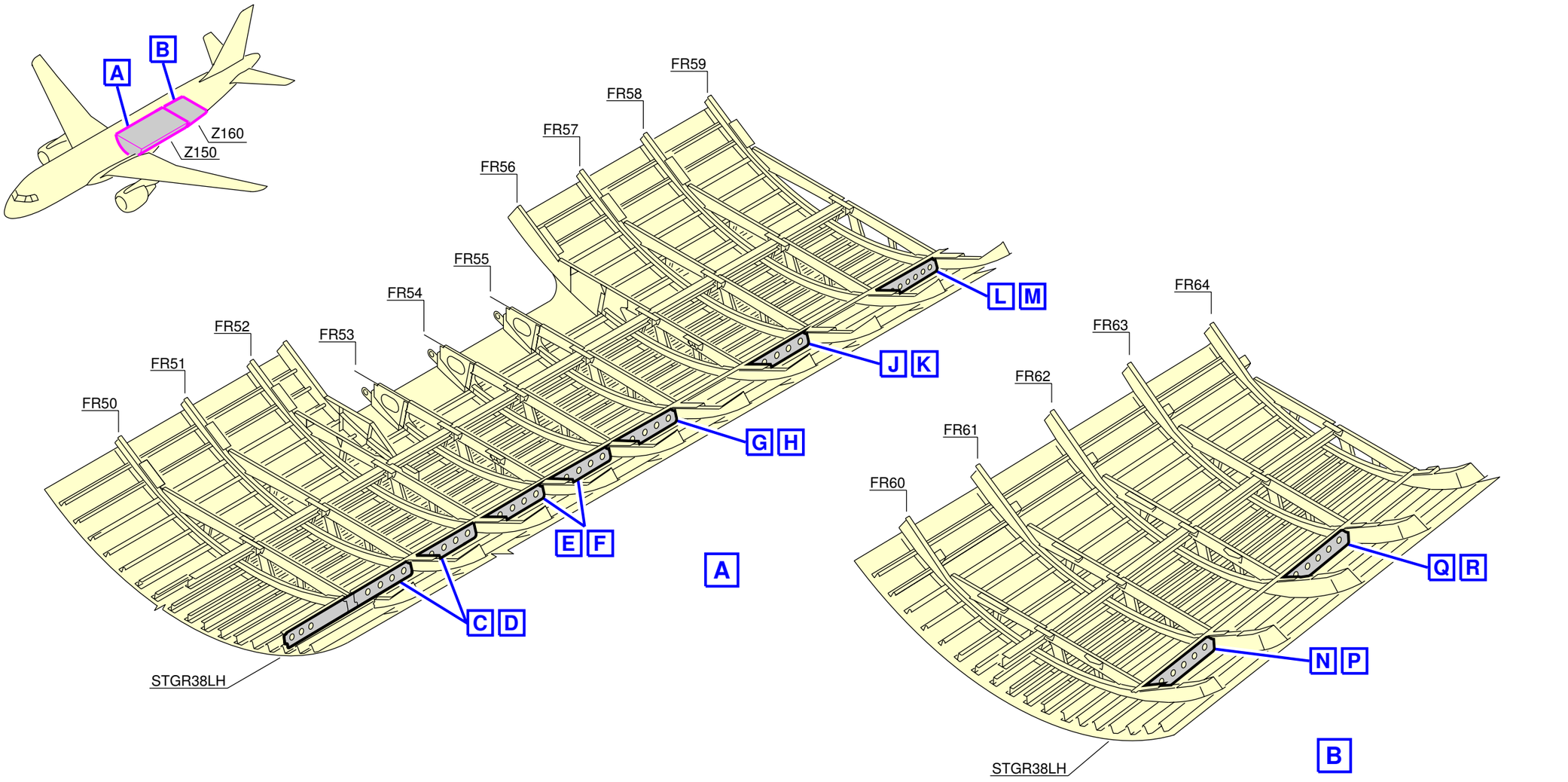
**CONF 003



N_SB_531364_6_BQAC_01_00

Figure A-GBQAC - Sheet 01
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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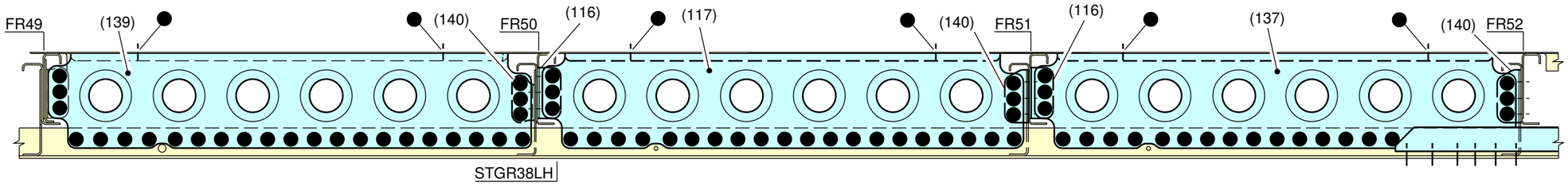
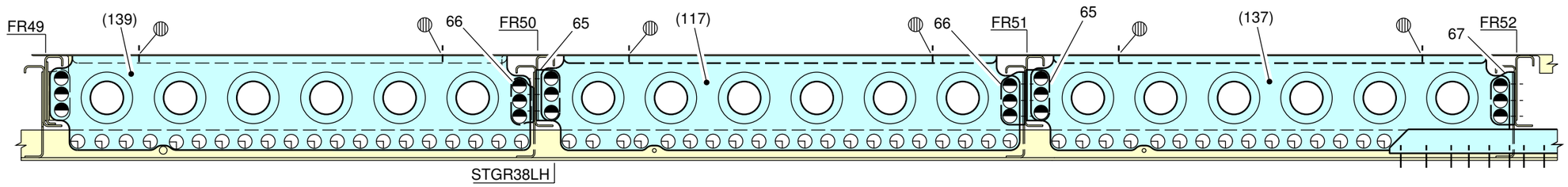
**CONF 003

BEFORE



AFTER



NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6

N_SB_531364_6_BQAC_02_00

Figure A-GBQAC - Sheet 02
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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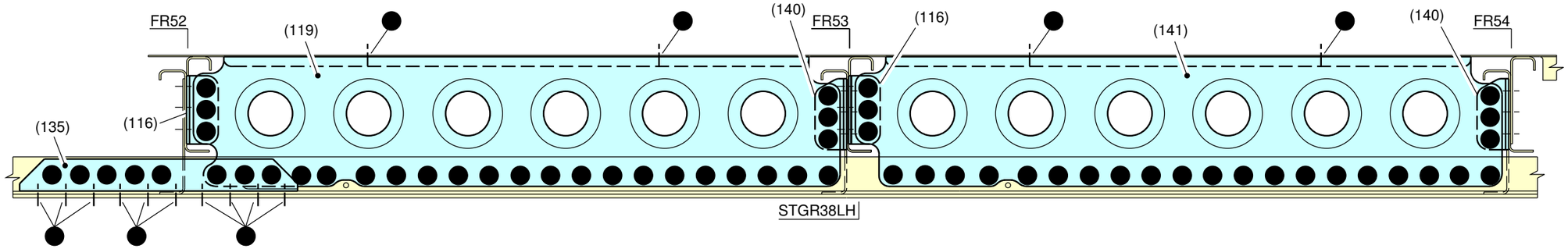
**CONF 003

BEFORE



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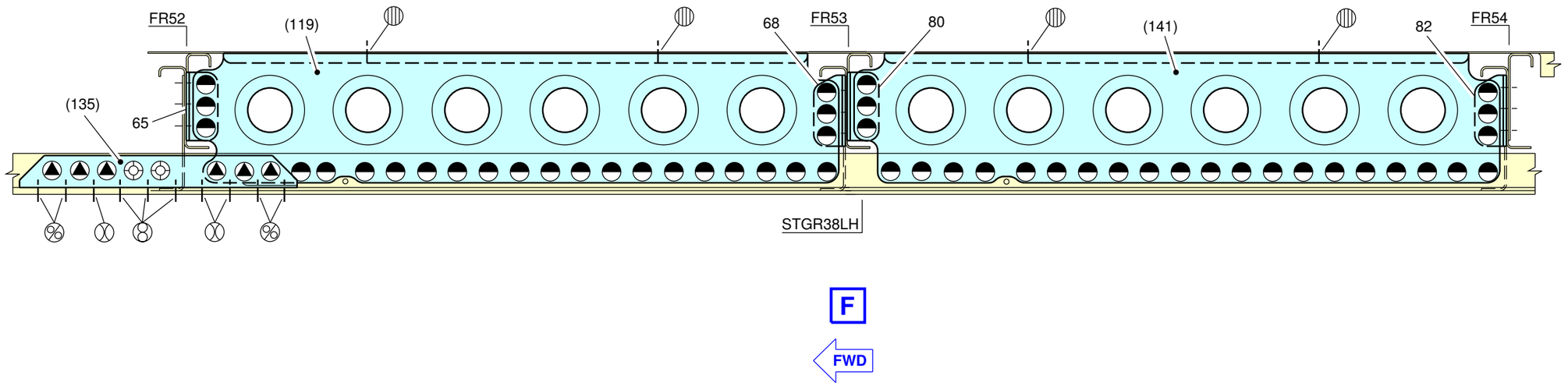

NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6

N_SB_531364_6_BQAC_03_00

Figure A-GBQAC - Sheet 03
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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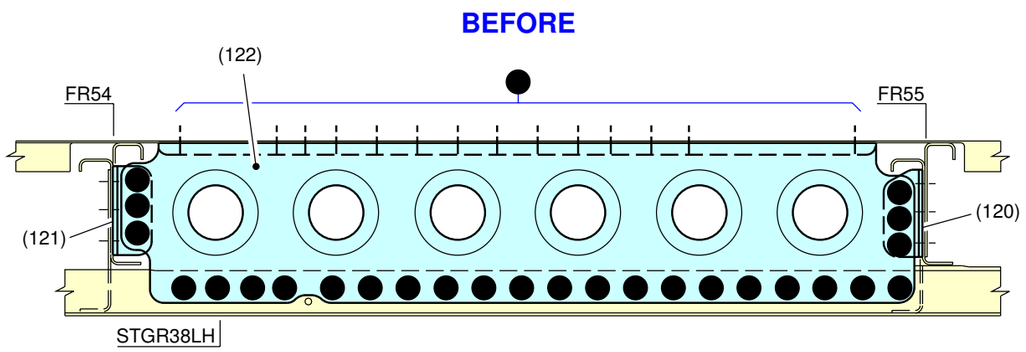
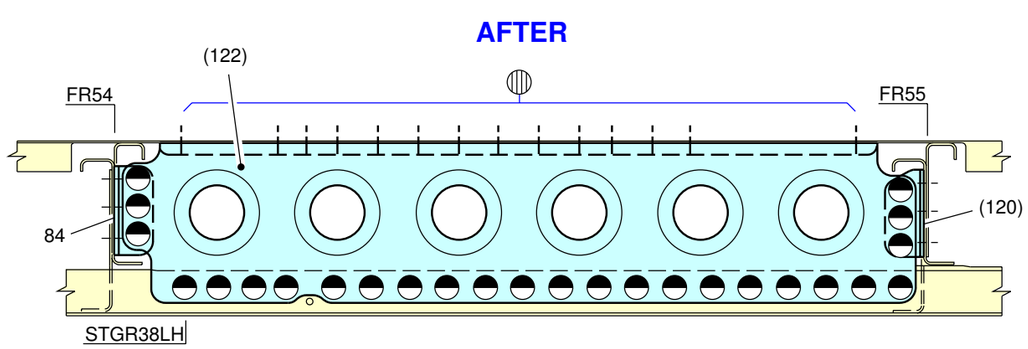
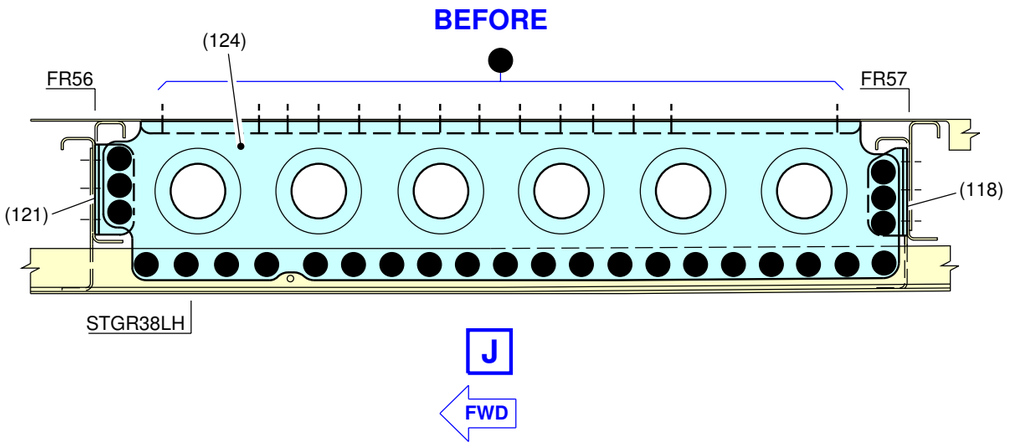
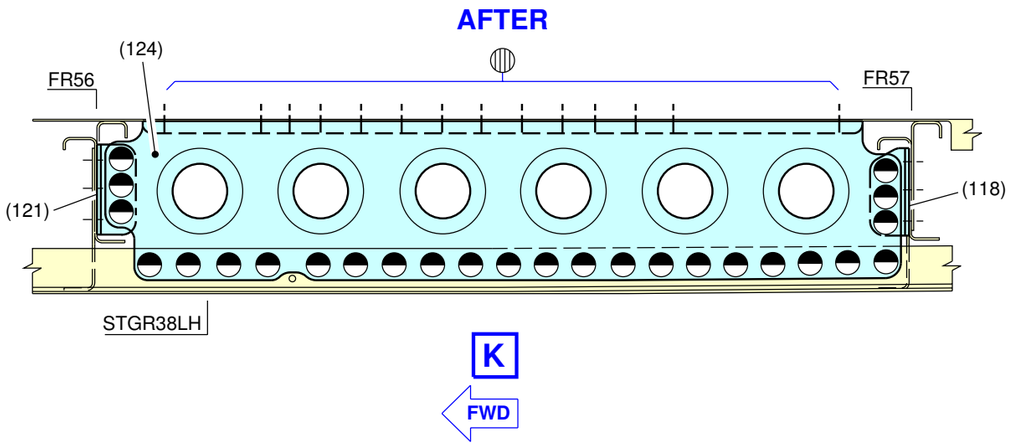
**CONF 003









NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6

N_SB_531364_6_BQAC_04_00

Figure A-GBQAC - Sheet 04
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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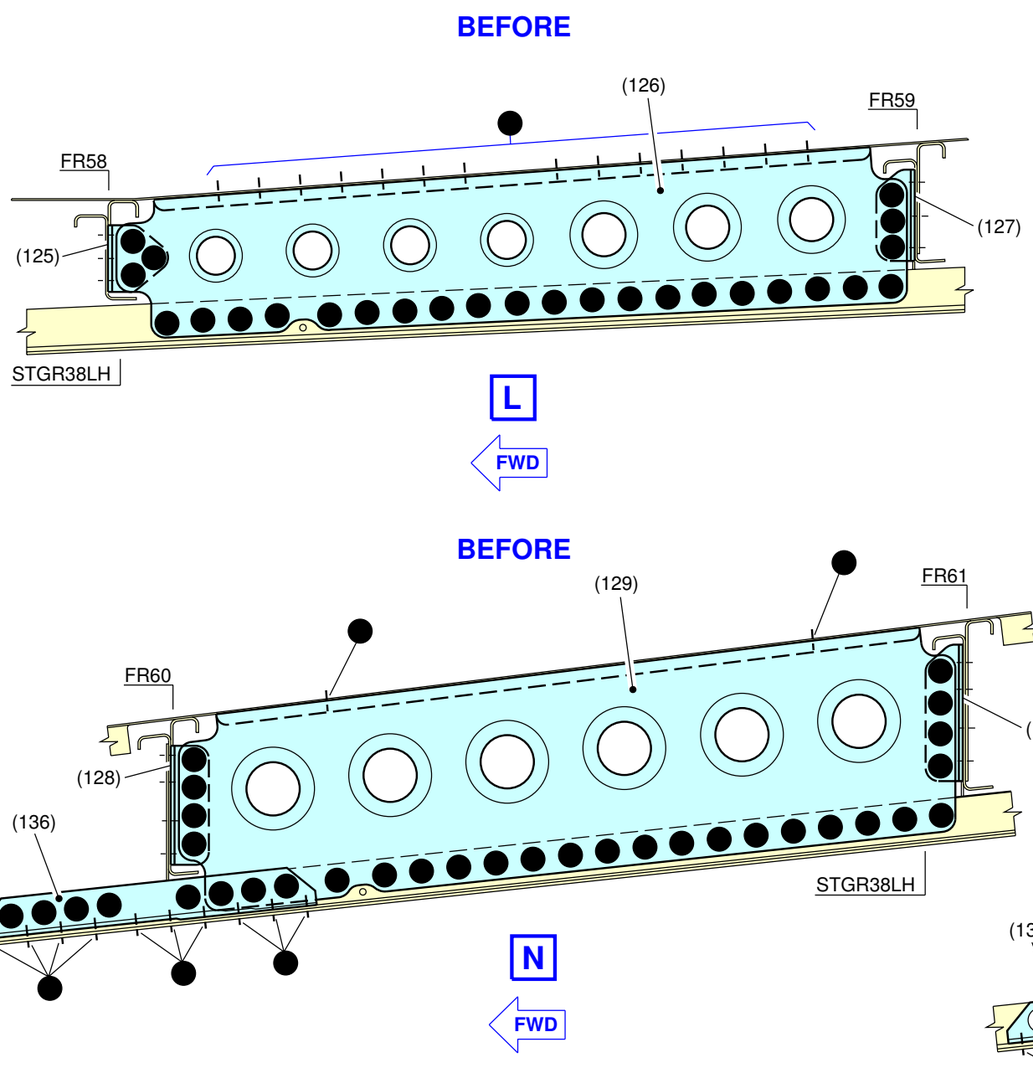
**CONF 003



NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6

N_SB_531364_6_BQAC_05_00

Figure A-GBQAC - Sheet 05
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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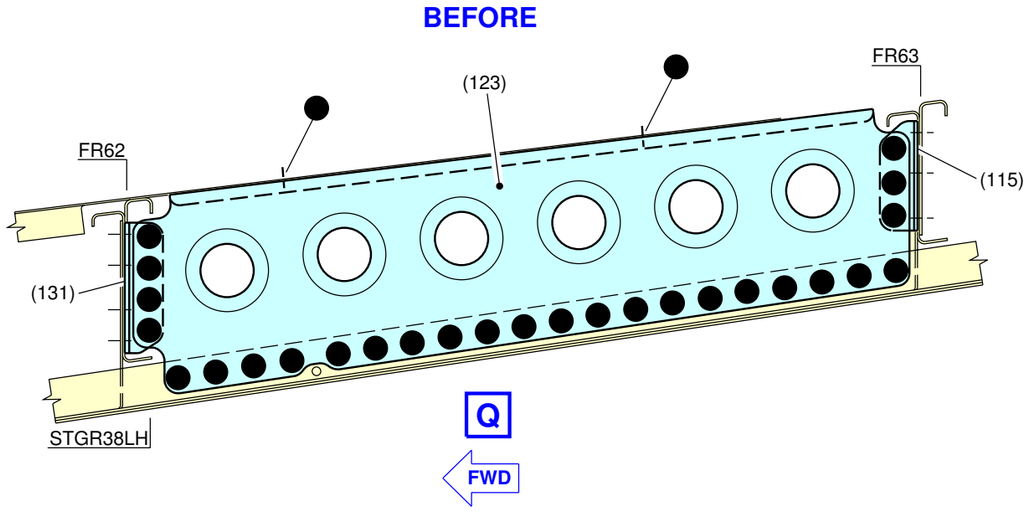
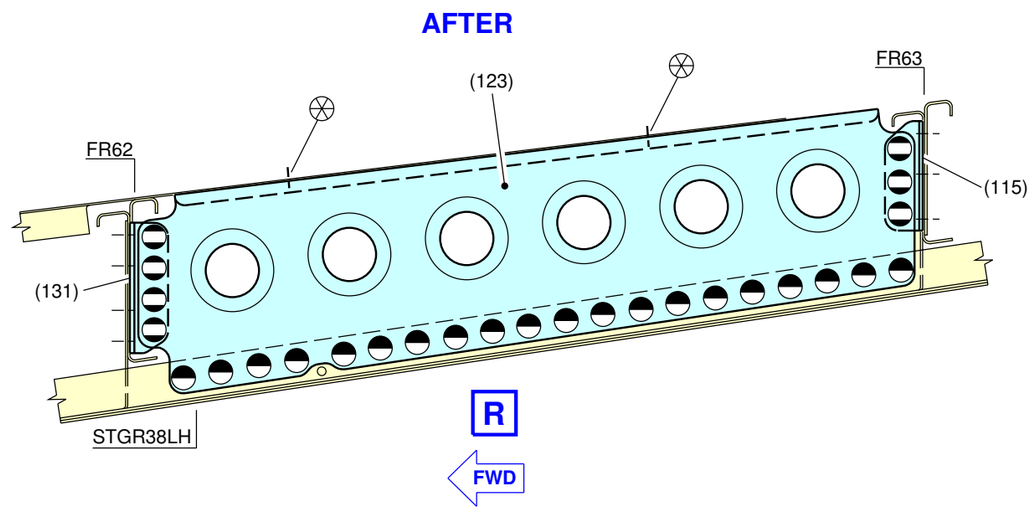
**CONF 003





HOLE SYMBOL	ITEM	P/N	DESCRIPTION	HOLE DIAMETER MIN	HOLE DIAMETER MAX	REMARKS
	544	EN6069D4–04	RIVET	3.250 mm (0.1280 in)	3.350 mm (0.1318 in)	NOMINAL SIZE
	545	EN6069D4–05	RIVET	3.250 mm (0.1280 in)	3.350 mm (0.1318 in)	NOMINAL SIZE
	655	EN6081D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	HOLE DIAMETER MIN	HOLE DIAMETER MAX	REMARKS
	784	DAN5–6–4Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	786	DAN5–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	864	DAN6–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	865	DAN6–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	885	DAN6–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	886	DAN6–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	887	DAN6–6–7Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			

NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BQAC_06_01

Figure A-GBQAC - Sheet 06
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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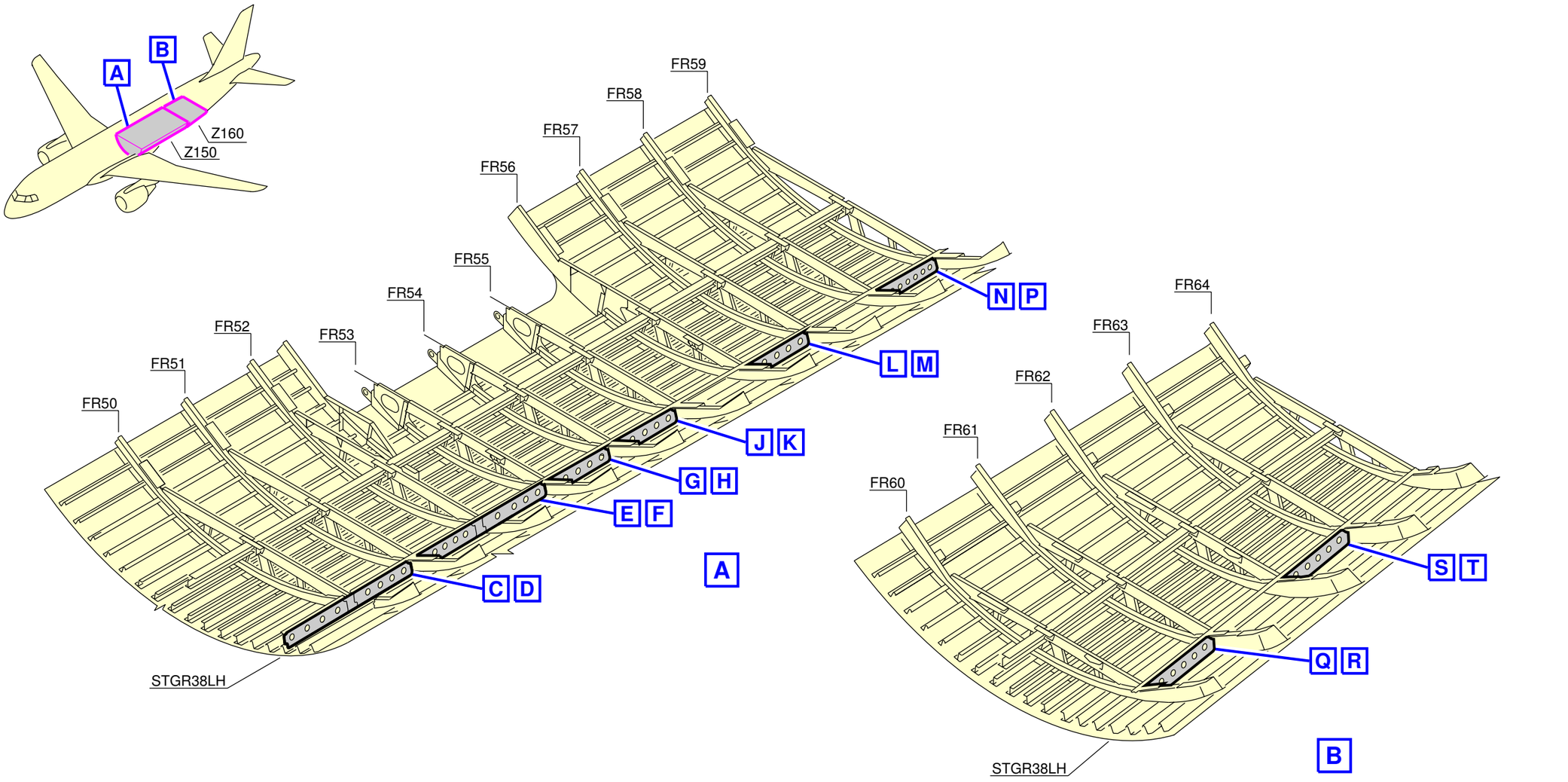
**CONF 004



N_SB_531364_6_BQAD_01_00

Figure A-GBQAD - Sheet 01
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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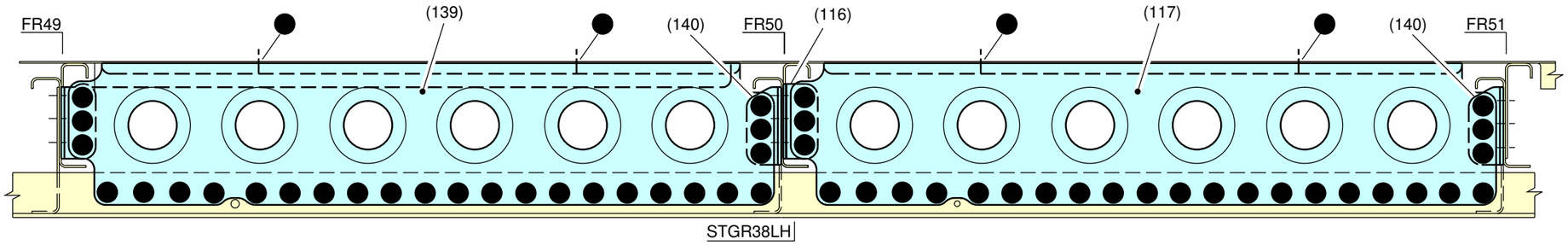
**CONF 004

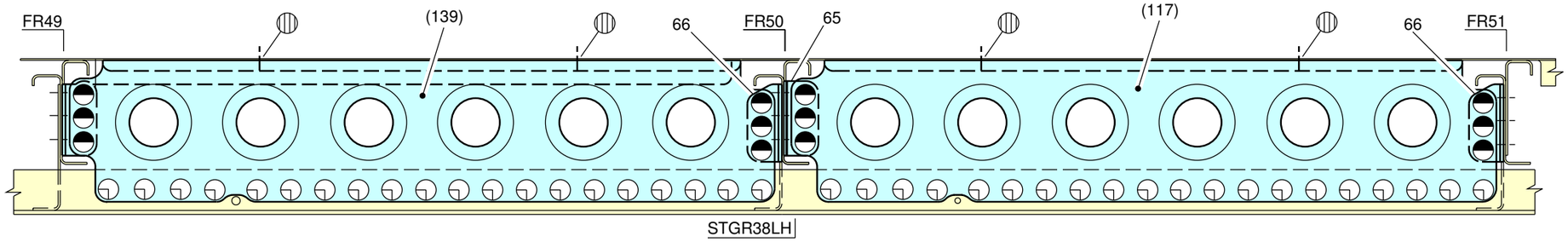
BEFORE



C

FWD

AFTER



D

FWD

NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 7.

N_SB_531364_6_BQAD_02_00

Figure A-GBQAD - Sheet 02
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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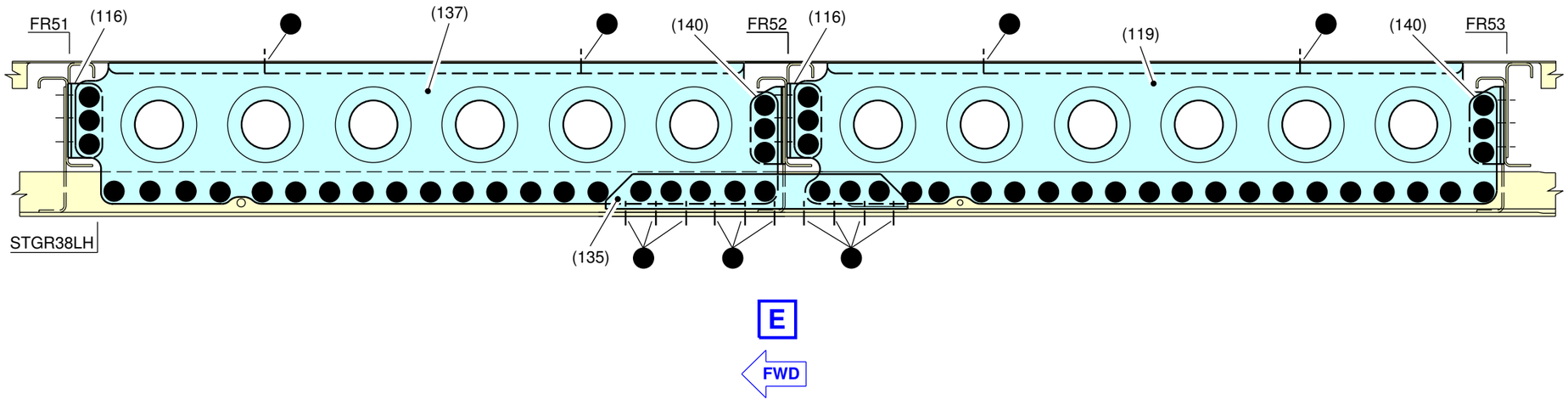
**CONF 004

BEFORE



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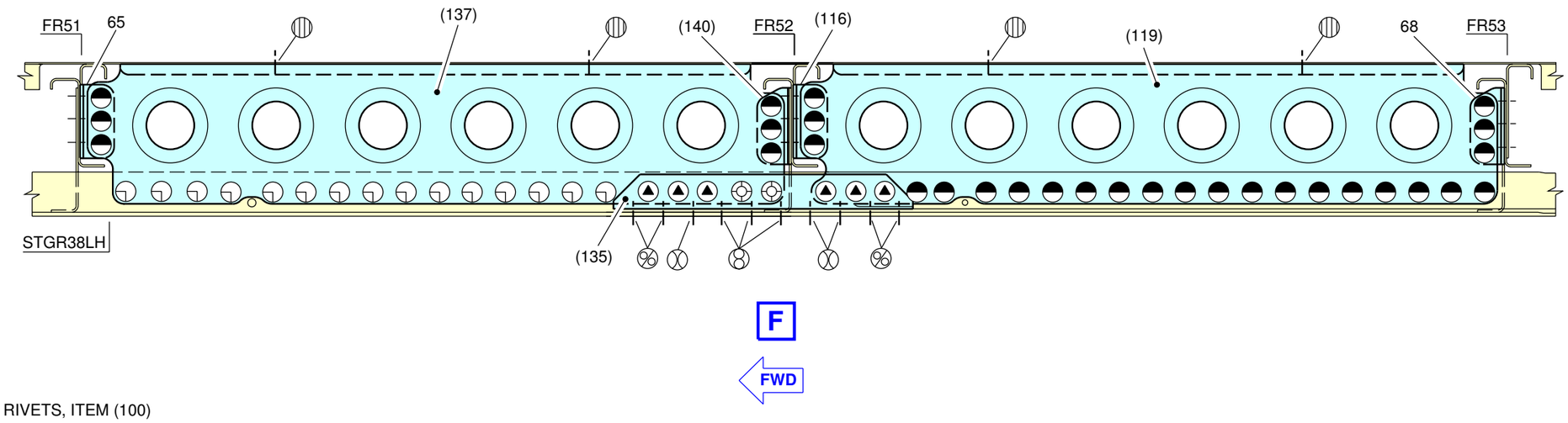

NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 7.

N_SB_531364_6_BQAD_03_00

Figure A-GBQAD - Sheet 03
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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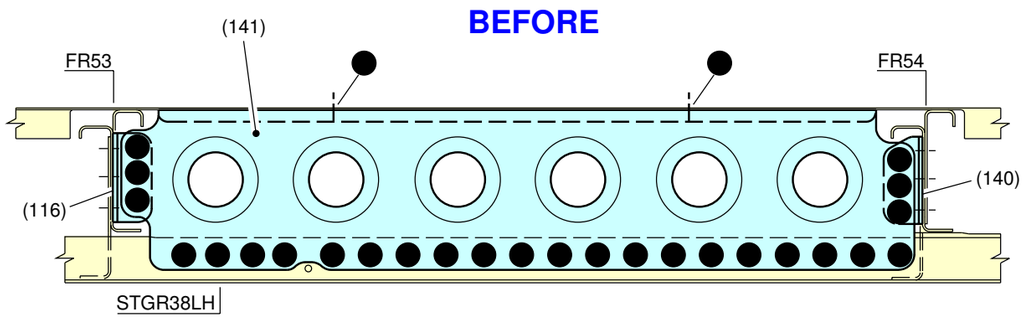
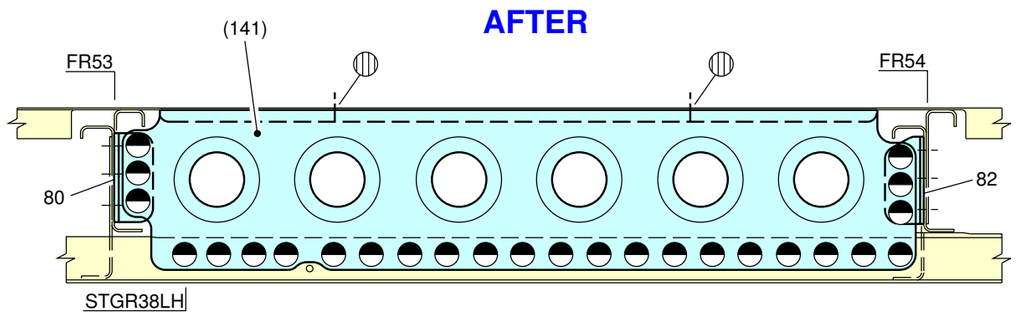
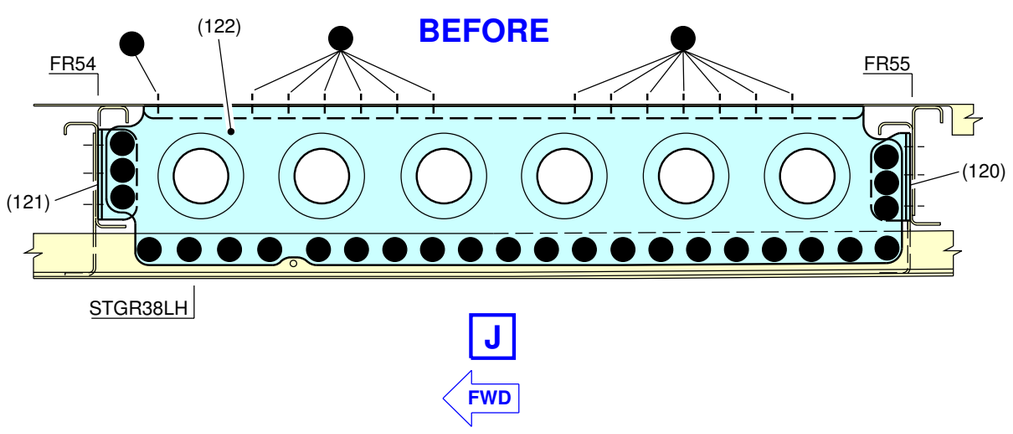
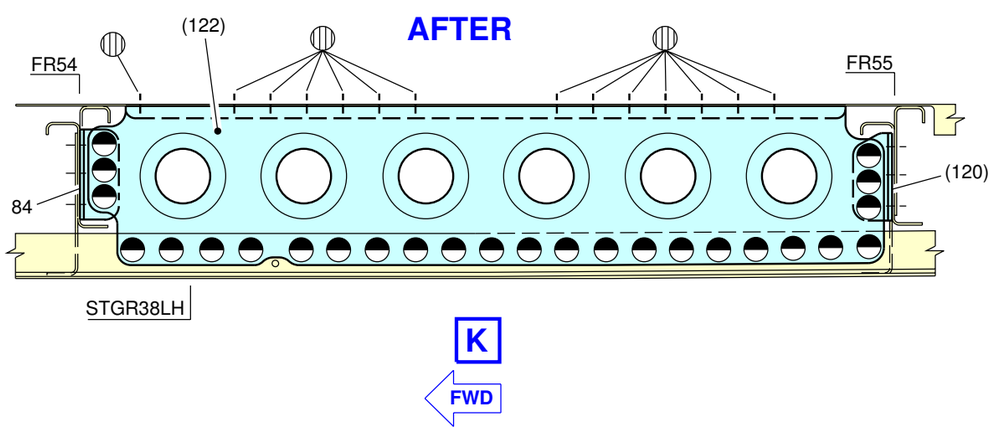
**CONF 004









NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 7.

N_SB_531364_6_BQAD_04_00

Figure A-GBQAD - Sheet 04
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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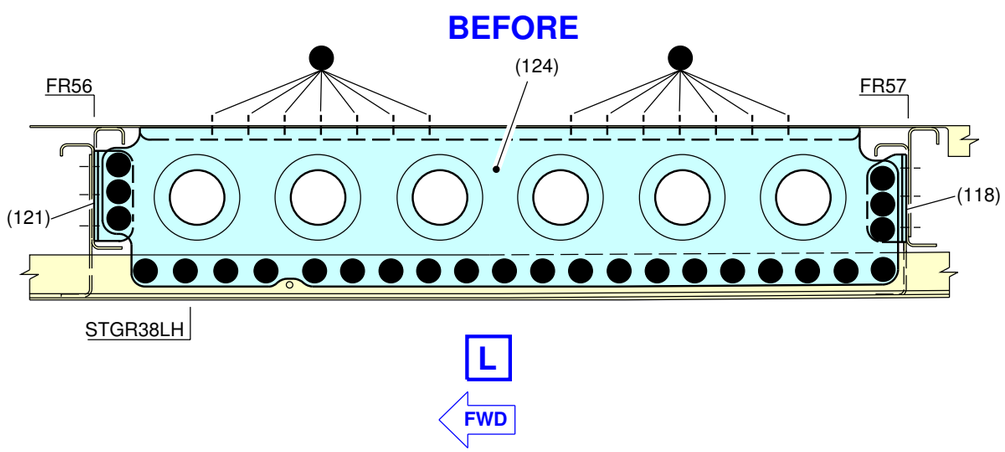
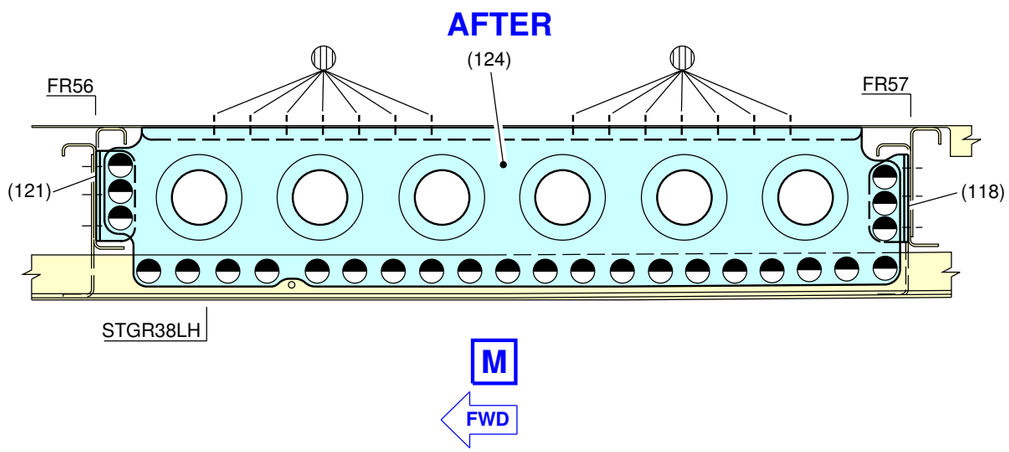
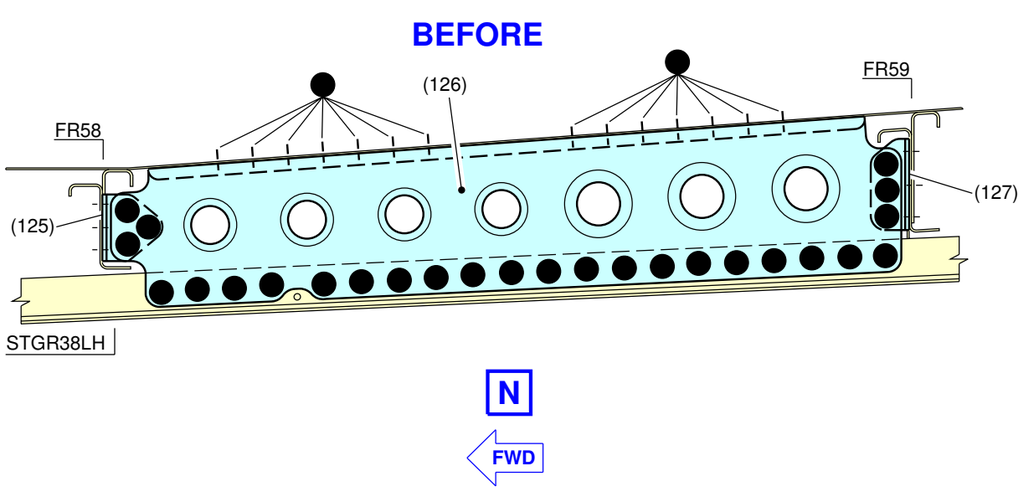
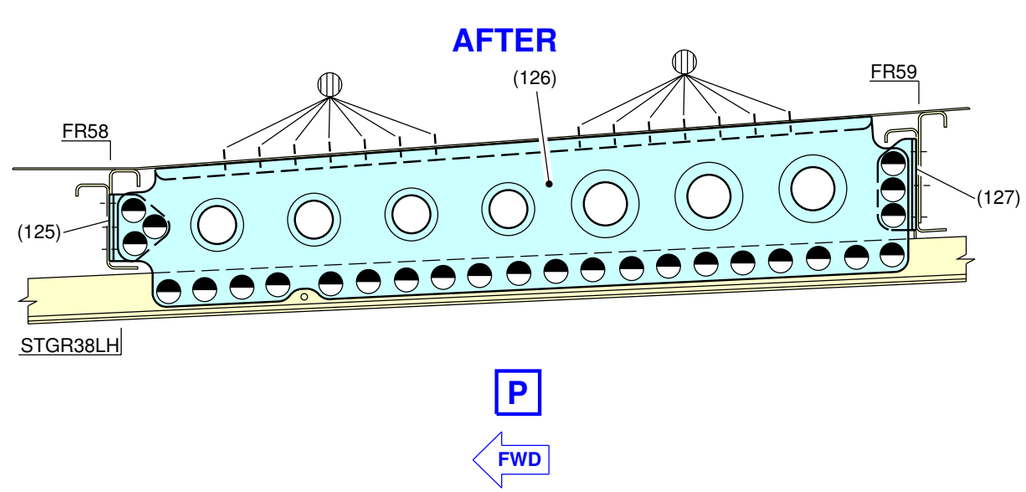
**CONF 004









NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 7.

N_SB_531364_6_BQAD_05_00

Figure A-GBQAD - Sheet 05
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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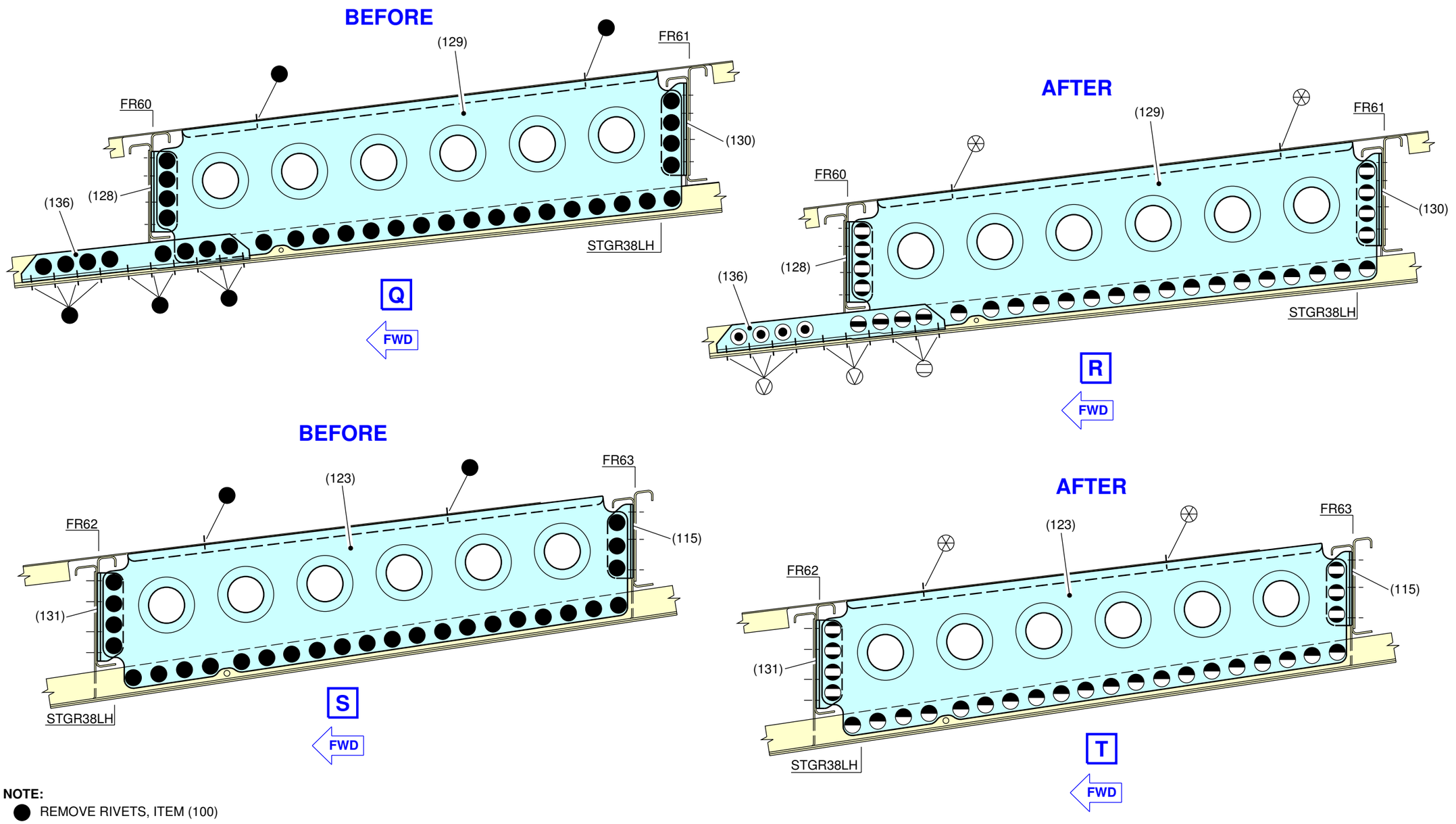
**CONF 004



NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 7.

