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ATA SYSTEM: 53

**TITLE: FUSELAGE - CENTER SECTION - OVERSIZE UPPER FRAME FEET
SPLICING FROM FR41 TO FR46**

MODIFICATION No.: 13743S22884

This page transmits Revision No.01 of Service Bulletin No.A300-53-6178

ADDITIONAL WORK

****CONF ALL**

Additional work is required by this revision for aircraft modified by any previous issue.

Unless otherwise stated by an Airworthiness Directive, AIRBUS recommends the additional work to be accomplished within one year after the issue of this revision.

The additional work consists in checking in the approved maintenance records, if a rotating probe inspection has been done before accomplishing the oversize of the open-holes during the embodiment on aircraft of the original revision No. 00 of this Service Bulletin.

REASON

Revision No. 01 issued to inform the operators that the rotating probe inspection is to be performed before accomplishing the oversize of the open-holes and to allow covering minor deviations from MOD No. 13748S22884:

- to avoid low edge margin on some holes
- to provide a possible range of diameters for bushes and to extend the authorized diameters from -6 to -6R2 for some fasteners holes.

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

TA	MSN
80509545/003/2018-1	0294 0344 0358 0361 0365 0380 0388 0401 0405 0408 0411 0414 0417 0477 0479 0505 0521 0525 0529-0530 0532 0536 0543 0546 0553 0555 0557-0559 0561 0563 0572 0575 0579 0581 0584 0602 0603 0607 0608 0611 0613 0617 0618 0621 0623 0625 0626 0629 0630 0632 0633 0637 0641 0643 0657 0659 0664 0666 0668 0670 0673 0677 0679 0683 0688 0694 0696 0699 0701 0703 0707 0709 0711 0713 0715 0717 0719 0721-0730 0732-0746 0748-0750 0752-0764 0766 0768-0775 0777-0794 0797 0799-0840 0845-0878

CHANGES

The main changes of this revision are:

- Additional Work task and associated data added
- COMPLIANCE paragraph updated
- MANPOWER paragraph updated
- Modification task updated and associated data modified
 - . Work breakdown modified
- Components procurement addresses modified
- Component COMPA01 to Component COMPA15 updated
- Appendix 01 - Elapsed Time Assumption updated
- Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot and Appendix 03 - Principle of Bush Machining and Installation in the Frame added
- Minor changes applied.

FRONT MATTER		
FUSELAGE - CENTER SECTION - OVERSIZE UPPER FRAME FEET SPLICING FROM FR41 TO FR46	CONFIGURATION UPDATED	R
SUMMARY		
REASON/DESCRIPTION/OPERATIONAL CONSEQUENCES	REASON UPDATED	R
GENERAL EVALUATION	GENERAL EVALUATION TABLE UPDATED	R
MATERIAL PRICE INFORMATION	MATERIAL PRICE INFORMATION TABLE UPDATED	R

	MATERIAL PRICE INFORMATION TABLE UPDATED	R
	MATERIAL PRICE INFORMATION TABLE UPDATED	R
	MATERIAL PRICE INFORMATION TABLE UPDATED	R
	MATERIAL PRICE INFORMATION TABLE UPDATED	R
EFFECTIVITY	OPERATOR LIST UPDATED	R
REFERENCES / REPERCUSSIONS	REFERENCES/REPERCUSSIONS TABLE UPDATED	R
MANPOWER	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
APPENDICES	APPENDICES UPDATED	R
PLANNING INFORMATION		
EFFECTIVITY	EFFECTIVITY RELATED INFORMATION UPDATED	R
Configuration definition		
CONF 001	CONFIGURATION DEFINITION UPDATED	R
CONF 002	CONFIGURATION DEFINITION UPDATED	R
CONF 003	CONFIGURATION DEFINITION UPDATED CONFIGURATION DESCRIPTION UPDATED	R
CONF 004	CONFIGURATION DEFINITION UPDATED CONFIGURATION DESCRIPTION UPDATED	R
Material Effectivity	MATERIAL EFFECTIVITY UPDATED CONFIGURATION UPDATED MATERIAL SET QUANTITY UPDATED MATERIAL SET UPDATED	R
	MATERIAL EFFECTIVITY ADDED	N
	MATERIAL EFFECTIVITY UPDATED CONFIGURATION UPDATED MATERIAL SET QUANTITY UPDATED MATERIAL SET UPDATED	R
	MATERIAL EFFECTIVITY ADDED	N
	MATERIAL EFFECTIVITY ADDED	N
REASON		
History	HISTORY UPDATED	R
Objective/Action	OBJECTIVE/ACTION UPDATED	R
COMPLIANCE		
Accomplishment Timescale	ACCOMPLISHMENT TIMESCALE UPDATED CONFIGURATION UPDATED	R
Accomplishment Timescale	ACCOMPLISHMENT TIMESCALE ADDED	N
Accomplishment Timescale	ACCOMPLISHMENT TIMESCALE ADDED	N
Accomplishment Timescale	ACCOMPLISHMENT TIMESCALE ADDED	N