N_SB_531364_6_BQAD_06_00

Figure A-GBQAD - Sheet 06
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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**CONF 004

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	HOLE DIAMETER		REMARKS
				MIN	MAX	
	544	EN6069D4–04	RIVET	3.250 mm (0.1280 in)	3.350 mm (0.1318 in)	NOMINAL SIZE
	545	EN6069D4–05	RIVET	3.250 mm (0.1280 in)	3.350 mm (0.1318 in)	NOMINAL SIZE
	655	EN6081D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	784	DAN5–6–4Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	786	DAN5–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	864	DAN6–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	865	DAN6–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	885	DAN6–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	886	DAN6–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	887	DAN6–6–7Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			

N_SB_531364_6_BQAD_07_01

Figure A-GBQAD - Sheet 07
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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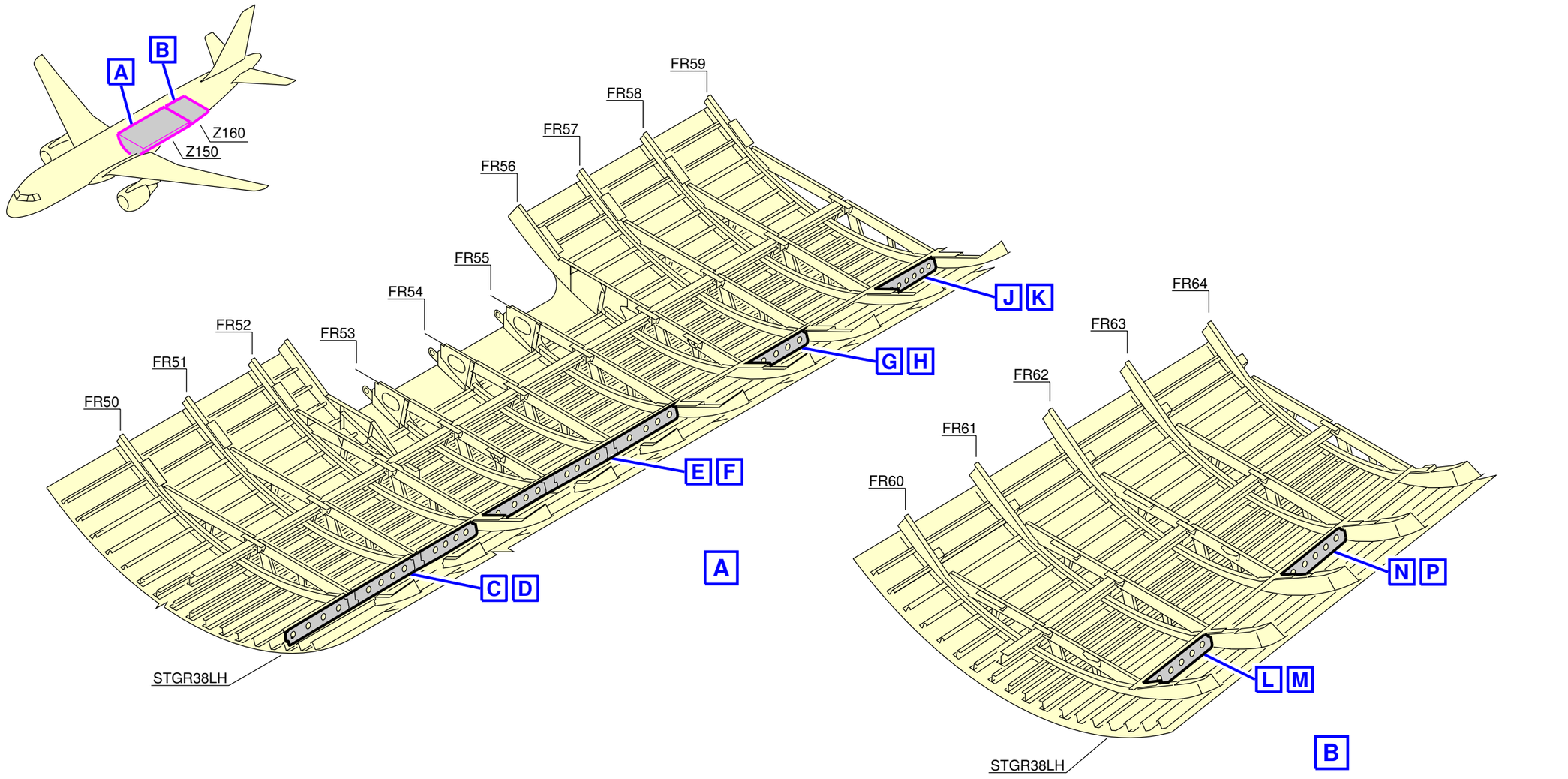
**CONF 005



N_SB_531364_6_BQAE_01_00

Figure A-GBQAE - Sheet 01
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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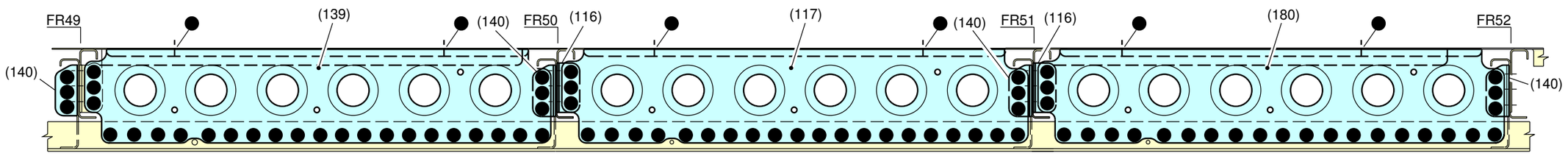
**CONF 005

BEFORE



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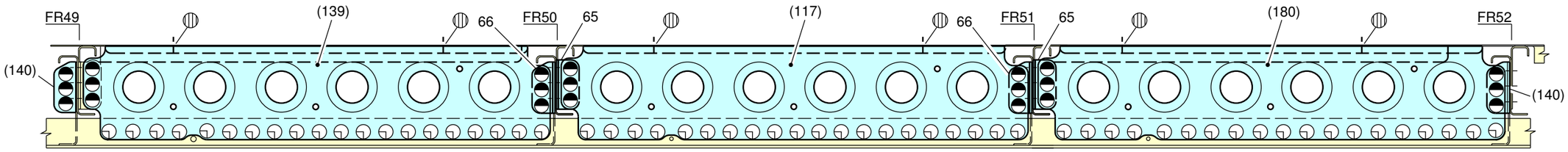

NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6

N_SB_531364_6_BQAE_02_00

Figure A-GBQAE - Sheet 02
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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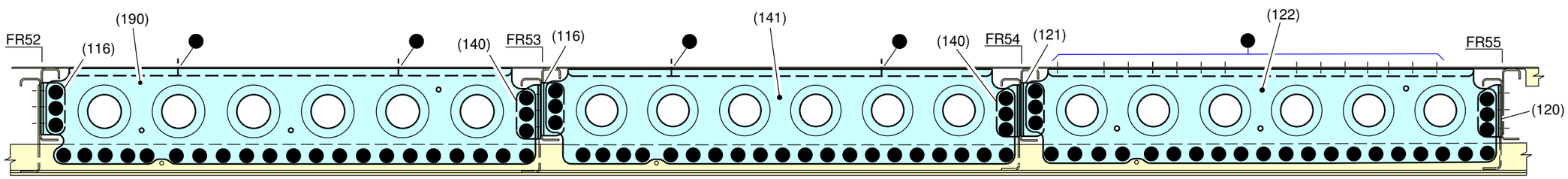
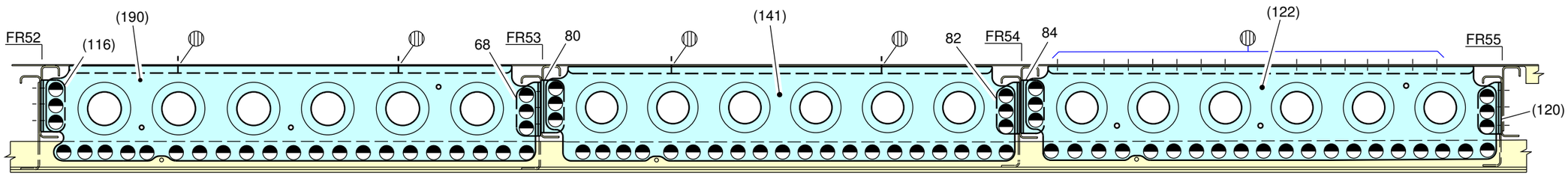
**CONF 005

BEFORE



AFTER



NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6

N_SB_531364_6_BQAE_03_00

Figure A-GBQAE - Sheet 03
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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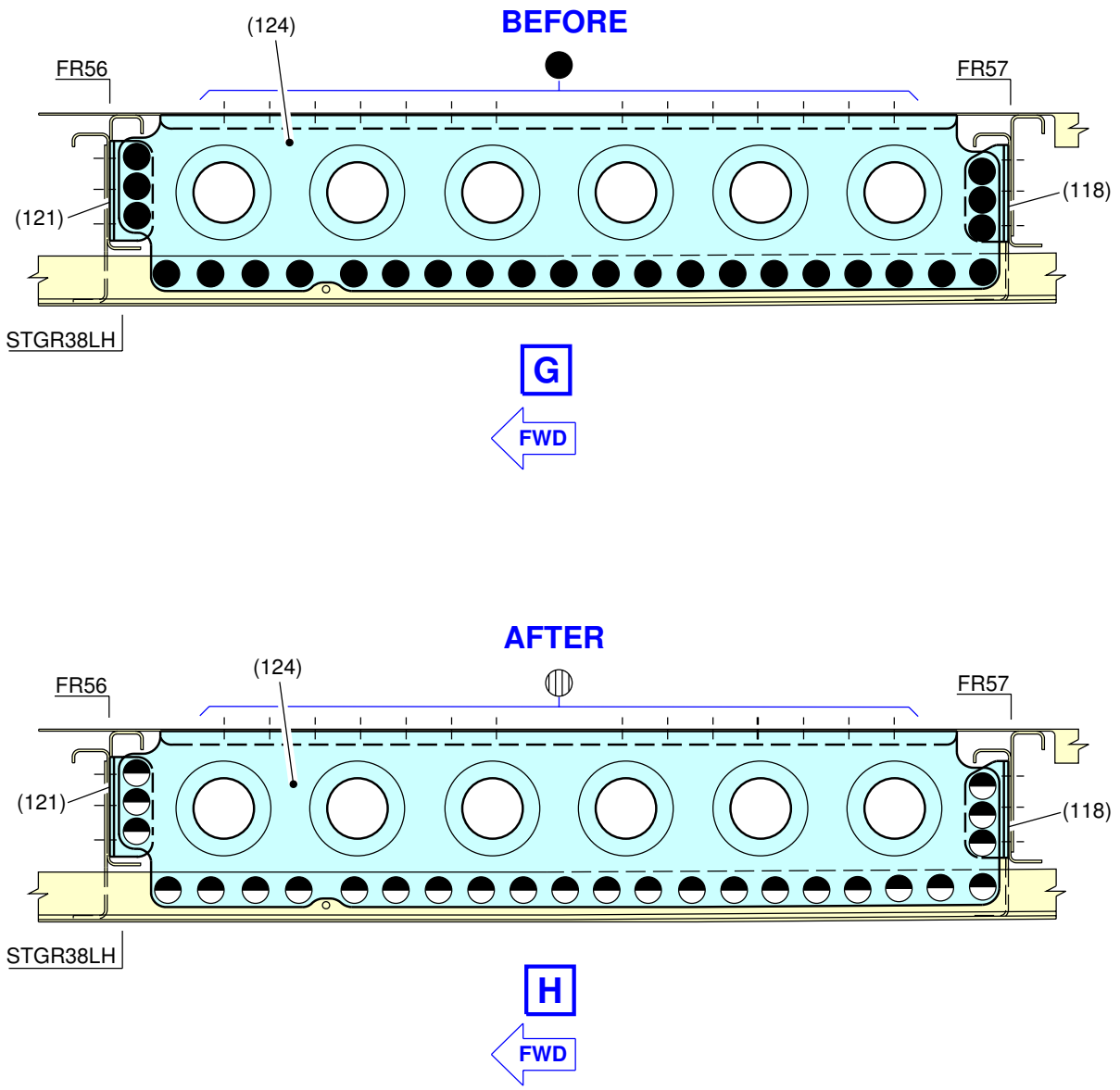
**CONF 005



NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6

N_SB_531364_6_BQAE_04_00

Figure A-GBQAE - Sheet 04
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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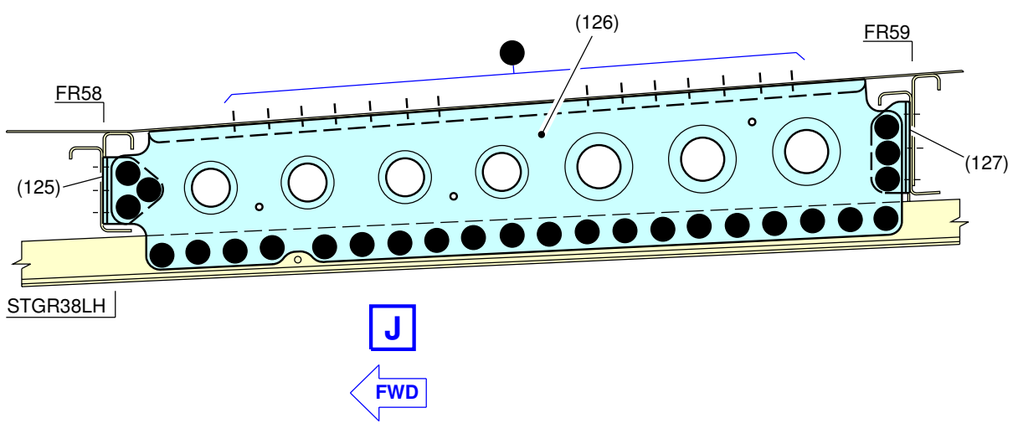
**CONF 005

BEFORE



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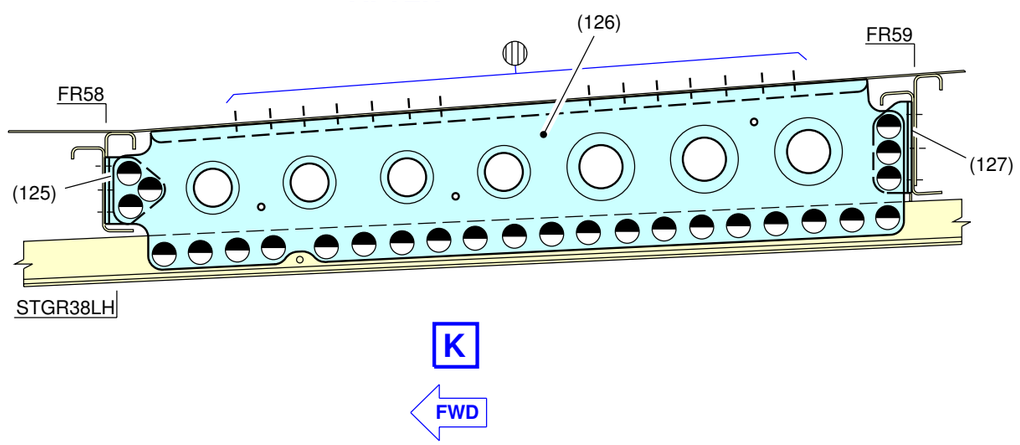

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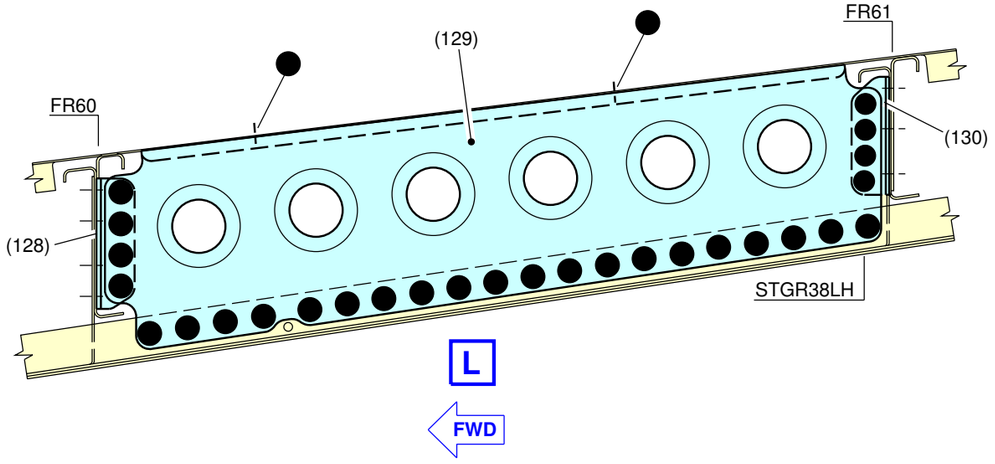

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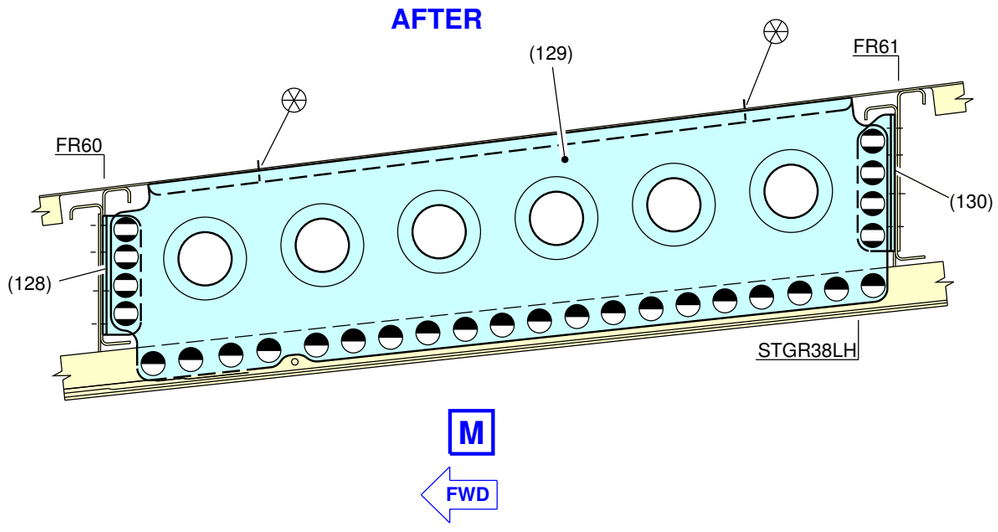

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6

N_SB_531364_6_BQAE_05_00

Figure A-GBQAE - Sheet 05
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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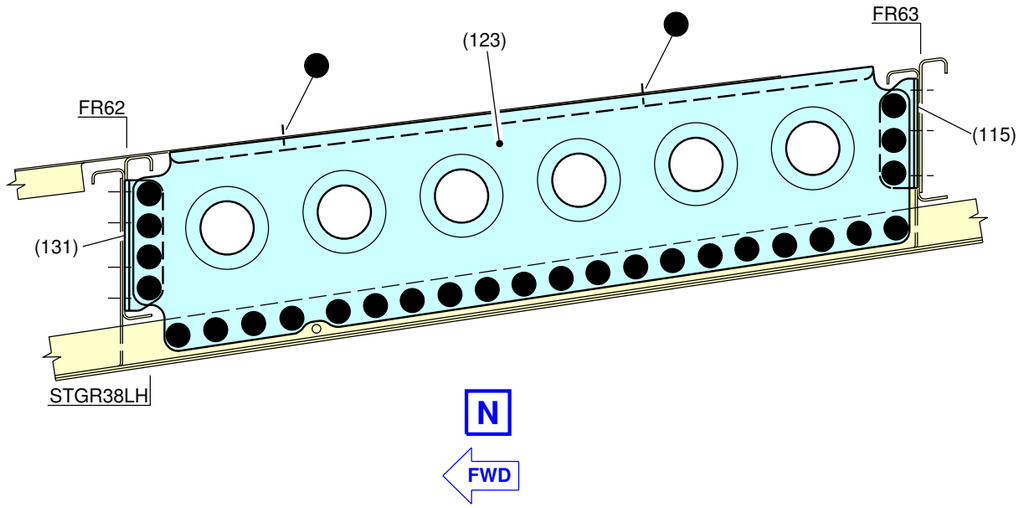
**CONF 005

BEFORE



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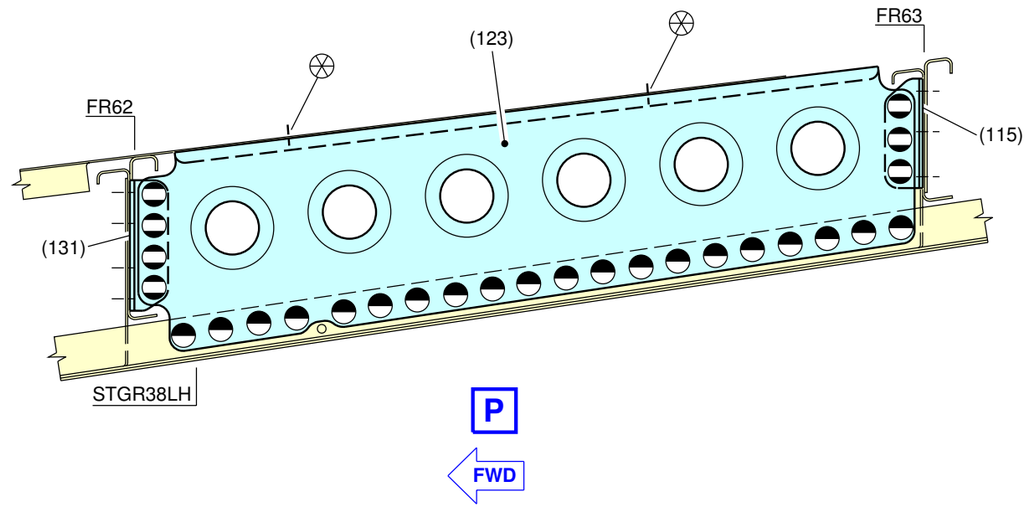