Accomplishment Timescale	ACCOMPLISHMENT TIMESCALE ADDED	N
Accomplishment Timescale	ACCOMPLISHMENT TIMESCALE DELETED FOR APPLICABLE MSN	D
Accomplishment Timescale	ACCOMPLISHMENT TIMESCALE DELETED FOR APPLICABLE MSN	D
Accomplishment Timescale	ACCOMPLISHMENT TIMESCALE DELETED FOR APPLICABLE MSN	D
Accomplishment Timescale	ACCOMPLISHMENT TIMESCALE DELETED FOR APPLICABLE MSN	D
APPROVAL	APPROVAL UPDATED	R
MANPOWER	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
REFERENCES	REFERENCED DOCUMENTATION UPDATED	R
	REFERENCED DOCUMENTATION UPDATED	R
	REFERENCED DOCUMENTATION UPDATED	R
	REFERENCED DOCUMENTATION UPDATED	R
	REFERENCED DOCUMENTATION UPDATED	R
MATERIAL INFORMATION		
MATERIAL - PRICE AND AVAILABILITY		
Procurement Addresses	PROCUREMENT ADDRESSES UPDATED MATERIAL SET UPDATED	R
Price and Availability	PRICE AND AVAILABILITY UPDATED MATERIAL SET UPDATED	R
LIST OF MATERIALS - OPERATOR SUPPLIED		
Consumable Materials		
Consumable CMLA01	CONSUMABLE MATERIAL SET UPDATED CONSUMABLE UPDATED QUANTITY UPDATED	R
Components	COMPONENTS UPDATED	R
Component COMPA01	PART MATERIAL SET UPDATED PART NUMBER UPDATED QUANTITY UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED	R
Component COMPA02	PART MATERIAL SET UPDATED PART NUMBER UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED QUANTITY UPDATED	R
Component COMPA03	PART MATERIAL SET UPDATED QUANTITY UPDATED PART NUMBER UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED	R

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Component COMPA04	PART MATERIAL SET UPDATED QUANTITY UPDATED PART NUMBER UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED	R
Component COMPA05	PART MATERIAL SET UPDATED QUANTITY UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED	R
Component COMPA06	PART MATERIAL SET UPDATED QUANTITY UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED	R
Component COMPA07	PART MATERIAL SET UPDATED QUANTITY UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED	R
Component COMPA08	PART MATERIAL SET UPDATED QUANTITY UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED	R
Component COMPA09	PART MATERIAL SET UPDATED QUANTITY UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED	R
Component COMPA10	PART MATERIAL SET UPDATED QUANTITY UPDATED PART NUMBER UPDATED ITEM NUMBER UPDATED KEYWORD UPDATED	R
Component COMPA11	PART MATERIAL SET UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED	R
Component COMPA12	PART MATERIAL SET UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED	R
Component COMPA13	PART MATERIAL SET UPDATED PART NUMBER UPDATED QUANTITY UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED	R

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Component COMPA14	PART MATERIAL SET UPDATED PART NUMBER UPDATED QUANTITY UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED	R
Component COMPA15	PART MATERIAL SET UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED	R
Component COMPA16	PART MATERIAL SET ADDED	N
Component COMPA17	PART MATERIAL SET ADDED	N
ACCOMPLISHMENT INSTRUCTIONS		
TASK 536178- 831-801-001-Modification	TASK SOLUTION UPDATED NOTE UPDATED CAUTION UPDATED	R
Task associated data - 001	MAN HOURS UPDATED ELAPSED TIME UPDATED	R
Task associated data - 002	MAN HOURS UPDATED ELAPSED TIME UPDATED	R
Task associated data - 003	MAN HOURS UPDATED ELAPSED TIME UPDATED	R
Task associated data - 004	MAN HOURS UPDATED ELAPSED TIME UPDATED	R
Task associated data - 005	MAN HOURS UPDATED ELAPSED TIME UPDATED	R
Subtask 536178-941-001-001	SUBTASK SOLUTION UPDATED NOTE UPDATED	R
Subtask 536178-941-001-001	SUBTASK SOLUTION UPDATED NOTE UPDATED	R
Subtask 536178-941-001-002	SUBTASK SOLUTION UPDATED CONFIGURATION UPDATED REFERENCED DOCUMENTATION UPDATED FIGURE REFERENCE UPDATED ZONE UPDATED REFERENCES UPDATED NOTE UPDATED	R
Subtask 536178-941-001-002	SUBTASK SOLUTION UPDATED CONFIGURATION UPDATED REFERENCED DOCUMENTATION UPDATED FIGURE REFERENCE UPDATED ZONE UPDATED REFERENCES UPDATED NOTE UPDATED	R
Subtask 536178-941-001-001	SUBTASK SOLUTION UPDATED NOTE UPDATED	R
Subtask 536178-000-001-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-002-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-003-001	SUBTASK SOLUTION ADDED	N

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Subtask 536178-000-004-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-005-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-006-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-007-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-008-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-009-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-010-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-011-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-012-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-013-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-014-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-015-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-016-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-017-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-018-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-001-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-002-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-003-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-004-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-005-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-006-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-007-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-008-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-009-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-010-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-011-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-012-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-013-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-014-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-015-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-016-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-017-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-018-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-001-001	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CAUTION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R

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Subtask 536178-831-002-001	SUBTASK SOLUTION UPDATED ZONE UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED CAUTION UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R
Subtask 536178-831-003-001	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED CAUTION UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R
Subtask 536178-831-004-001	SUBTASK SOLUTION UPDATED ZONE UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED CAUTION UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R

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Subtask 536178-831-005-001	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED CAUTION UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R
Subtask 536178-831-006-001	SUBTASK SOLUTION UPDATED ZONE UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED CAUTION UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R
Subtask 536178-831-007-001	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED PART NUMBER DESCRIPTION UPDATED CAUTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED MATERIAL LIST UPDATED REFERENCES UPDATED	R

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Subtask 536178-831-008-001	SUBTASK SOLUTION UPDATED ZONE UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED PART NUMBER DESCRIPTION UPDATED CAUTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED MATERIAL LIST UPDATED REFERENCES UPDATED	R
Subtask 536178-831-009-001	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED FIGURE REFERENCE UPDATED CAUTION UPDATED CONFIGURATION UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R
Subtask 536178-831-010-001	SUBTASK SOLUTION UPDATED ZONE UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED FIGURE REFERENCE UPDATED CAUTION UPDATED CONFIGURATION UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R

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Subtask 536178-831-011-001	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED CAUTION UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R
Subtask 536178-831-012-001	SUBTASK SOLUTION UPDATED ZONE UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED CAUTION UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R
Subtask 536178-831-013-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-014-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-015-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-016-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-017-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-018-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-001-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-002-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-003-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-004-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-005-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-006-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-019-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-020-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-021-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-022-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-831-024-001	SUBTASK SOLUTION ADDED	N