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	HOLE DIAMETER		REMARKS
				MIN	MAX	
⊗	544	EN6069D4–04	RIVET	3.250 mm (0.1280 in)	3.350 mm (0.1318 in)	NOMINAL SIZE
⊜	545	EN6069D4–05	RIVET	3.250 mm (0.1280 in)	3.350 mm (0.1318 in)	NOMINAL SIZE
◒	655	EN6081D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◓	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◵	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE

NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BQAE_06_01

Figure A-GBQAE - Sheet 06
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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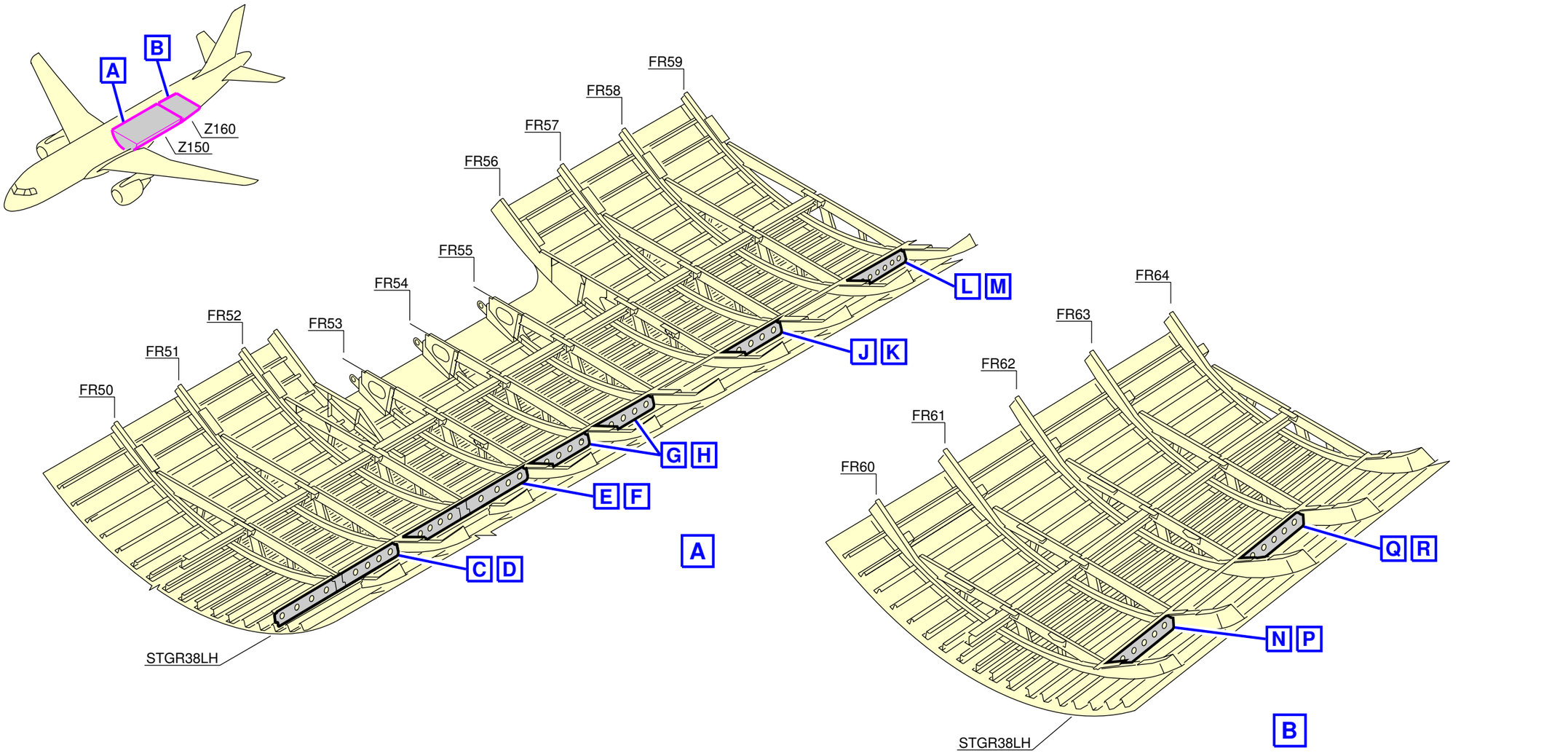
**CONF 006



N_SB_531364_6_BQAF_01_00

Figure A-GBQAF - Sheet 01
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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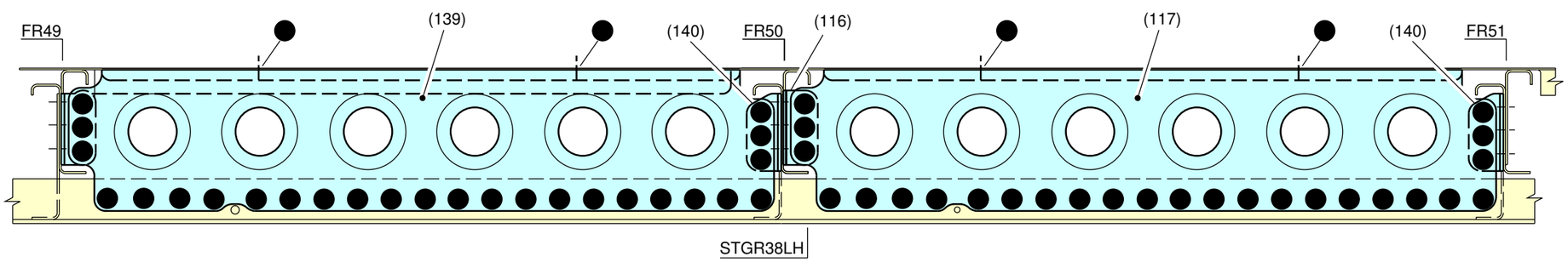
**CONF 006

BEFORE



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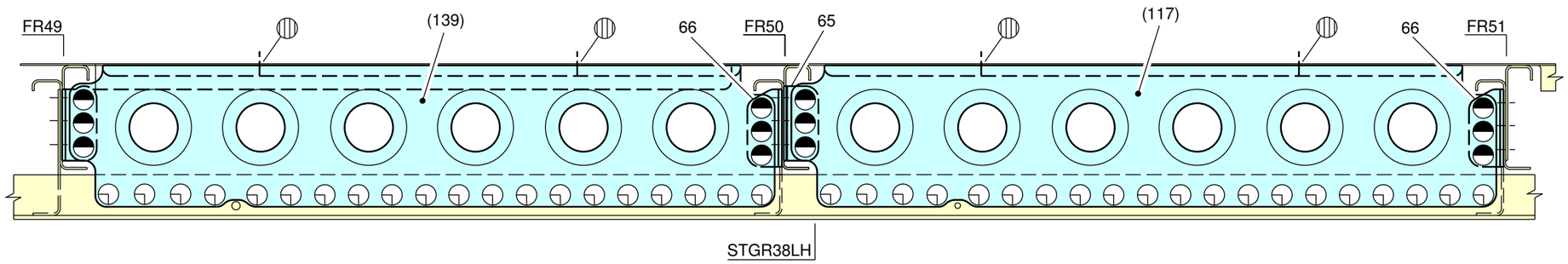

NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 7

N_SB_531364_6_BQAF_02_00

Figure A-GBQAF - Sheet 02
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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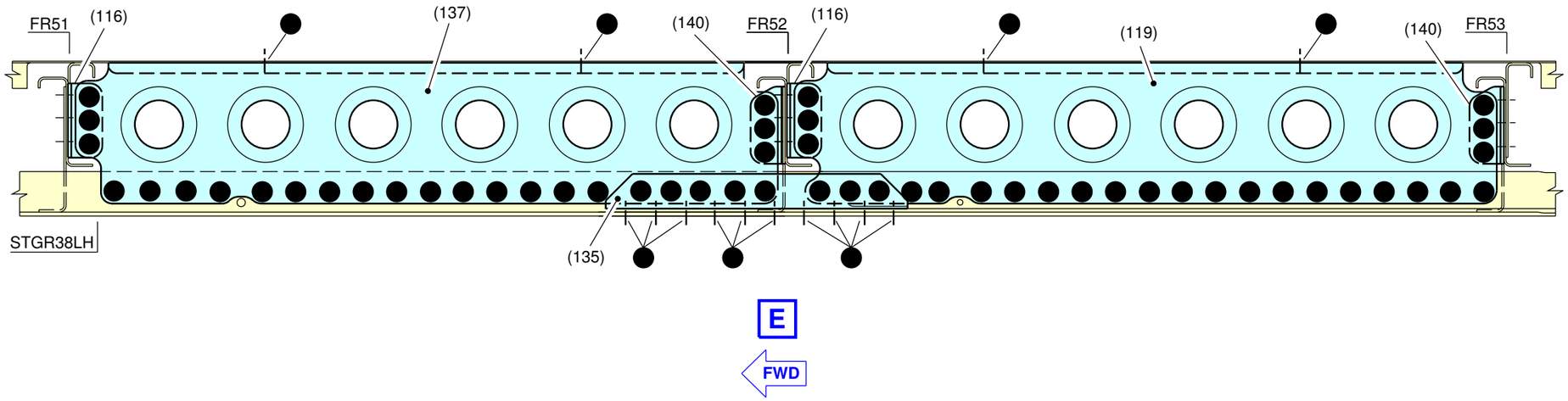
**CONF 006

BEFORE



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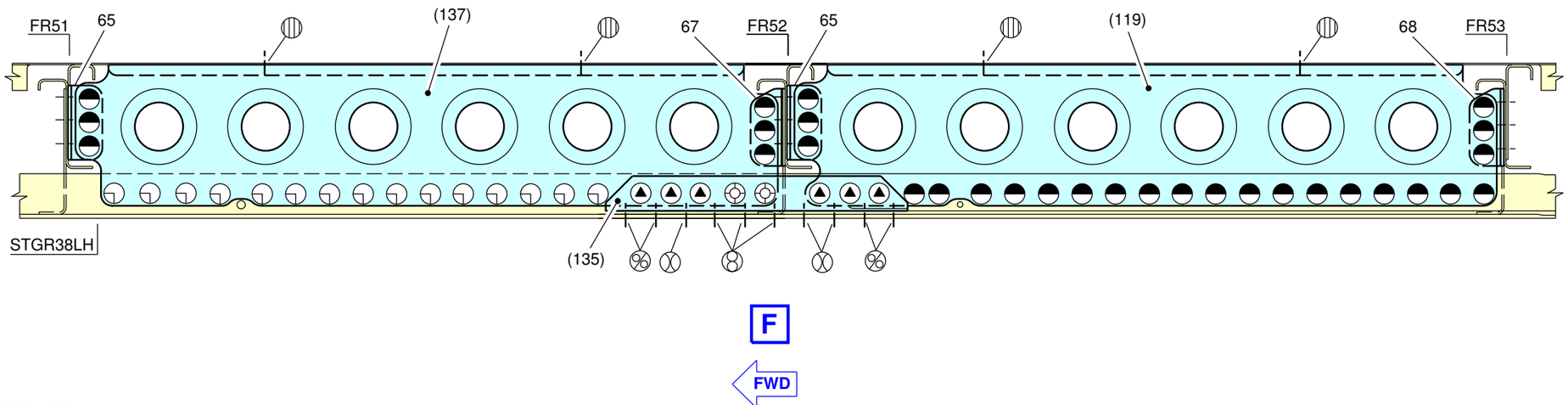

NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 7

N_SB_531364_6_BQAF_03_00

Figure A-GBQAF - Sheet 03
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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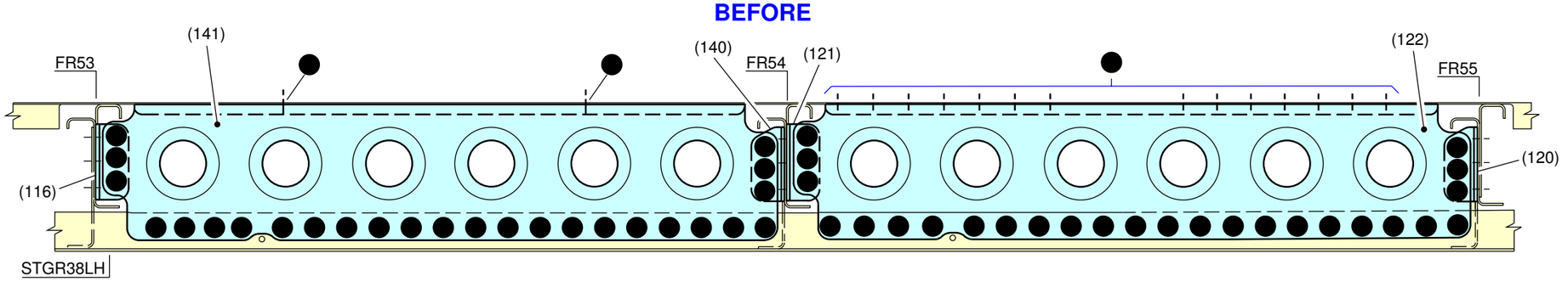
**CONF 006

BEFORE



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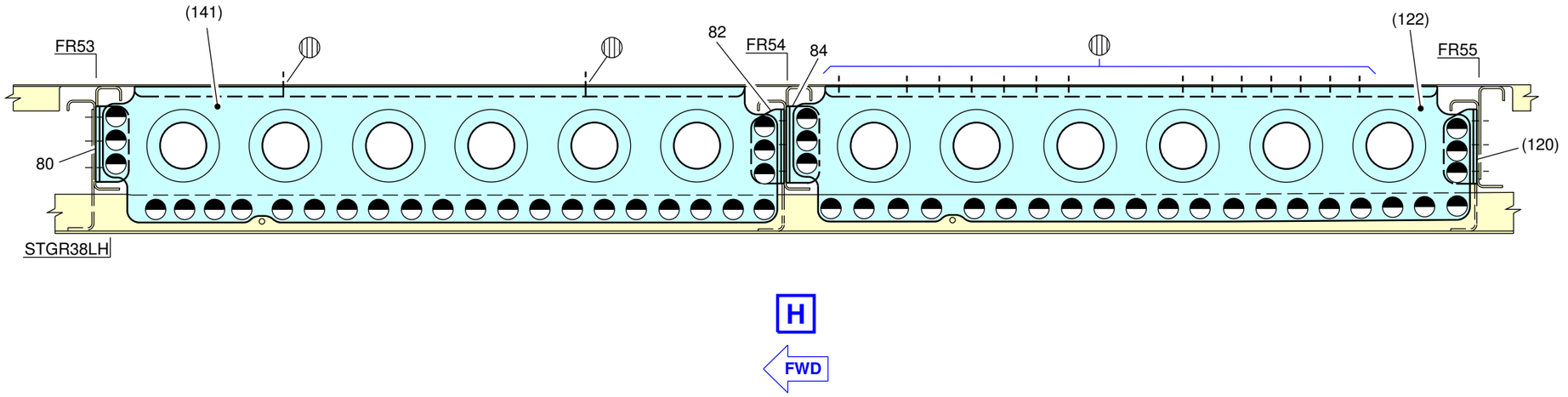

NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 7

N_SB_531364_6_BQAF_04_00

Figure A-GBQAF - Sheet 04
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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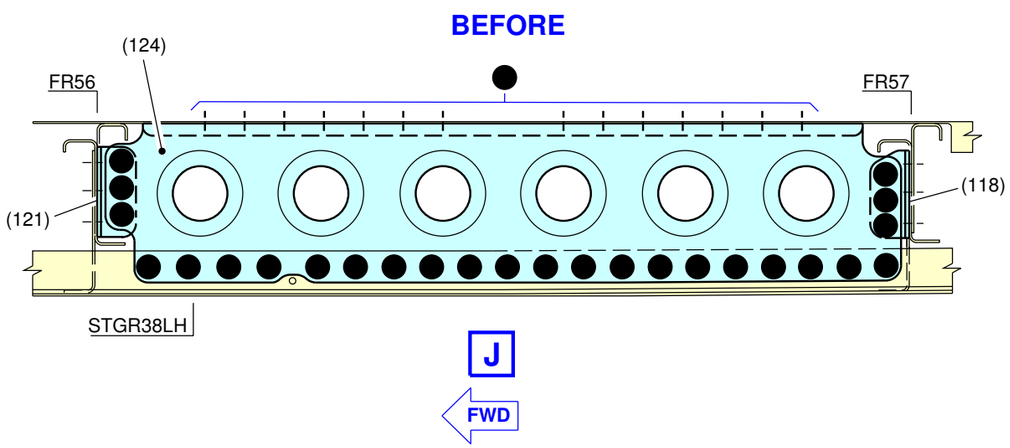
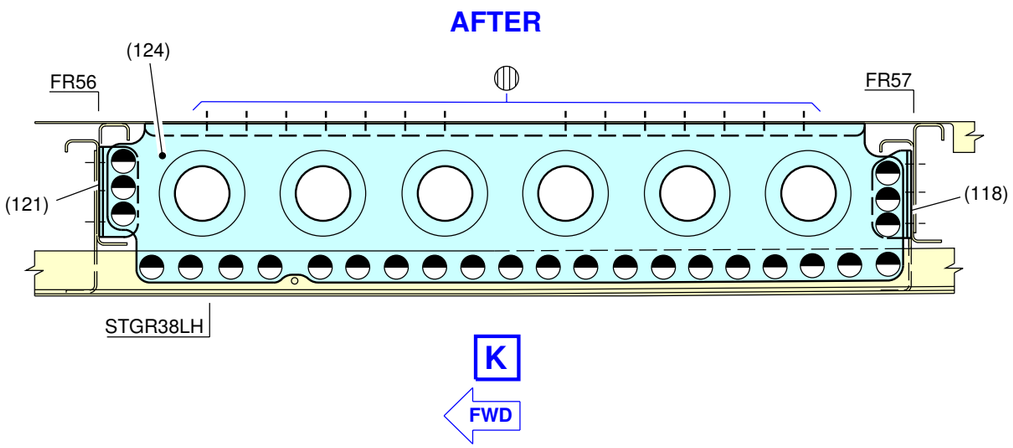
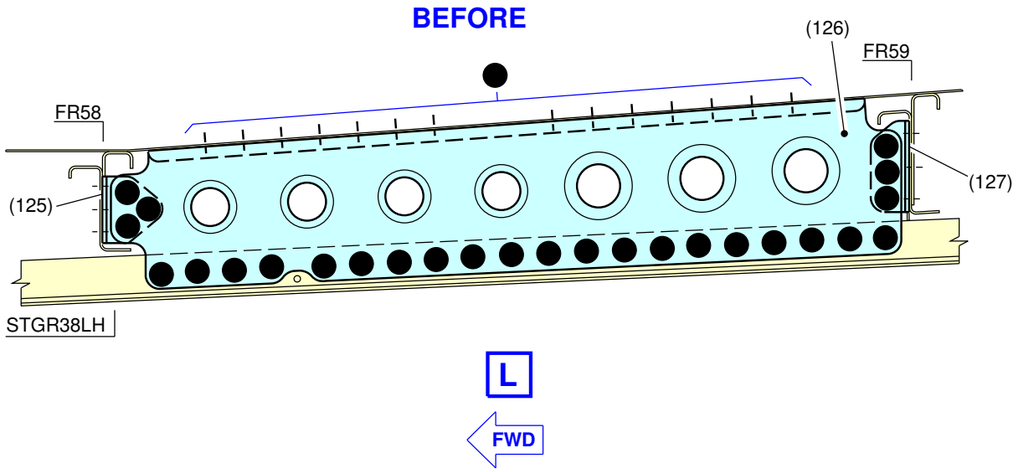
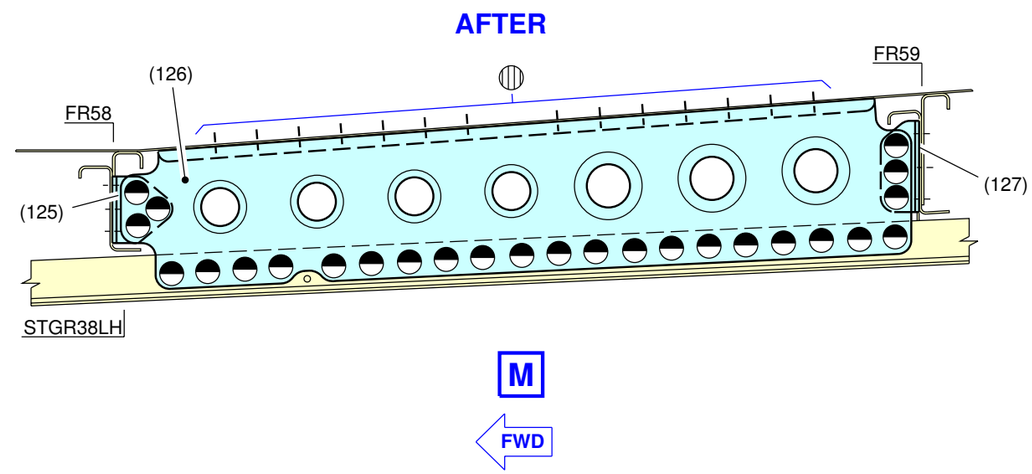
**CONF 006









NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 7

N_SB_531364_6_BQAF_05_00

Figure A-GBQAF - Sheet 05
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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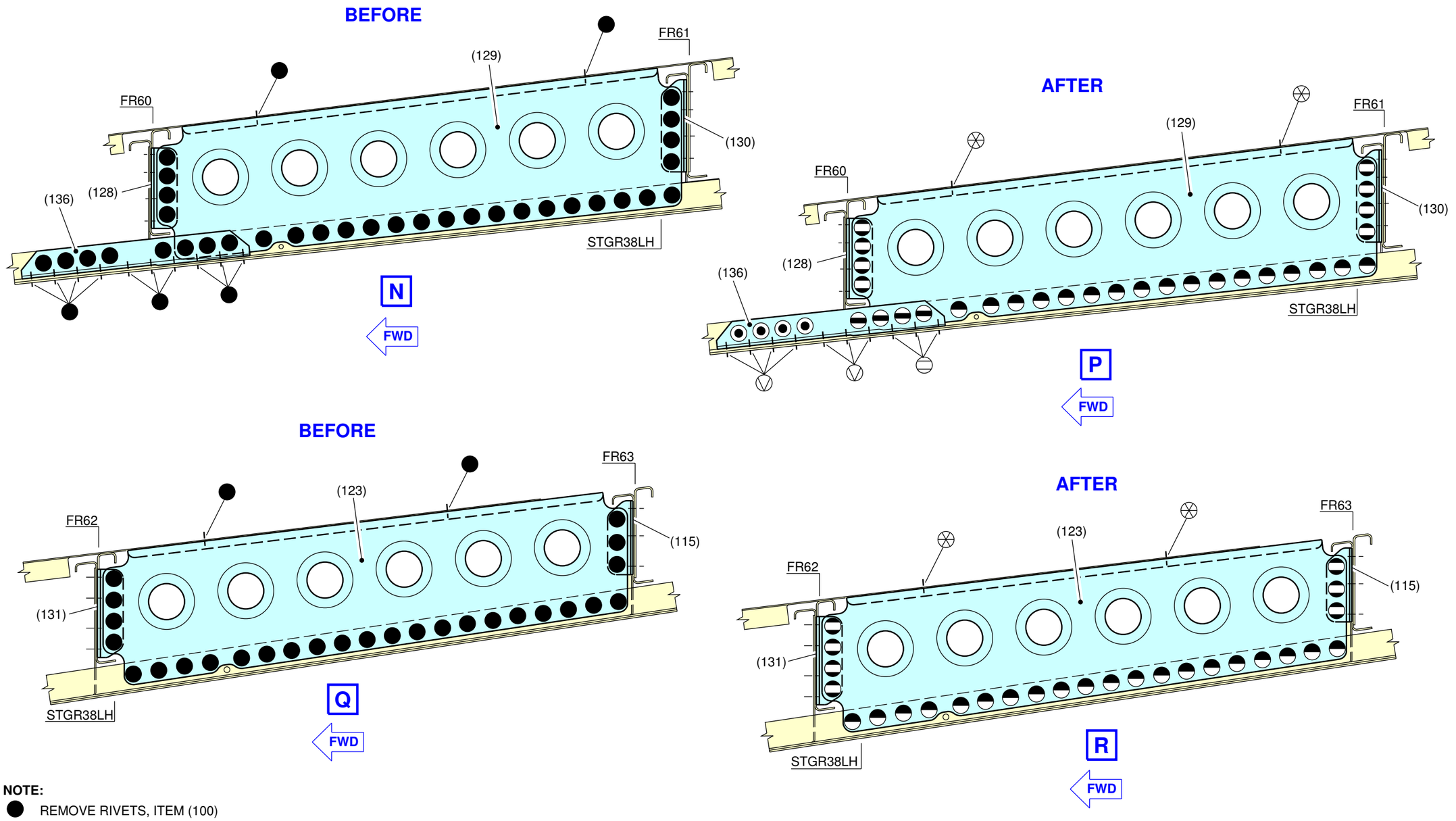
**CONF 006



NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 7

N_SB_531364_6_BQAF_06_00

Figure A-GBQAF - Sheet 06
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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**CONF 006

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	HOLE DIAMETER		REMARKS
				MIN	MAX	
	544	EN6069D4–04	RIVET	3.250 mm (0.1280 in)	3.350 mm (0.1318 in)	NOMINAL SIZE
	545	EN6069D4–05	RIVET	3.250 mm (0.1280 in)	3.350 mm (0.1318 in)	NOMINAL SIZE
	655	EN6081D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
	764	DAN5–6–4X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	765	DAN5–6–5X	PIN	5.113 mm (0.2013 in)	5.152 mm (0.2028 in)	1ST OVERSIZE TRANSITION FIT
	807	DAN11–6X	COLLAR			
	784	DAN5–6–4Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	786	DAN5–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	864	DAN6–6–4	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	865	DAN6–6–5	PIN	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT
	806	NSA5075–6	COLLAR			
	885	DAN6–6–5Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	886	DAN6–6–6Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			
	887	DAN6–6–7Y	PIN	5.509 mm (0.2169 in)	5.549 mm (0.2185 in)	2ND OVERSIZE TRANSITION FIT
	809	DAN11–6Y	COLLAR			

N_SB_531364_6_BQAF_07_01

Figure A-GBQAF - Sheet 07
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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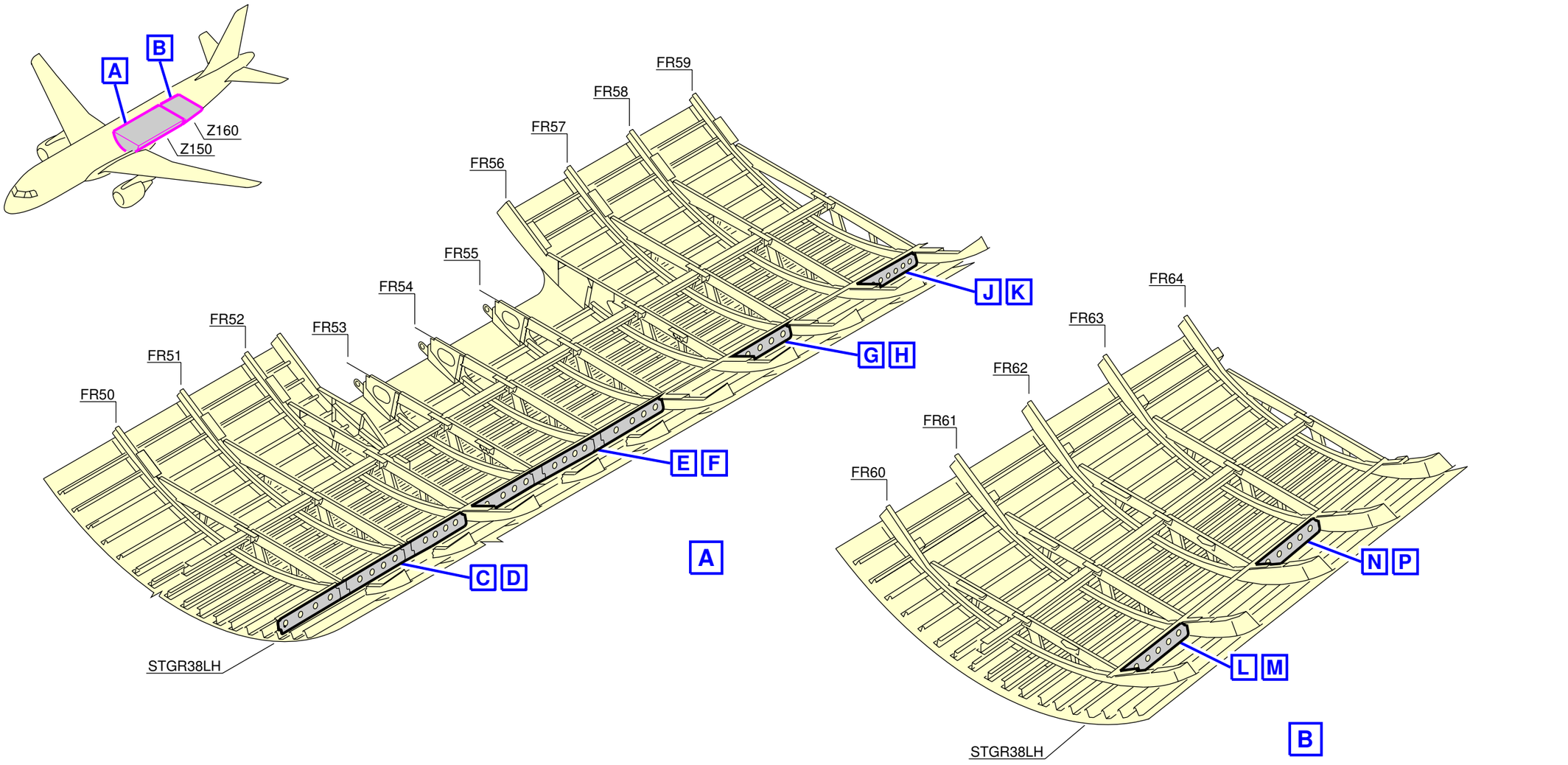
**CONF 007



N_SB_531364_6_BQAG_01_00

Figure A-GBQAG - Sheet 01
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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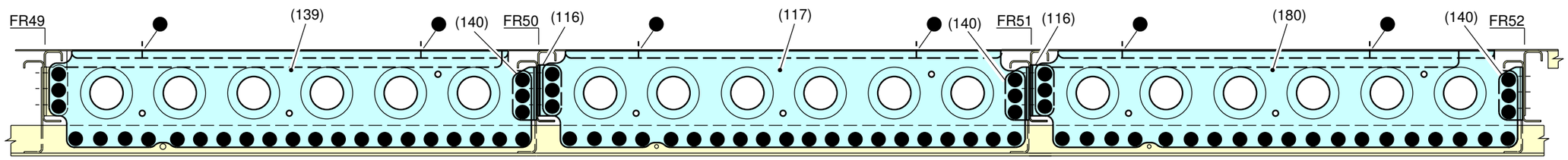
**CONF 007

BEFORE



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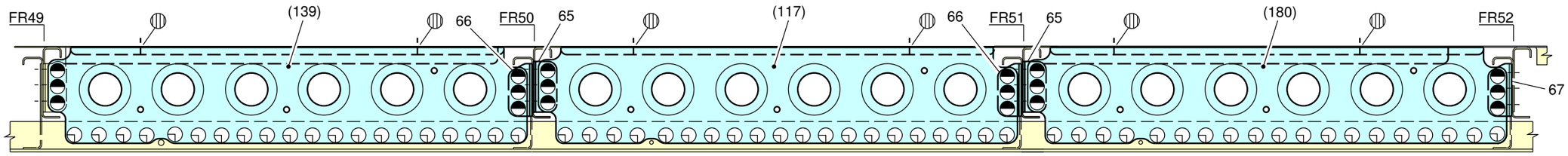

NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BQAG_02_01

Figure A-GBQAG - Sheet 02
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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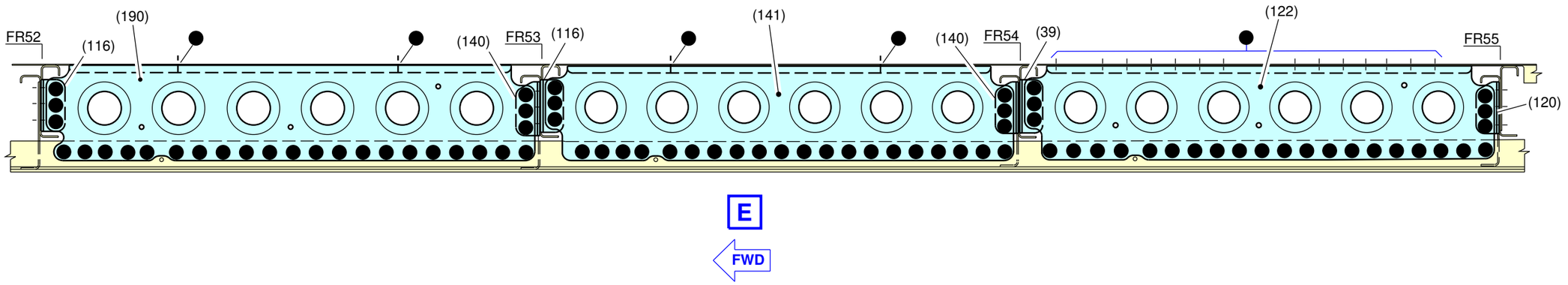
**CONF 007

BEFORE



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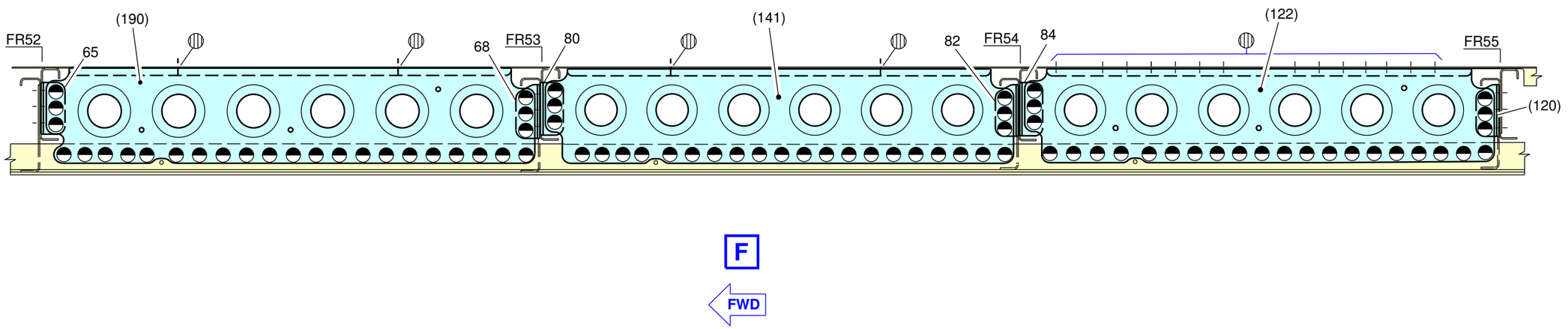

NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BQAG_03_00

Figure A-GBQAG - Sheet 03
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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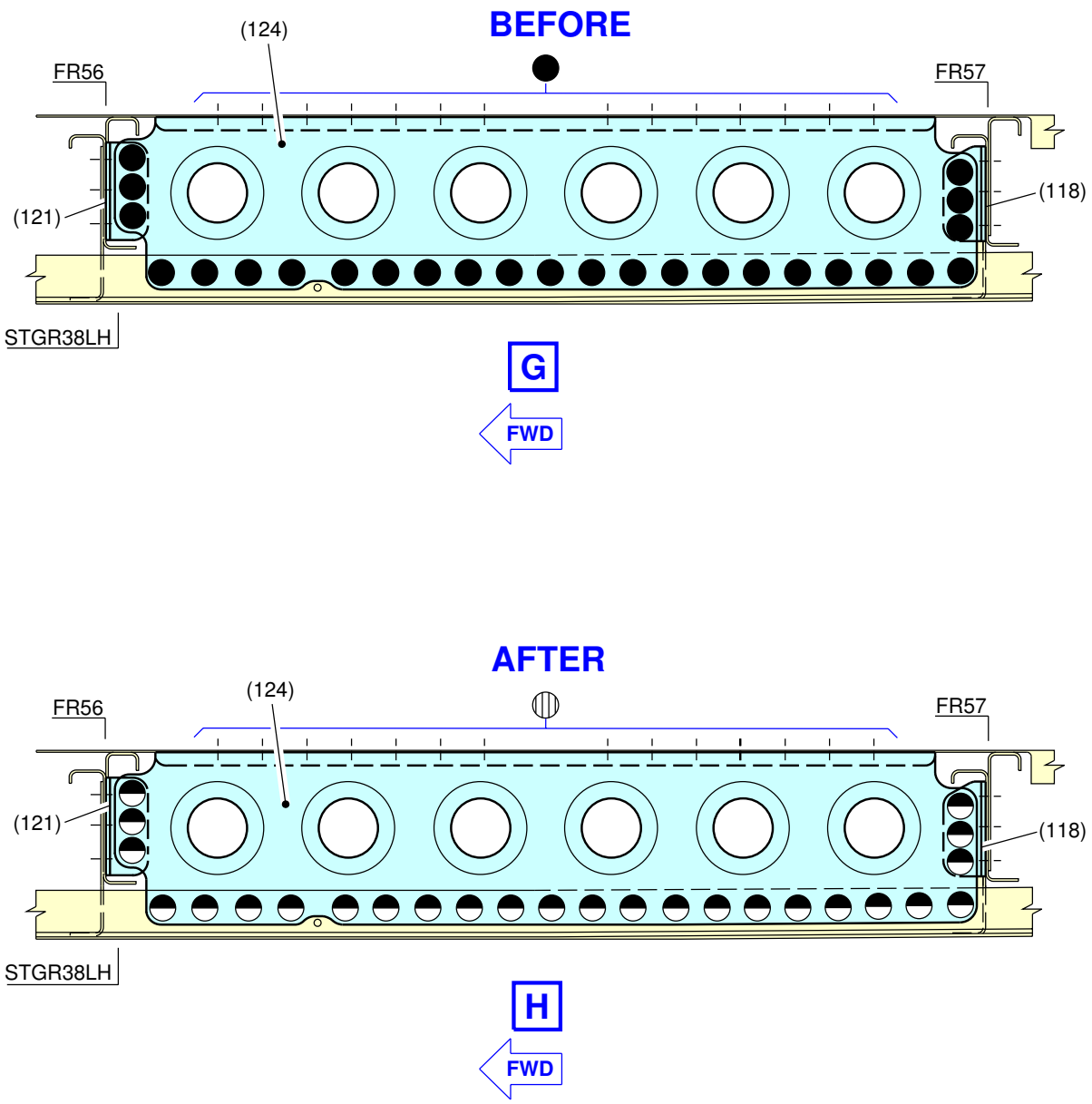
**CONF 007



NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BQAG_04_00

Figure A-GBQAG - Sheet 04
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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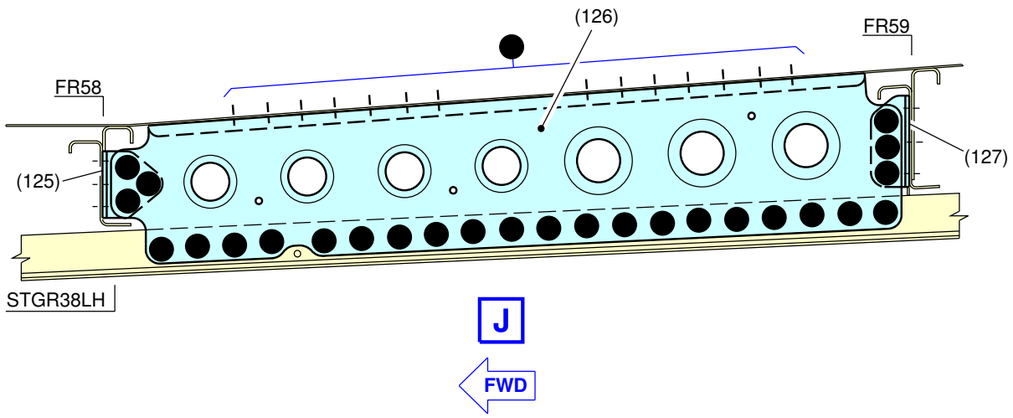
**CONF 007

BEFORE



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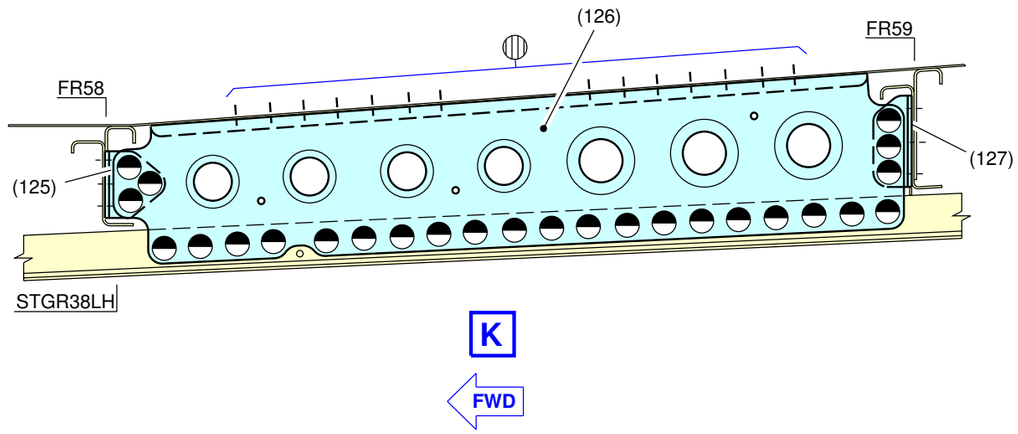

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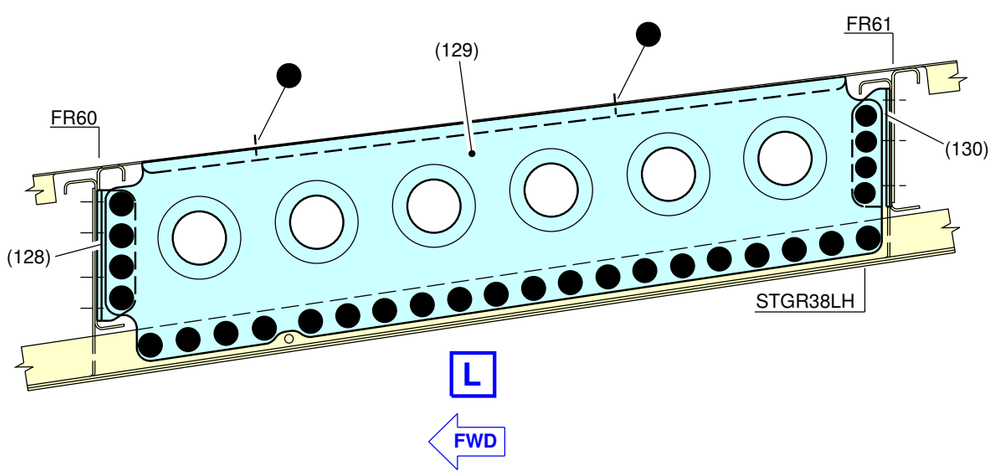

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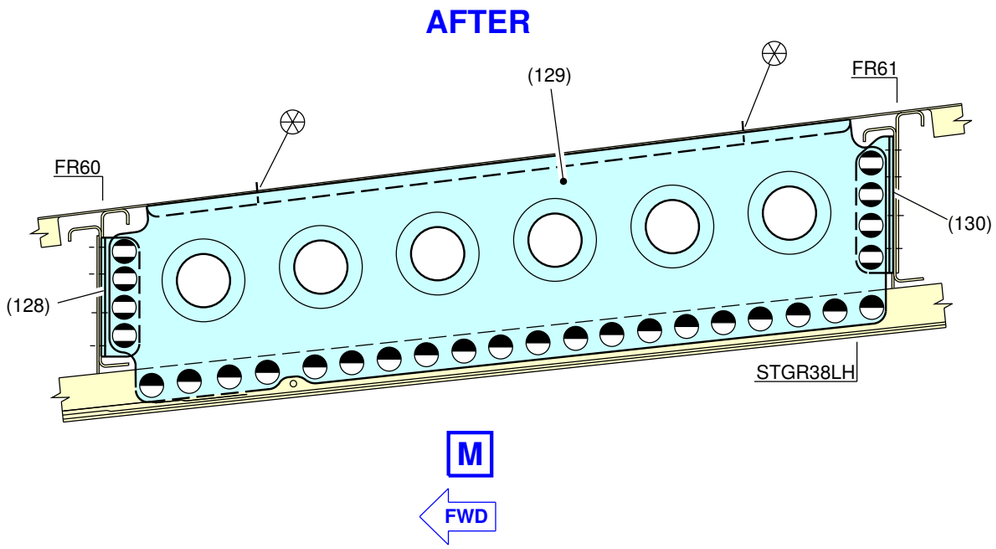

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BQAG_05_00

Figure A-GBQAG - Sheet 05
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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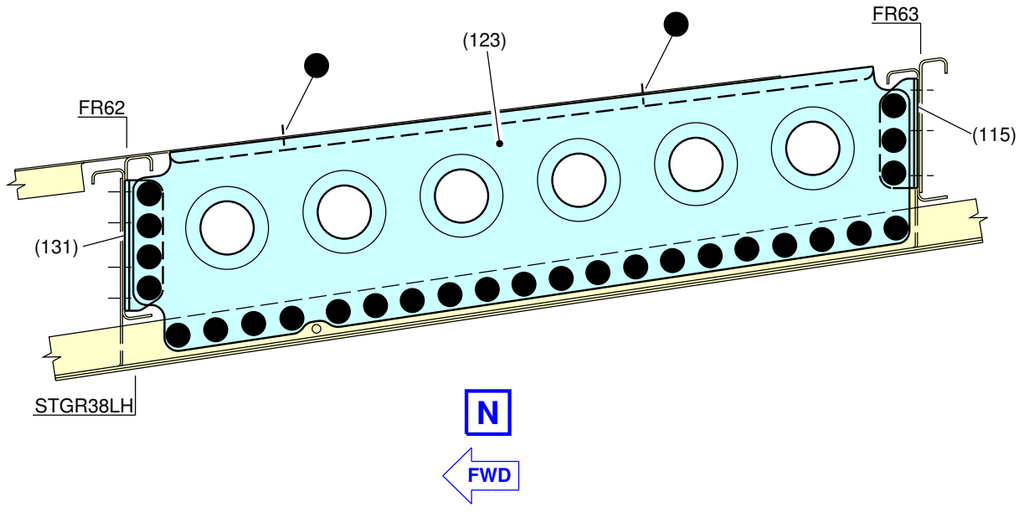
**CONF 007

BEFORE



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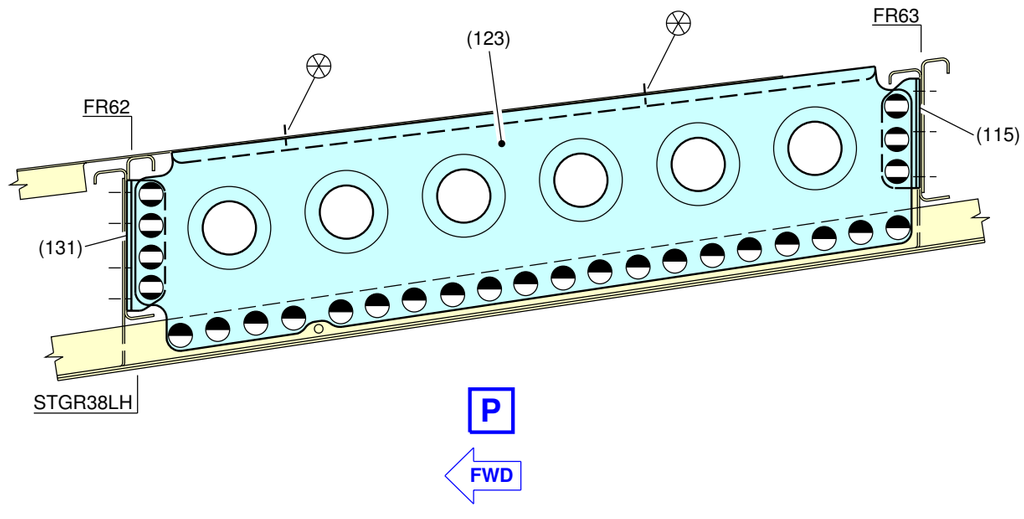

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	HOLE DIAMETER		REMARKS
				MIN	MAX	
⊗	544	EN6069D4–04	RIVET	3.250 mm (0.1280 in)	3.350 mm (0.1318 in)	NOMINAL SIZE
⊘	545	EN6069D4–05	RIVET	3.250 mm (0.1280 in)	3.350 mm (0.1318 in)	NOMINAL SIZE
◒	655	EN6081D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◓	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◵	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE

NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BQAG_06_01

Figure A-GBQAG - Sheet 06
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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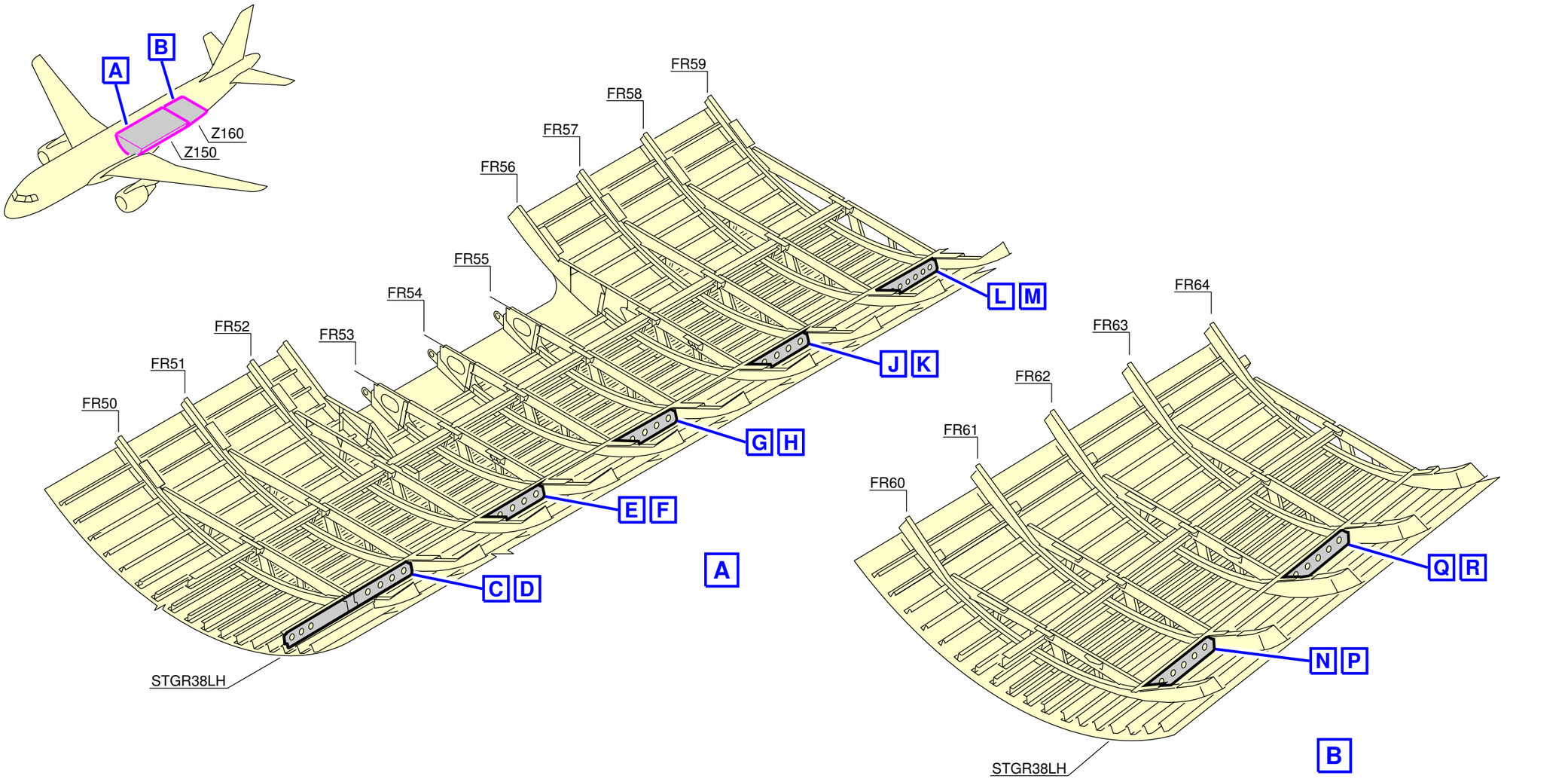
**CONF 009



N_SB_531364_6_BQAJ_01_00

Figure A-GBQAJ - Sheet 01
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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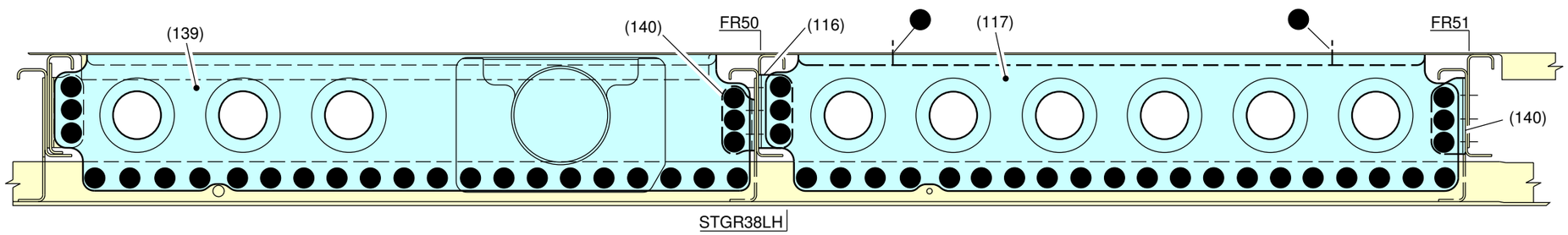
**CONF 009

BEFORE



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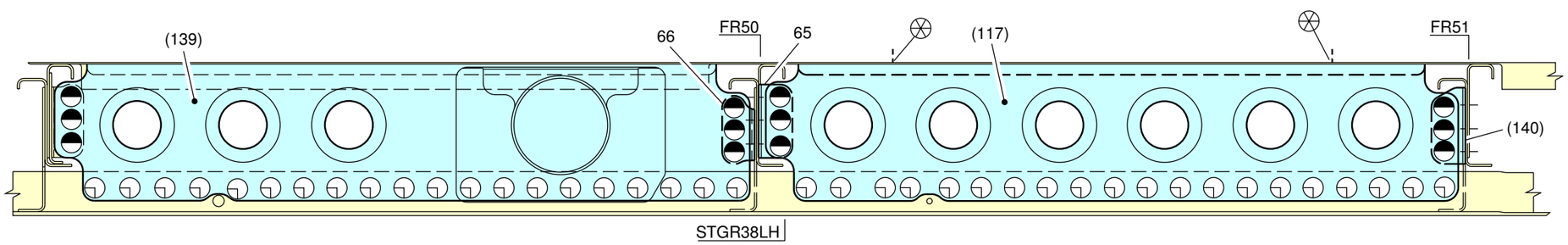

NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BQAJ_02_00

Figure A-GBQAJ - Sheet 02
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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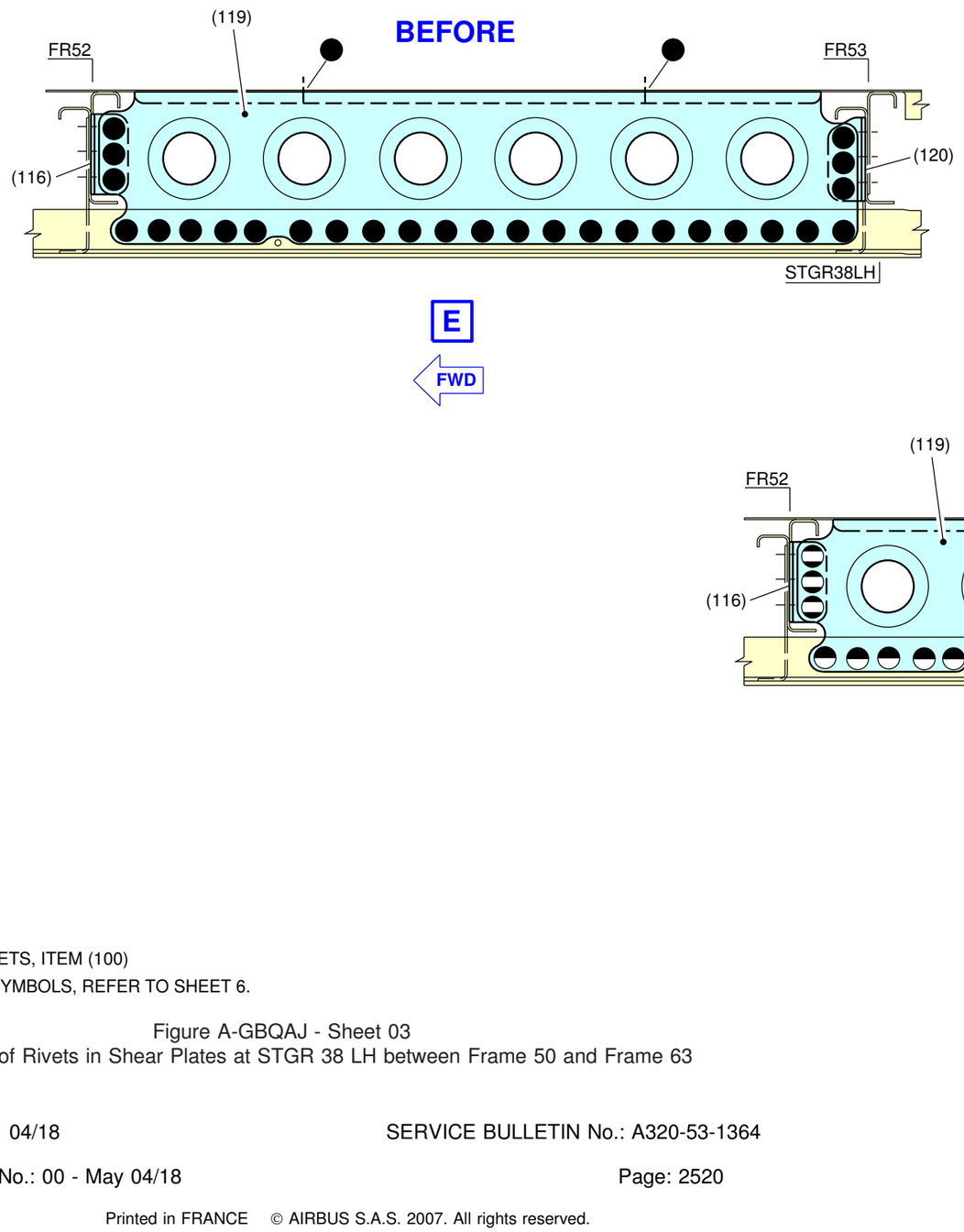
**CONF 009



NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BQAJ_03_00

Figure A-GBQAJ - Sheet 03
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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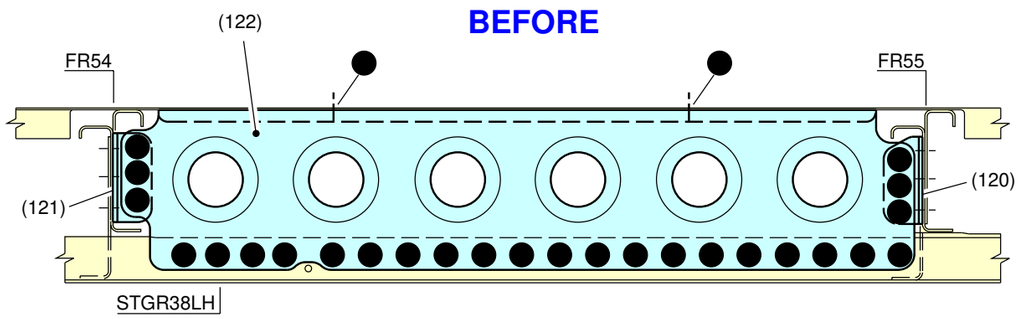
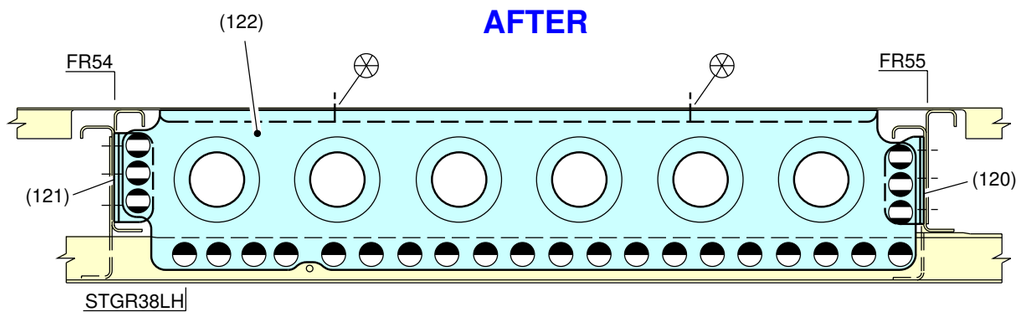
**CONF 009





NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6

N_SB_531364_6_BQAJ_04_00

Figure A-GBQAJ - Sheet 04
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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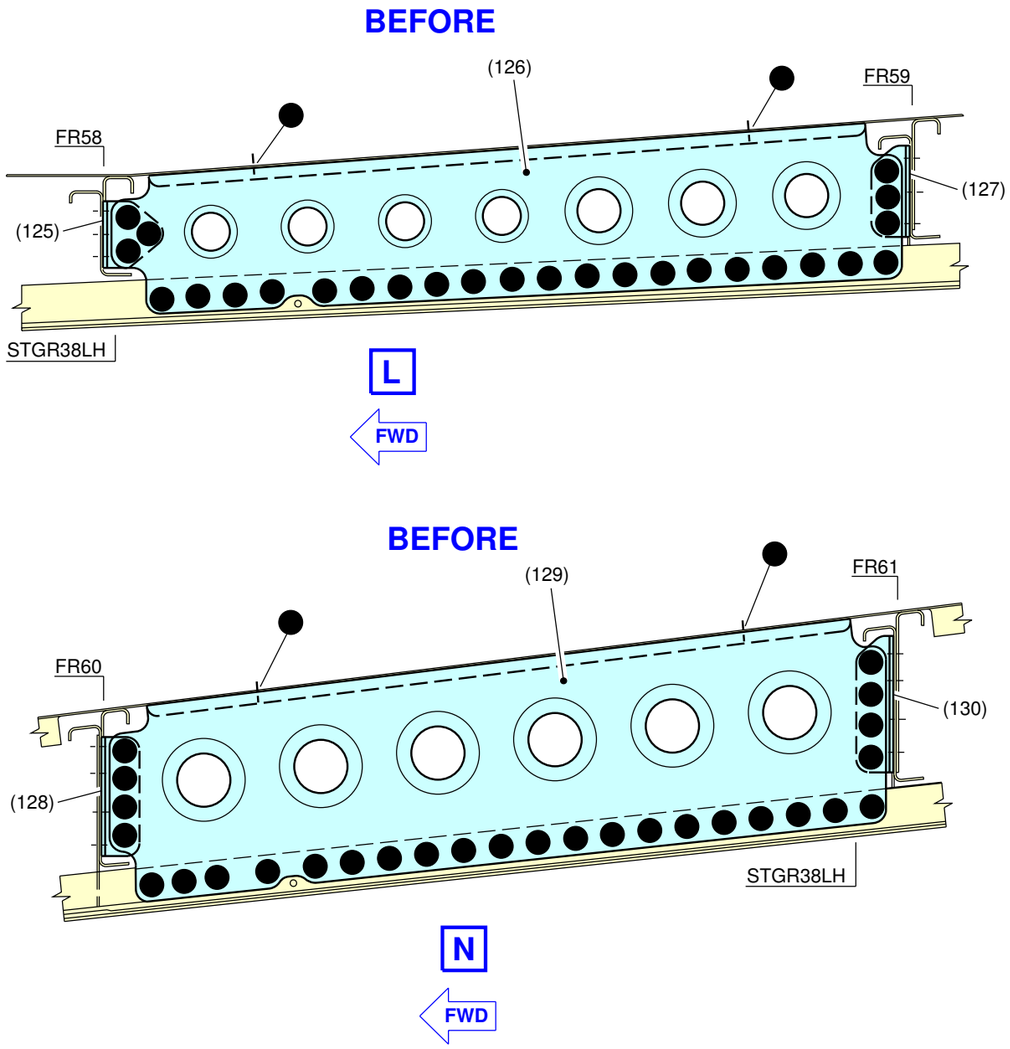
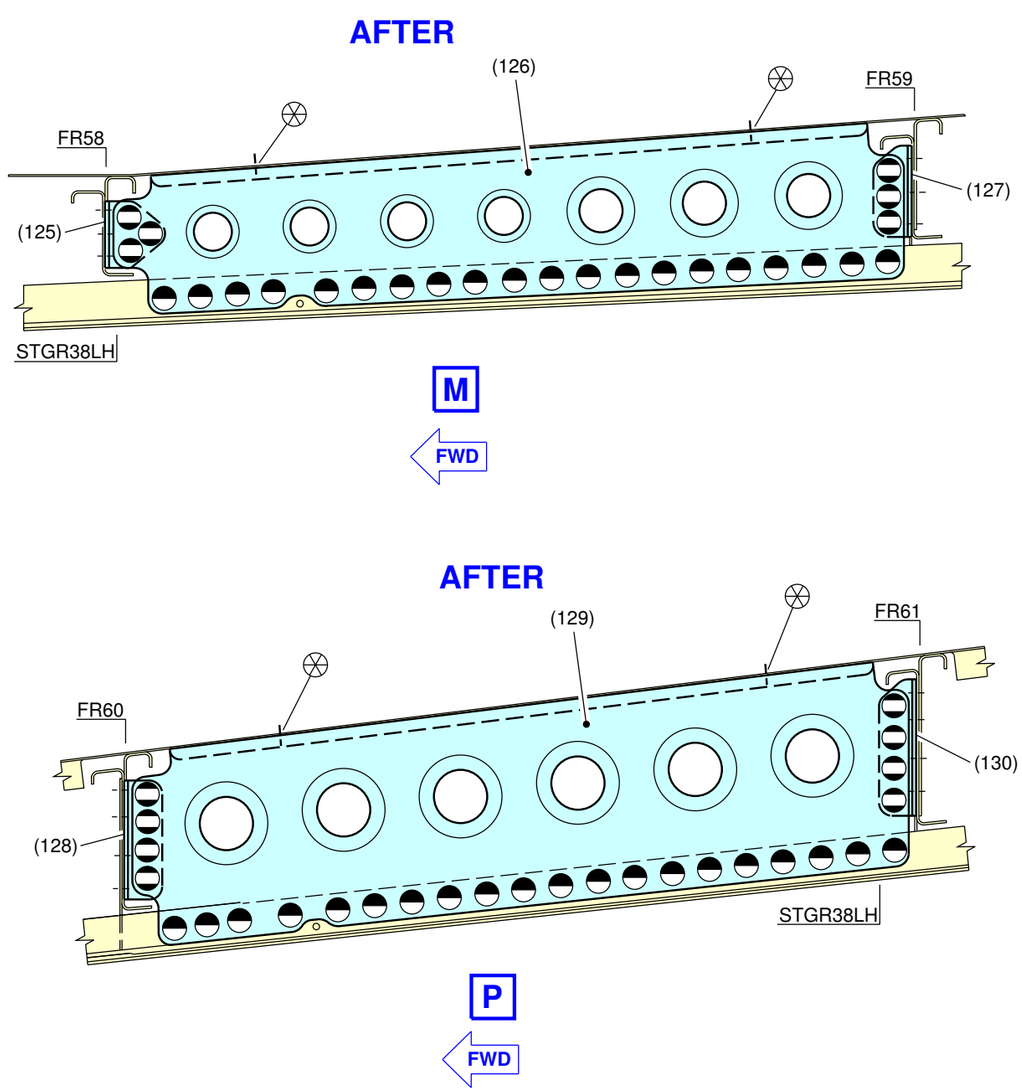
**CONF 009





NOTE:

● REMOVE RIVETS, ITEM (100)

FOR FASTENER SYMBOLS, REFER TO SHEET 6.