Subtask 536178-800-001-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-002-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-003-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-800-006-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-000-027-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-000-035-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-036-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-019-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-020-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-831-026-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-027-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-028-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-029-001	SUBTASK SOLUTION ADDED	N

Subtask 536178-831-030-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-031-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-032-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-033-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-034-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-035-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-036-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-037-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-038-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-039-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-040-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-041-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-042-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-007-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-008-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-009-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-010-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-011-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-012-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-043-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-044-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-045-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-046-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-047-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-048-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-007-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-008-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-009-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-010-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-011-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-012-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-001-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-002-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-003-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-004-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-005-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-006-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-007-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-008-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-009-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-010-003	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-011-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-012-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-013-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-014-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-015-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-016-002	SUBTASK SOLUTION ADDED	N

Subtask 536178-000-017-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-018-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-001-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-002-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-003-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-004-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-005-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-006-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-007-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-008-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-009-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-010-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-011-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-012-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-013-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-014-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-015-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-016-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-017-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-018-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-001-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-002-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-003-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-004-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-005-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-006-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-007-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-008-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-009-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-010-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-011-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-012-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-013-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-014-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-015-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-016-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-017-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-018-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-001-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-002-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-003-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-004-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-005-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-006-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-019-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-020-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-021-002	SUBTASK SOLUTION ADDED	N

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Subtask 536178-831-022-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-023-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-024-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-001-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-002-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-003-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-004-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-005-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-006-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-019-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-020-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-021-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-022-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-023-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-024-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-025-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-026-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-027-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-028-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-029-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-030-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-031-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-032-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-033-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-034-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-035-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-036-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-019-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-020-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-021-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-022-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-023-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-024-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-025-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-026-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-027-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-028-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-029-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-030-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-031-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-032-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-033-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-034-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-035-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-036-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-025-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-026-001	SUBTASK SOLUTION ADDED	N

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Subtask 536178-831-027-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-028-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-029-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-030-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-031-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-032-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-033-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-034-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-035-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-036-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-037-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-038-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-039-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-040-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-041-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-042-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-007-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-008-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-009-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-010-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-011-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-012-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-043-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-044-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-045-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-046-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-047-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-048-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-007-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-008-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-009-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-010-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-011-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-012-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-001-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-002-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-003-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-004-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-005-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-006-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D

Subtask 536178-831-007-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-008-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-009-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-010-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-011-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-012-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-000-001-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-002-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-003-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-004-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-005-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-006-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-007-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-008-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-009-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-010-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-011-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-012-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-013-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-014-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-015-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-016-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-017-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-018-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-001-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-002-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-003-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-004-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-005-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-006-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-007-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-008-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-009-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-010-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-011-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-012-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-013-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-014-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-015-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-016-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-017-001	SUBTASK SOLUTION ADDED	N

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Subtask 536178-250-018-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-001-001	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CAUTION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R
Subtask 536178-831-002-001	SUBTASK SOLUTION UPDATED ZONE UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED CAUTION UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R
Subtask 536178-831-003-001	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED CAUTION UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R

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Subtask 536178-831-004-001	SUBTASK SOLUTION UPDATED ZONE UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED CAUTION UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R
Subtask 536178-831-005-001	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED CAUTION UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R
Subtask 536178-831-006-001	SUBTASK SOLUTION UPDATED ZONE UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED CAUTION UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R

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Subtask 536178-831-007-001	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED PART NUMBER DESCRIPTION UPDATED CAUTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED MATERIAL LIST UPDATED REFERENCES UPDATED	R
Subtask 536178-831-008-001	SUBTASK SOLUTION UPDATED ZONE UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED PART NUMBER DESCRIPTION UPDATED CAUTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED MATERIAL LIST UPDATED REFERENCES UPDATED	R
Subtask 536178-831-009-001	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED FIGURE REFERENCE UPDATED CAUTION UPDATED CONFIGURATION UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R