N_SB_531364_6_BQAJ_05_00

Figure A-GBQAJ - Sheet 05
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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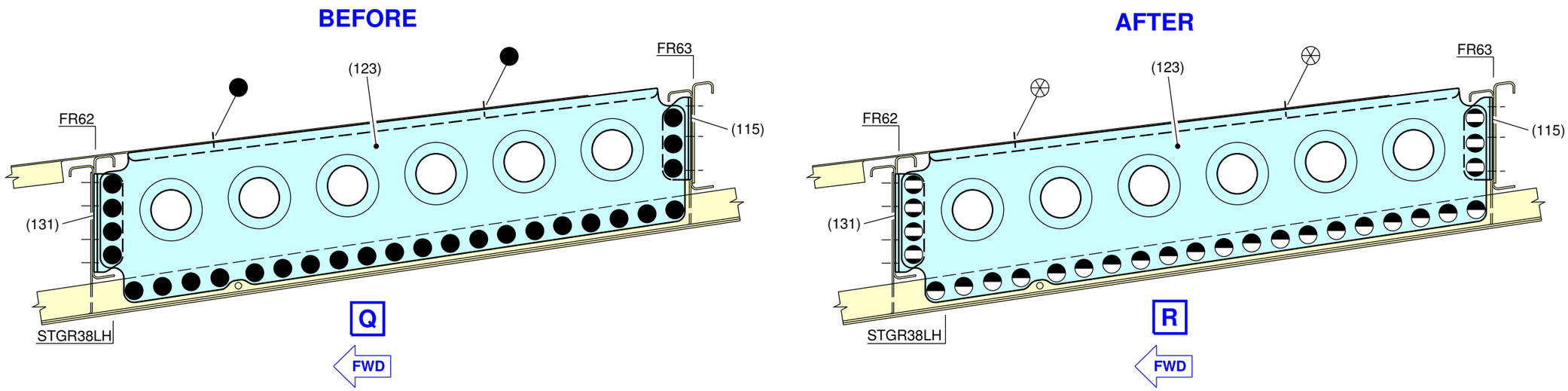
**CONF 009



HOLE SYMBOL	ITEM	P/N	DESCRIPTION	HOLE DIAMETER		REMARKS
				MIN	MAX	
⊗	544	EN6069D4–04	RIVET	3.250 mm (0.1280 in)	3.350 mm (0.1318 in)	NOMINAL SIZE
◒	655	EN6081D5–05	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◓	656	EN6081D5–06	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE
◵	657	EN6081D5–07	RIVET	4.060 mm (0.1599 in)	4.170 mm (0.1641 in)	NOMINAL SIZE

NOTE:

● REMOVE RIVETS, ITEM (100)

N_SB_531364_6_BQAJ_06_01

Figure A-GBQAJ - Sheet 06
Replacement of Rivets in Shear Plates at STGR 38 LH between Frame 50 and Frame 63

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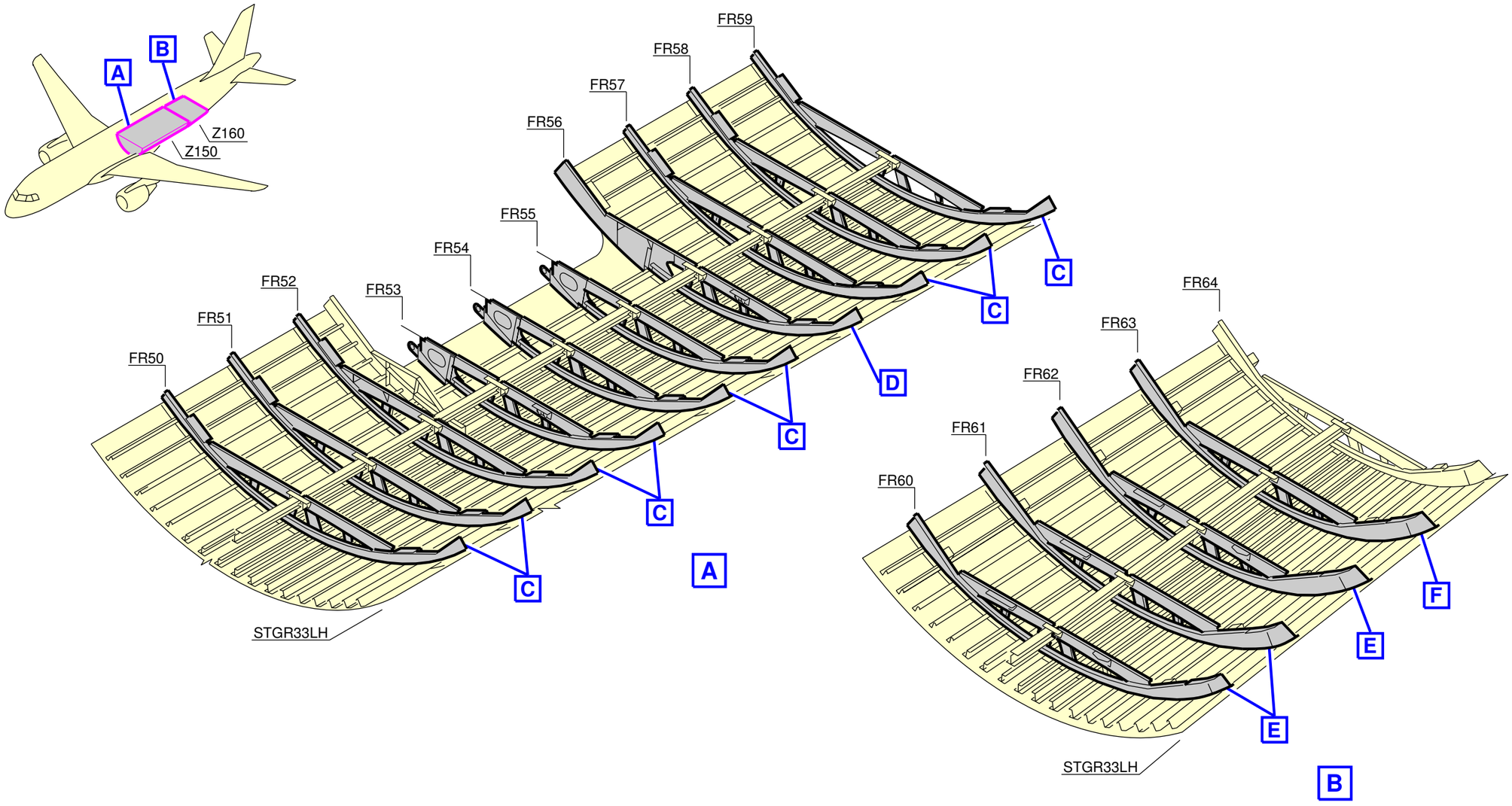
**CONF 001 thru 004, 006, 008



N_SB_531364_6_BRAA_01_00

Figure A-GBRAA - Sheet 01
Cold Expansion of Holes in Frame 50 thru Frame 63

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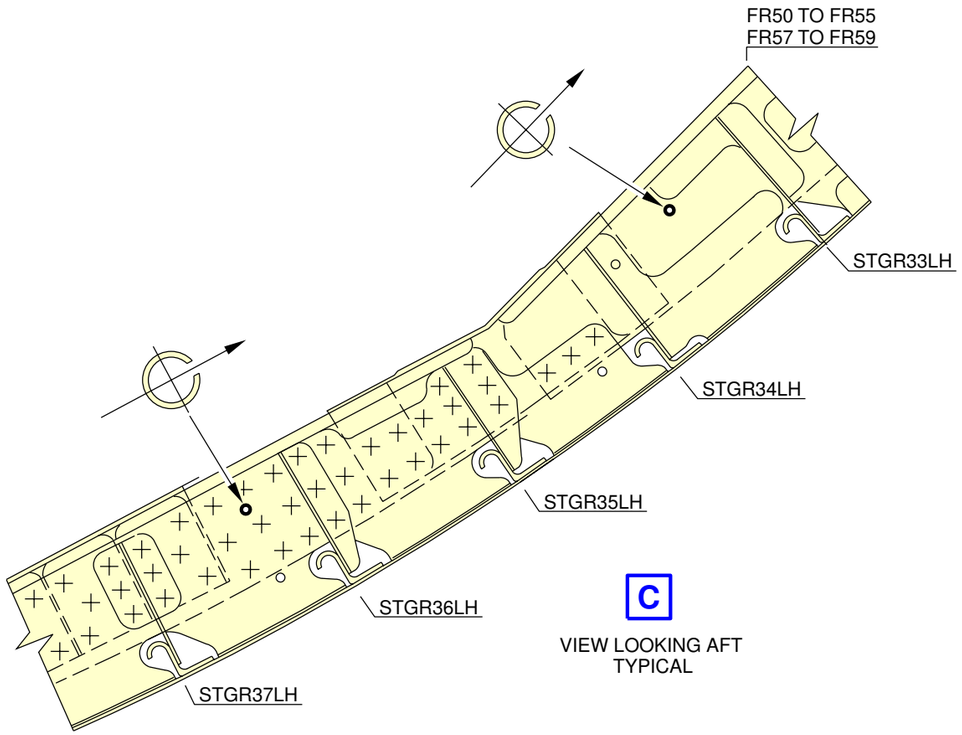
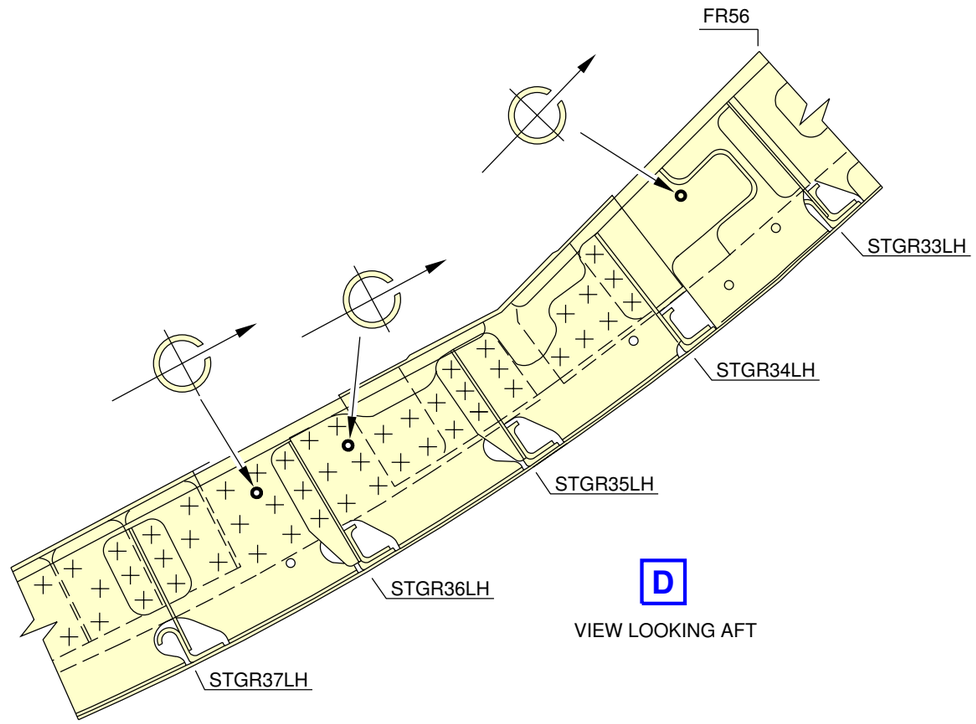
**CONF 001 thru 004, 006, 008



C

VIEW LOOKING AFT
TYPICAL



D

VIEW LOOKING AFT

POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	8–1–N	6.380 mm (0.2512 in)	6.450 mm (0.2539 in)	6.580 mm (0.2591 in)	6.610 mm (0.2602 in)

NOTE:

┼ EXISTING RIVETS

N_SB_531364_6_BRAA_02_01

Figure A-GBRAA - Sheet 02
Cold Expansion of Holes in Frame 50 thru Frame 63

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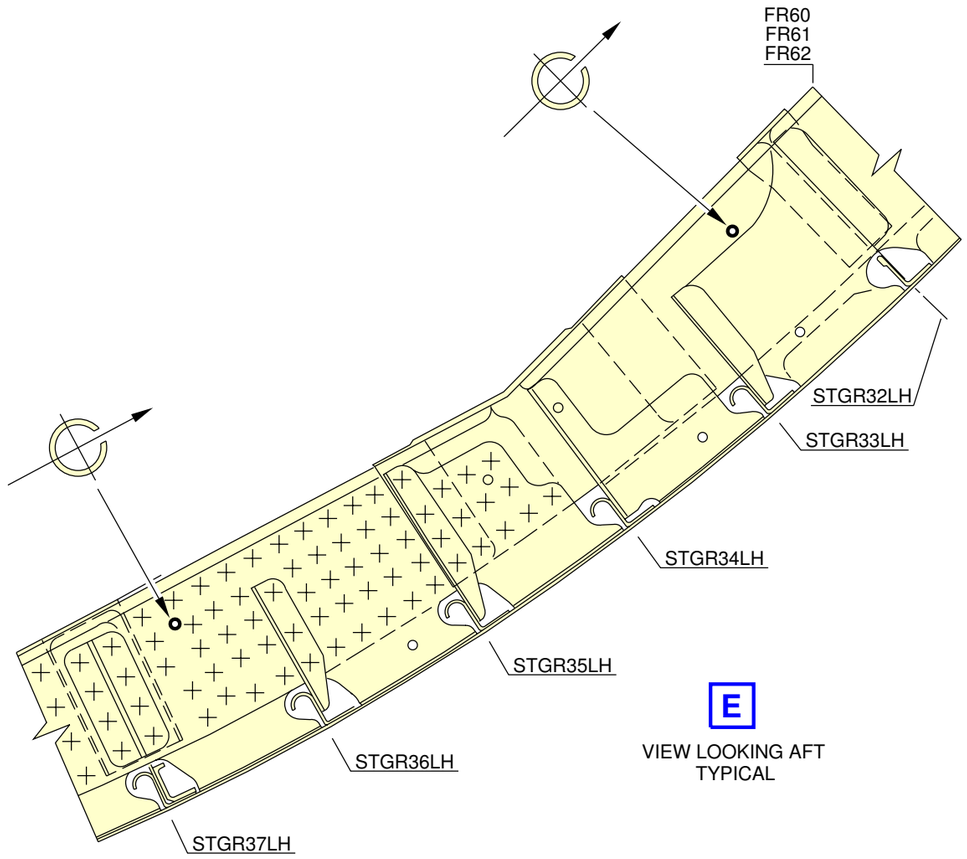
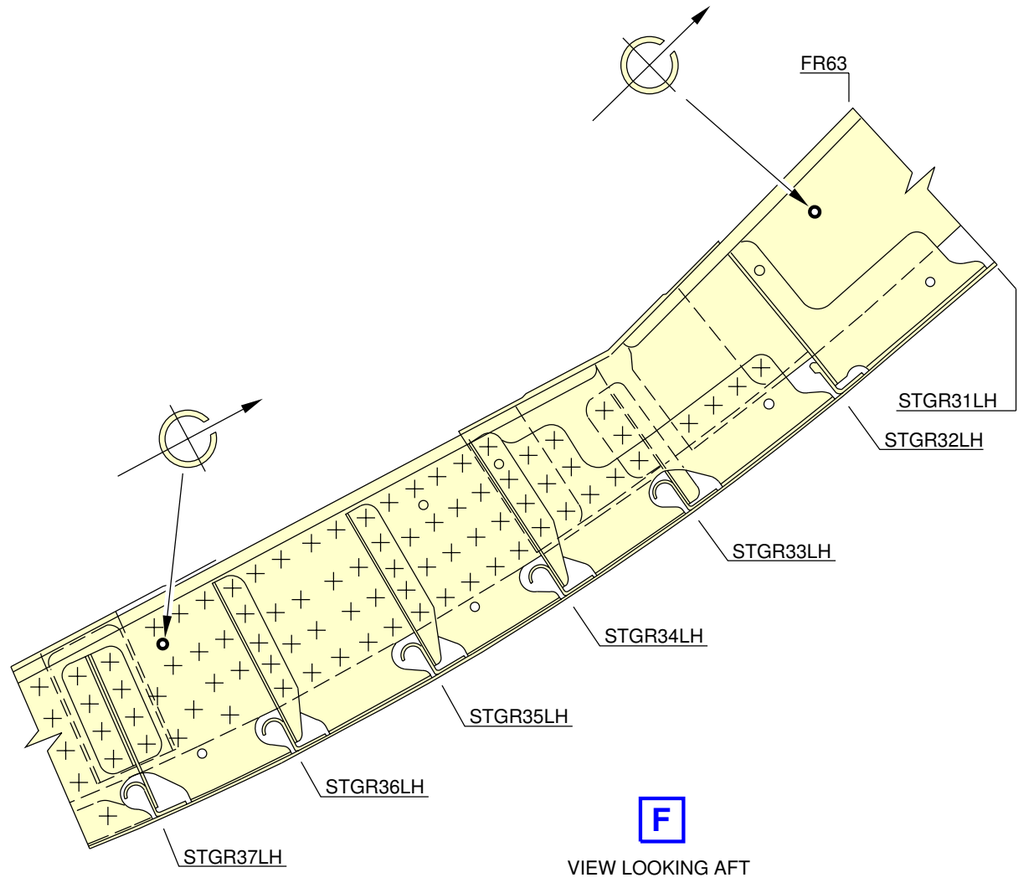
****CONF 001 thru 004, 006, 008**



E

VIEW LOOKING AFT
TYPICAL



F

VIEW LOOKING AFT

POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

NOTE:

┼ EXISTING RIVETS

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING	
		MIN	MAX	MIN	MAX
ONLY COLD WORKED	8–1–N	6.380 mm (0.2512 in)	6.450 mm (0.2539 in)	6.580 mm (0.2591 in)	6.610 mm (0.2602 in)

N_SB_531364_6_BRAA_03_01

Figure A-GBRAA - Sheet 03
Cold Expansion of Holes in Frame 50 thru Frame 63

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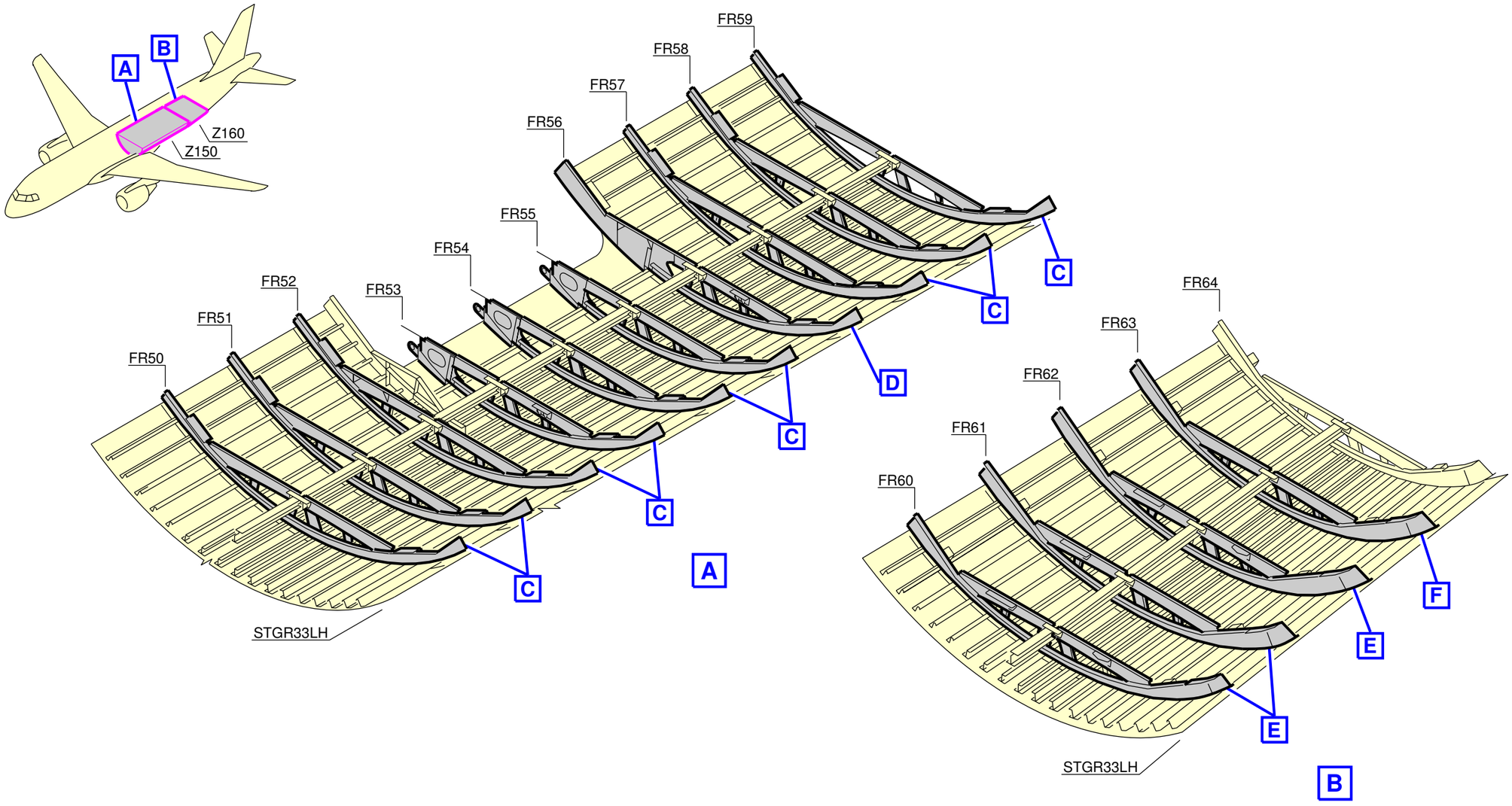
**CONF 005, 007, 009



N_SB_531364_6_BRAB_01_00

Figure A-GBRAB - Sheet 01
Cold Expansion of Holes in Frame 50 thru Frame 63

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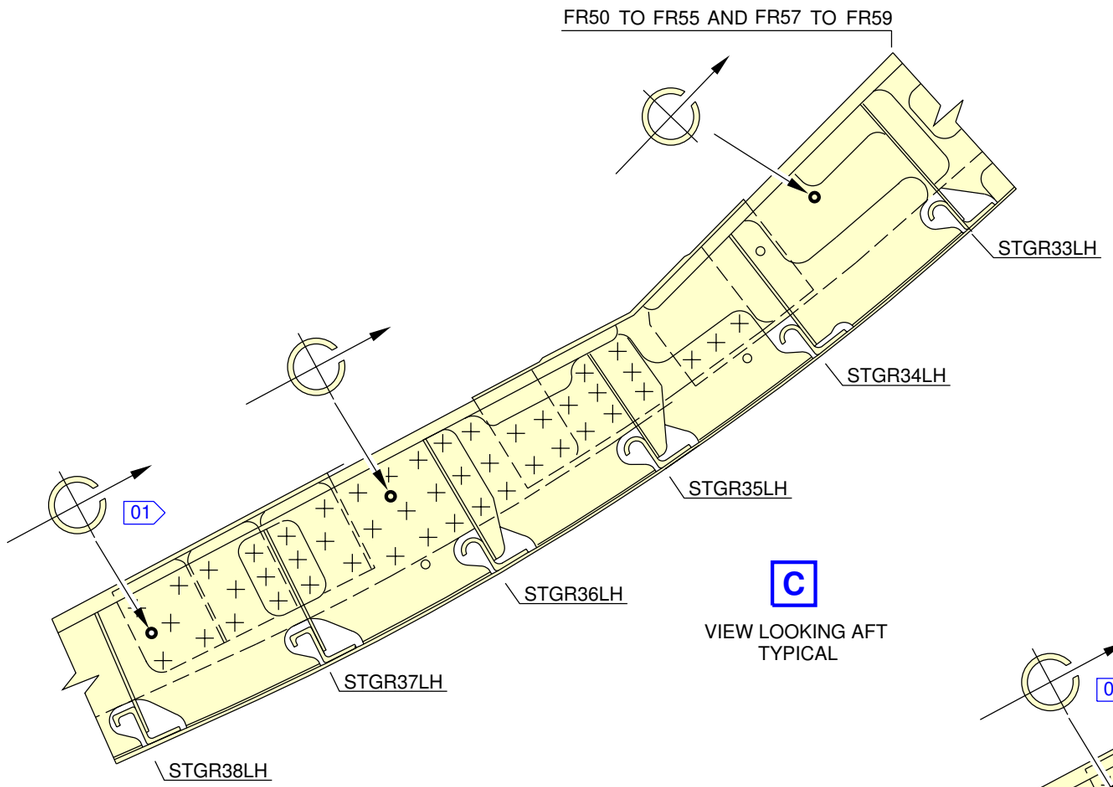
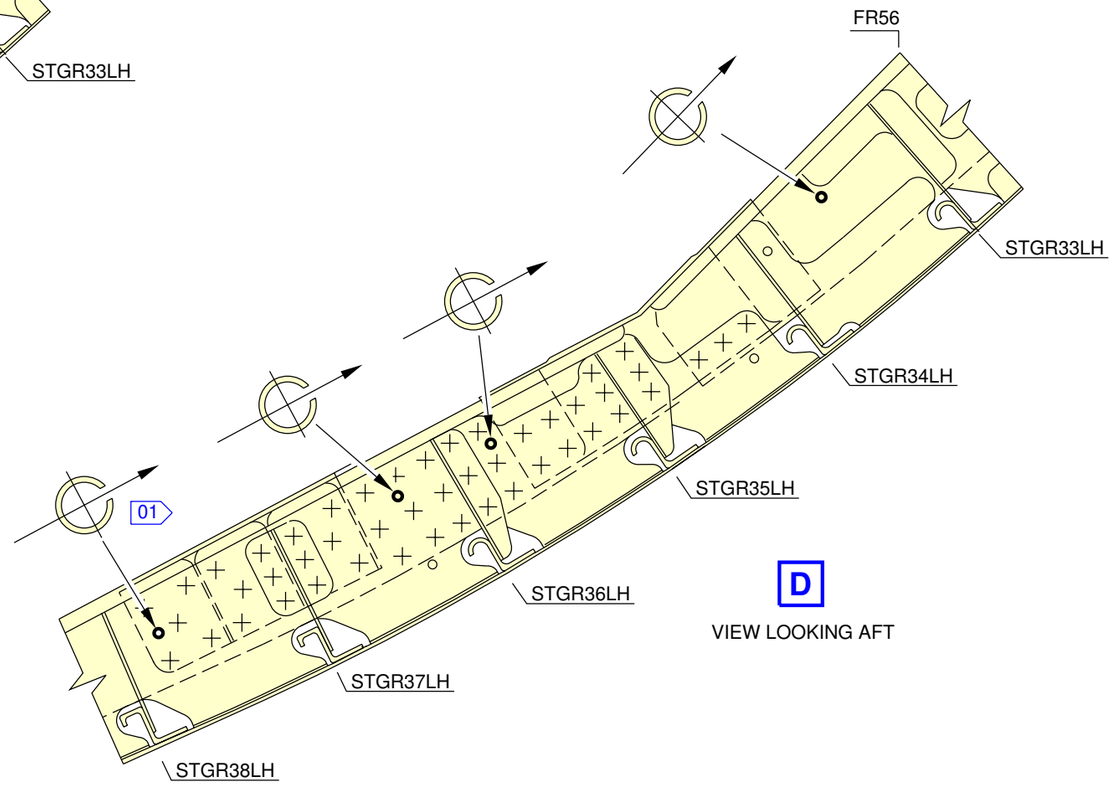
**CONF 005, 007, 009