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Subtask 536178-831-010-001	SUBTASK SOLUTION UPDATED ZONE UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED FIGURE REFERENCE UPDATED CAUTION UPDATED CONFIGURATION UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R
Subtask 536178-831-011-001	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED CAUTION UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R
Subtask 536178-831-012-001	SUBTASK SOLUTION UPDATED ZONE UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED CAUTION UPDATED PART NUMBER DESCRIPTION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R
Subtask 536178-831-013-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-014-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-015-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-016-001	SUBTASK SOLUTION ADDED	N

Subtask 536178-831-017-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-018-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-001-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-002-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-003-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-004-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-005-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-006-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-019-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-020-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-021-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-022-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-023-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-024-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-001-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-002-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-003-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-004-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-005-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-006-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-019-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-020-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-021-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-022-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-023-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-024-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-025-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-026-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-027-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-028-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-000-030-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-031-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-032-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-033-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-034-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-035-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-036-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-019-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-020-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-021-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-022-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-023-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-024-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-025-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-026-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-027-001	SUBTASK SOLUTION ADDED	N

Subtask 536178-250-028-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-029-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-030-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-031-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-032-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-033-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-034-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-035-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-036-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-025-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-026-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-027-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-831-029-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-030-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-031-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-032-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-033-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-034-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-035-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-036-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-037-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-038-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-039-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-040-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-041-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-042-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-007-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-008-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-009-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-010-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-011-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-012-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-043-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-044-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-045-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-046-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-047-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-048-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-007-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-008-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-009-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-010-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-011-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-012-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-001-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-002-002	SUBTASK SOLUTION ADDED	N

Subtask 536178-000-003-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-004-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-005-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-006-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-007-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-008-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-009-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-010-003	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-011-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-012-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-013-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-014-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-015-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-016-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-017-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-018-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-001-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-002-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-003-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-004-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-005-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-006-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-007-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-008-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-009-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-010-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-011-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-012-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-013-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-014-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-015-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-016-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-017-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-018-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-001-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-002-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-003-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-004-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-005-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-006-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-007-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-008-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-009-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-010-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-011-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-012-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-013-002	SUBTASK SOLUTION ADDED	N

Subtask 536178-831-014-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-015-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-016-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-017-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-018-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-001-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-002-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-003-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-004-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-005-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-006-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-019-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-020-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-021-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-022-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-023-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-024-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-001-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-002-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-003-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-000-019-002	SUBTASK SOLUTION ADDED	N
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Subtask 536178-000-023-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-024-002	SUBTASK SOLUTION ADDED	N
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Subtask 536178-000-027-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-028-002	SUBTASK SOLUTION ADDED	N
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Subtask 536178-000-030-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-031-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-032-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-033-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-034-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-035-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-036-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-019-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-020-002	SUBTASK SOLUTION ADDED	N
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Subtask 536178-250-022-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-023-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-024-002	SUBTASK SOLUTION ADDED	N

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Subtask 536178-250-025-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-026-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-027-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-250-030-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-031-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-032-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-033-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-034-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-035-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-036-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-025-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-831-027-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-831-030-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-031-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-032-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-033-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-831-036-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-400-011-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-012-002	SUBTASK SOLUTION ADDED	N
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Subtask 536178-831-045-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-046-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-047-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-048-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-007-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-800-011-001	SUBTASK SOLUTION ADDED	N

Subtask 536178-800-012-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-001-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-002-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-003-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-004-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-005-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-006-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-007-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-008-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-009-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-010-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-011-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-012-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
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Subtask 536178-000-004-003	SUBTASK SOLUTION ADDED	N
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Subtask 536178-000-007-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-250-003-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-004-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-005-002	SUBTASK SOLUTION ADDED	N

Subtask 536178-250-006-002	SUBTASK SOLUTION ADDED	N
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Subtask 536178-250-008-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-250-011-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-012-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-013-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-014-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-015-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-250-018-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-001-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-002-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-831-004-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-005-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-831-008-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-831-017-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-018-002	SUBTASK SOLUTION ADDED	N
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Subtask 536178-400-003-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-004-003	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-005-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-006-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-019-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-020-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-021-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-022-003	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-023-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-024-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-001-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-002-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-003-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-004-001	SUBTASK SOLUTION ADDED	N

Subtask 536178-800-005-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-006-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-019-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-020-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-021-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-022-003	SUBTASK SOLUTION ADDED	N
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Subtask 536178-000-024-002	SUBTASK SOLUTION ADDED	N
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Subtask 536178-000-033-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-034-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-035-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-000-036-002	SUBTASK SOLUTION ADDED	N
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Subtask 536178-250-020-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-021-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-022-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-023-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-024-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-025-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-026-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-027-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-028-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-029-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-030-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-031-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-032-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-033-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-034-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-035-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-250-036-001	SUBTASK SOLUTION ADDED	N
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Subtask 536178-831-026-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-027-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-028-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-029-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-030-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-031-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-032-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-033-001	SUBTASK SOLUTION ADDED	N

Subtask 536178-831-034-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-035-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-036-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-037-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-038-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-039-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-040-003	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-041-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-042-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-007-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-008-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-009-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-010-003	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-011-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-400-012-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-043-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-044-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-045-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-046-003	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-047-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-048-002	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-007-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-008-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-009-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-010-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-011-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-800-012-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-831-001-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-002-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-003-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-004-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-005-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-006-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-007-003	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-008-003	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-009-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-010-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D

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Subtask 536178-831-011-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-831-012-002	SUBTASK SOLUTION DELETED FOR APPLICABLE MSN	D
Subtask 536178-700-001-001	SUBTASK SOLUTION UPDATED NOTE UPDATED	R
Subtask 536178-700-001-001	SUBTASK SOLUTION UPDATED NOTE UPDATED	R
Subtask 536178-700-001-001	SUBTASK SOLUTION UPDATED NOTE UPDATED	R
Subtask 536178-942-001-002	SUBTASK SOLUTION UPDATED KEYWORD UPDATED PART NUMBER UPDATED QUANTITY UPDATED MATERIAL LIST UPDATED CONFIGURATION UPDATED REFERENCED DOCUMENTATION UPDATED FIGURE REFERENCE UPDATED NOTE UPDATED PART NUMBER DESCRIPTION UPDATED REFERENCES UPDATED	R
Subtask 536178-942-001-002	SUBTASK SOLUTION UPDATED KEYWORD UPDATED PART NUMBER UPDATED QUANTITY UPDATED MATERIAL LIST UPDATED CONFIGURATION UPDATED REFERENCED DOCUMENTATION UPDATED FIGURE REFERENCE UPDATED NOTE UPDATED PART NUMBER DESCRIPTION UPDATED REFERENCES UPDATED	R
TASK 536178- 839-801-001-Inspection - ADDITIONAL WORK	TASK SOLUTION ADDED	N
Task associated data - 001	TASK ASSOCIATED DATA ADDED	N
Task associated data - 002	TASK ASSOCIATED DATA ADDED	N
Task associated data - 003	TASK ASSOCIATED DATA ADDED	N
Task associated data - 004	TASK ASSOCIATED DATA ADDED	N
Task associated data - 005	TASK ASSOCIATED DATA ADDED	N
Subtask 536178-839-003-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-839-003-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-839-003-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-839-003-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-839-003-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-832-003-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-832-003-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-832-003-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-832-003-001	SUBTASK SOLUTION ADDED	N
Subtask 536178-832-003-001	SUBTASK SOLUTION ADDED	N