C

VIEW LOOKING AFT
TYPICAL



D

VIEW LOOKING AFT

POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

NOTE:

01 VALID FOR MSN 3999 AND SUBSEQUENT.

\+ EXISTING RIVETS

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING		NOTE
		MIN	MAX	MIN	MAX	
ONLY COLD WORKED	8–1–N	6.380 mm (0.2512 in)	6.450 mm (0.2539 in)	6.580 mm (0.2591 in)	6.610 mm (0.2602 in)	–
ONLY COLD WORKED	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.450 mm (0.1752 in)	4.480 mm (0.1763 in)	01

N_SB_531364_6_BRAB_02_01

Figure A-GBRAB - Sheet 02
Cold Expansion of Holes in Frame 50 thru Frame 63

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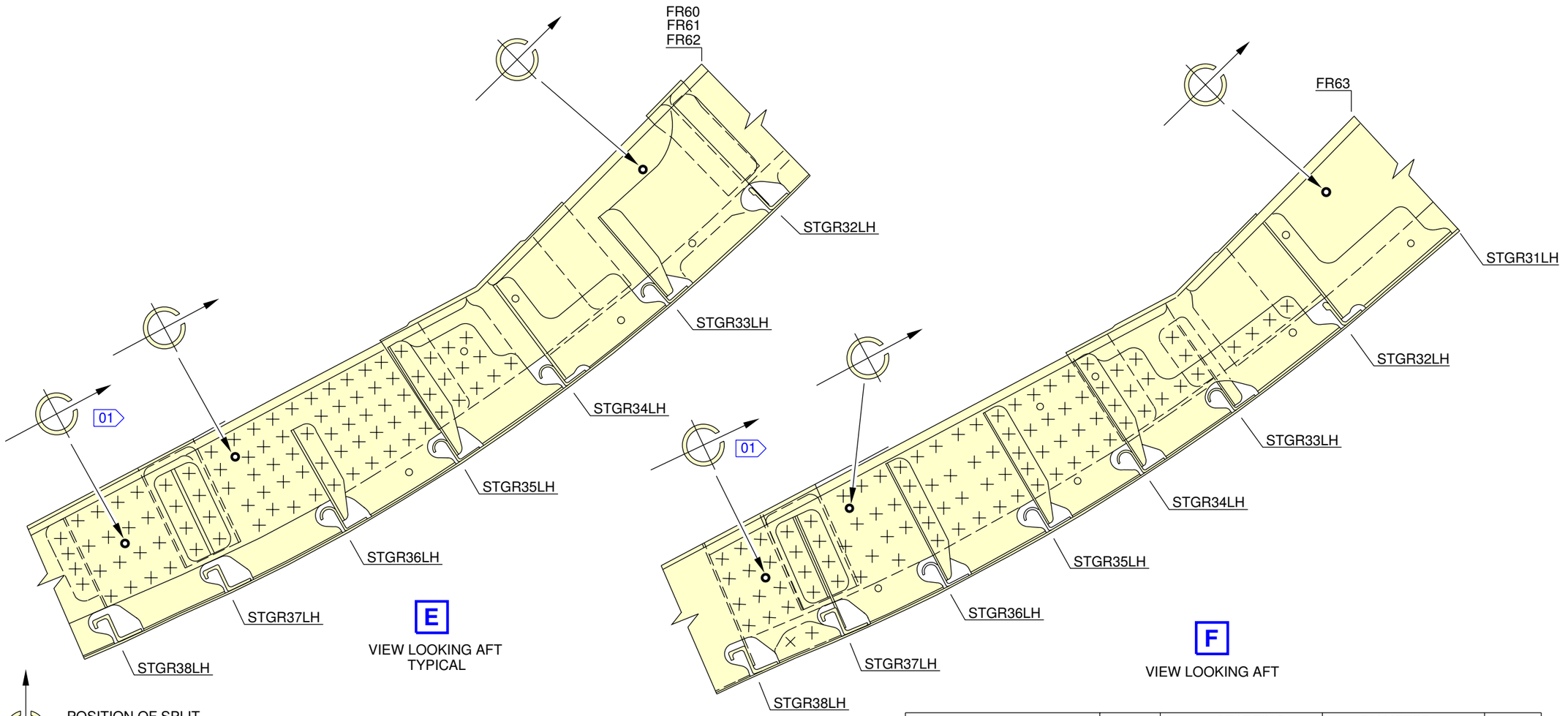
**CONF 005, 007, 009



POSITION OF SPLIT
IN EXPANSION SLEEVE
DURING COLD EXPANSION

STANDARD DIAMETER AFTER MANDREL FORMING	STDN	STARTING HOLE DIAMETER		DIAMETER AFTER FORMING		NOTE
		MIN	MAX	MIN	MAX	
ONLY COLD WORKED	8–1–N	6.380 mm (0.2512 in)	6.450 mm (0.2539 in)	6.580 mm (0.2591 in)	6.610 mm (0.2602 in)	–
ONLY COLD WORKED	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1708 in)	4.450 mm (0.1752 in)	4.480 mm (0.1763 in)	01

NOTE:

01 VALID FOR MSN 3999 AND SUBSEQUENT.

EXISTING RIVETS

N_SB_531364_6_BRAB_03_01

Figure A-GBRAB - Sheet 03
Cold Expansion of Holes in Frame 50 thru Frame 63

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**CONF ALL

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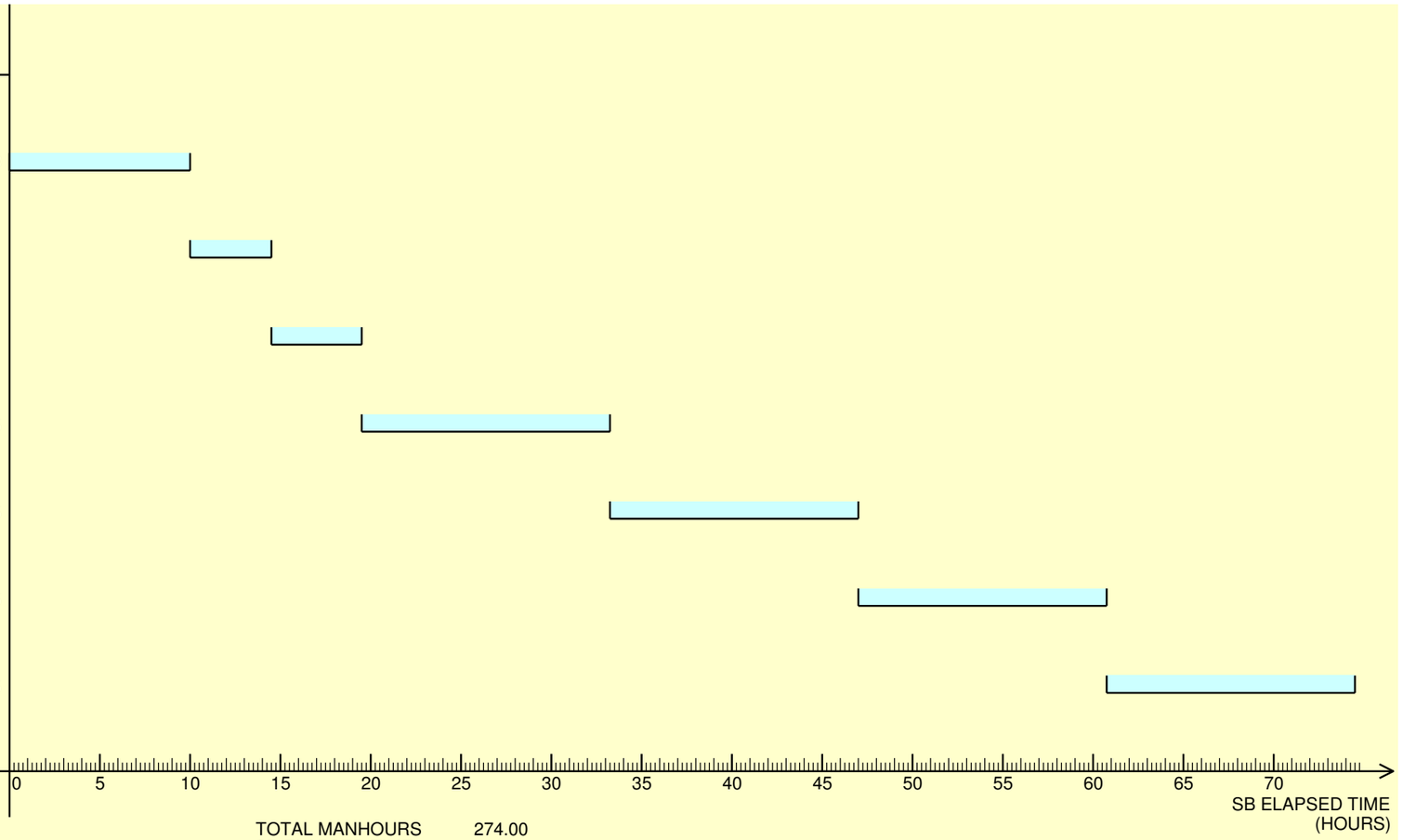
**CONF ALL

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A320–53–1364 01 02

STEPS	MH	PER	ET/S
GET ACCESS	19.00	2	10.00
REMOVE THE SHEAR PLATES AT STGR 38 LH BETWEEN FRAME 50 AND FRAME 63	4.50	1	4.50
COLD EXPAND THE TACK AND TOOLING HOLES FROM FRAME 50 THRU FRAME 63	5.00	1	5.00
REPLACE THE SHEAR WEB AND THE FRAME CLIPS FROM FRAME 50, BETWEEN STGR 34 LH AND STGR 39 LH	15.25	2	13.75
REPLACE THE SHEAR WEB AND THE FRAME CLIPS FROM FRAME 51, BETWEEN STGR 34 LH AND STGR 39 LH	15.25	2	13.75
REPLACE THE SHEAR WEB AND THE FRAME CLIPS FROM FRAME 52, BETWEEN STGR 34 LH AND STGR 39 LH	15.25	2	13.75
REPLACE THE SHEAR WEB AND THE FRAME CLIPS FROM FRAME 53, BETWEEN STGR 34 LH AND STGR 39 LH	15.25	2	13.75



TOTAL MANHOURS 274.00
SB ELAPSED TIME 236.50

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.

N_SB_531364_6_ABAA_01_00

Figure A-GABAA - Sheet 01
Manpower Gantt Chart

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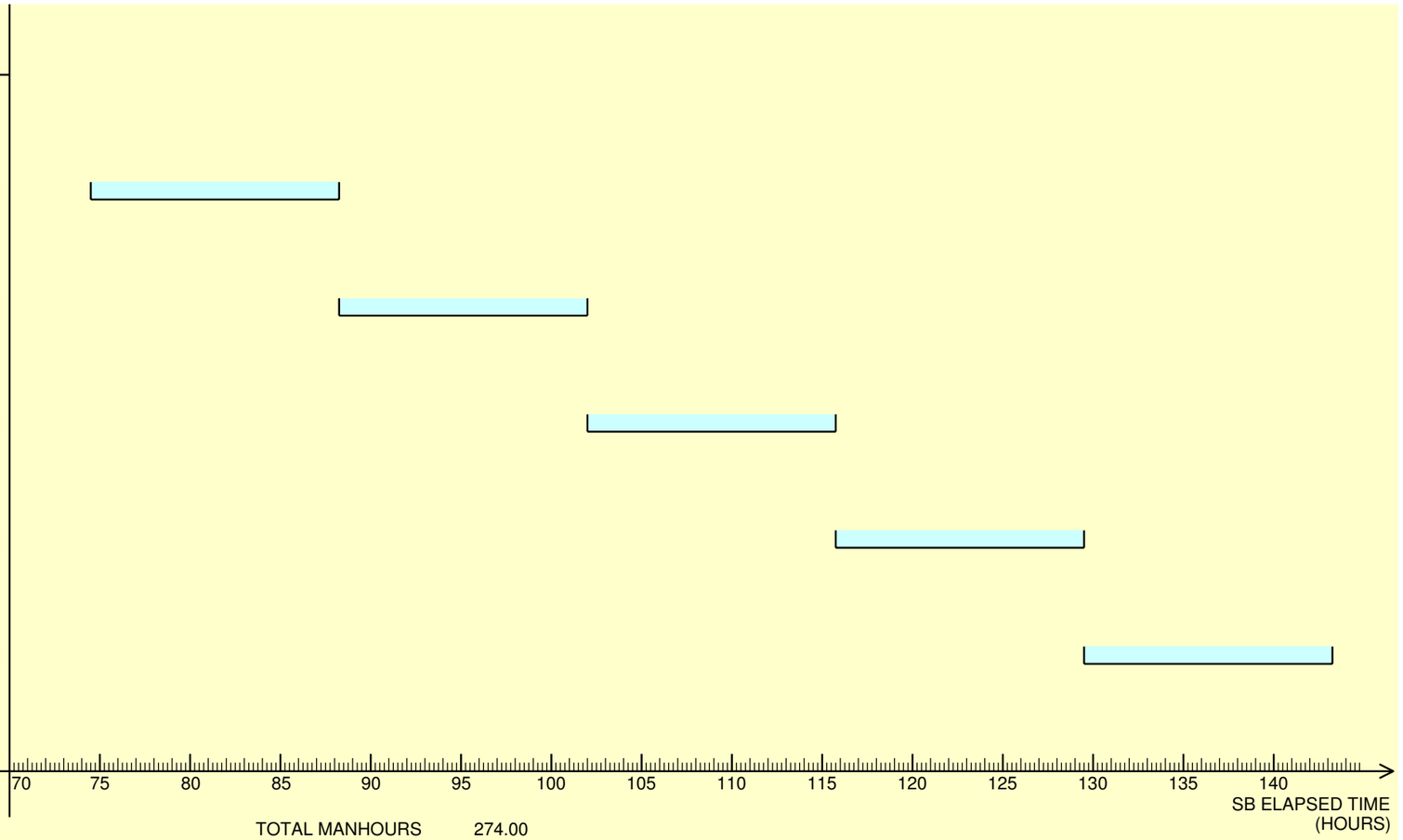
**CONF ALL

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A320–53–1364 01 02

STEPS	MH	PER	ET/S
REPLACE THE SHEAR WEB AND THE FRAME CLIPS FROM FRAME 54, BETWEEN STGR 34 LH AND STGR 39 LH	15.25	2	13.75
REPLACE THE SHEAR WEB AND THE FRAME CLIPS FROM FRAME 55, BETWEEN STGR 34 LH AND STGR 39 LH	15.25	2	13.75
REPLACE THE SHEAR WEB AND THE FRAME CLIPS FROM FRAME 56, BETWEEN STGR 34 LH AND STGR 39 LH	15.25	2	13.75
REPLACE THE SHEAR WEB AND THE FRAME CLIPS FROM FRAME 57, BETWEEN STGR 34 LH AND STGR 39 LH	15.25	2	13.75
REPLACE THE SHEAR WEB AND THE FRAME CLIPS FROM FRAME 58, BETWEEN STGR 34 LH AND STGR 39 LH	15.25	2	13.75



TOTAL MANHOURS 274.00
SB ELAPSED TIME 236.50

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.

N_SB_531364_6_ABAA_02_00

Figure A-GABAA - Sheet 02
Manpower Gantt Chart

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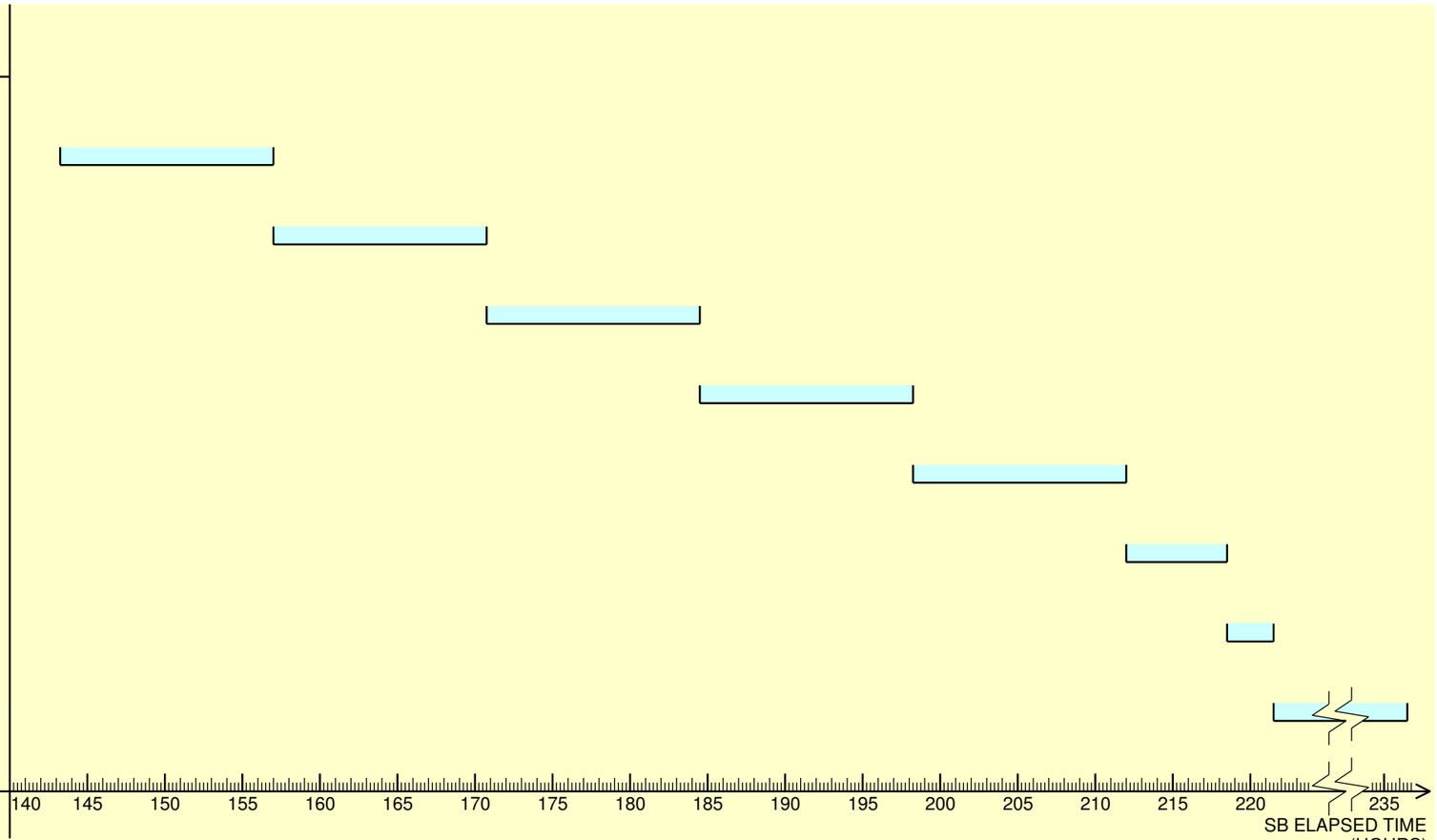
**CONF ALL

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A320–53–1364 01 02

STEPS	MH	PER	ET/S
REPLACE THE SHEAR WEB AND THE FRAME CLIPS FROM FRAME 59, BETWEEN STGR 34 LH AND STGR 39 LH	15.25	2	13.75
REPLACE THE SHEAR WEB AND THE FRAME CLIPS FROM FRAME 60, BETWEEN STGR 34 LH AND STGR 39 LH	15.25	2	13.75
REPLACE THE SHEAR WEB AND THE FRAME CLIPS FROM FRAME 61, BETWEEN STGR 33 LH AND STGR 39 LH	15.25	2	13.75
REPLACE THE SHEAR WEB AND THE FRAME CLIPS FROM FRAME 62, BETWEEN STGR 32 LH AND STGR 39 LH	15.25	2	13.75
REPLACE THE SHEAR WEB AND THE FRAME CLIPS FROM FRAME 63, BETWEEN STGR 32 LH AND STGR 39 LH	15.25	2	13.75
INSTALL THE SHEAR PLATES AT STGR 38 LH BETWEEN FRAME 49 AND FRAME 63	6.50	2	6.50
INSTALL NEW SURFACE PROTECTION ON FRAME 50 THRU FRAME 63	3.00	1	3.00
CLOSE UP	22.50	2	15.00
TOTAL MANHOURS	274.00		
SB ELAPSED TIME	236.50		



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.

N_SB_531364_6_ABAA_03_00

Figure A-GABAA - Sheet 03
Manpower Gantt Chart

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TITLE: FUSELAGE - REAR FUSELAGE - REINFORCE FRAMES IN AREA OF STGR32 - STGR39 LHS SECTION 17

MODIFICATION No.: 153065K15435 153563K15481

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
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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

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