Fig. A-FBAAA	FIGURE SOLUTION UPDATED	R
Fig. A-FBAAA Sheet 01	SHEET UPDATED	R
Fig. A-FBAAA Sheet 02	SHEET UPDATED	R
Fig. A-FBAAA Sheet 03	SHEET UPDATED	R
Fig. A-FBAAB	FIGURE SOLUTION UPDATED	R
Fig. A-FBAAB Sheet 01	SHEET UPDATED	R
Fig. A-FBAAB Sheet 02	SHEET UPDATED	R
Fig. A-FBAAB Sheet 03	SHEET UPDATED	R
Fig. A-FBBAA	FIGURE SOLUTION UPDATED	R
Fig. A-FBBAA Sheet 01	SHEET UPDATED	R
Fig. A-FBBAA Sheet 02	SHEET UPDATED	R
Fig. A-FBBAA Sheet 03	SHEET UPDATED	R
Fig. A-FBBAB	FIGURE SOLUTION UPDATED	R
Fig. A-FBBAB Sheet 01	SHEET UPDATED	R
Fig. A-FBBAB Sheet 02	SHEET UPDATED	R
Fig. A-FBBAB Sheet 03	SHEET UPDATED	R
Fig. A-FBCAA	FIGURE SOLUTION UPDATED	R
Fig. A-FBCAA Sheet 01	SHEET UPDATED	R
Fig. A-FBCAA Sheet 02	SHEET UPDATED	R
Fig. A-FBCAA Sheet 03	SHEET UPDATED	R
Fig. A-FBCAB	FIGURE SOLUTION UPDATED	R
Fig. A-FBCAB Sheet 01	SHEET UPDATED	R
Fig. A-FBCAB Sheet 02	SHEET UPDATED	R
Fig. A-FBCAB Sheet 03	SHEET UPDATED	R
Fig. A-FBDAA	FIGURE SOLUTION UPDATED	R
Fig. A-FBDAA Sheet 01	SHEET UPDATED	R
Fig. A-FBDAA Sheet 02	SHEET UPDATED	R
Fig. A-FBDAA Sheet 03	SHEET UPDATED	R
Fig. A-FBDAA Sheet 04	SHEET DELETED	D
Fig. A-FBDAB	FIGURE SOLUTION UPDATED	R
Fig. A-FBDAB Sheet 01	SHEET UPDATED	R
Fig. A-FBDAB Sheet 02	SHEET UPDATED	R
Fig. A-FBDAB Sheet 03	SHEET UPDATED	R
Fig. A-FBDAB Sheet 04	SHEET DELETED	D
Fig. A-FBDAC	FIGURE SOLUTION UPDATED	R
Fig. A-FBDAC Sheet 01	SHEET UPDATED	R
Fig. A-FBDAC Sheet 02	SHEET UPDATED	R
Fig. A-FBDAC Sheet 03	SHEET UPDATED	R
Fig. A-FBDAC Sheet 04	SHEET DELETED	D
Fig. A-FBEAA	FIGURE SOLUTION UPDATED	R
Fig. A-FBEAA Sheet 01	SHEET UPDATED	R

Fig. A-FBEAA Sheet 02	SHEET UPDATED	R
Fig. A-FBEAA Sheet 03	SHEET UPDATED	R
Fig. A-FBEAB	FIGURE SOLUTION UPDATED	R
Fig. A-FBEAB Sheet 01	SHEET UPDATED	R
Fig. A-FBEAB Sheet 02	SHEET UPDATED	R
Fig. A-FBEAB Sheet 03	SHEET UPDATED	R
Fig. A-FBFAA	FIGURE SOLUTION UPDATED	R
Fig. A-FBFAA Sheet 01	SHEET UPDATED	R
Fig. A-FBFAA Sheet 02	SHEET UPDATED	R
Fig. A-FBFAA Sheet 03	SHEET UPDATED	R
Fig. A-FBFAB	FIGURE SOLUTION UPDATED	R
Fig. A-FBFAB Sheet 01	SHEET UPDATED	R
Fig. A-FBFAB Sheet 02	SHEET UPDATED	R
Fig. A-FBFAB Sheet 03	SHEET UPDATED	R
Fig. A-FCAAA	FIGURE SOLUTION ADDED	N
Fig. A-FCAAA Sheet 01	SHEET ADDED	N
Fig. A-FCAAA Sheet 02	SHEET ADDED	N
Fig. A-FCAAB	FIGURE SOLUTION ADDED	N
Fig. A-FCAAB Sheet 01	SHEET ADDED	N
Fig. A-FCAAB Sheet 02	SHEET ADDED	N
Fig. A-FCBAA	FIGURE SOLUTION ADDED	N
Fig. A-FCBAA Sheet 01	SHEET ADDED	N
Fig. A-FCBAA Sheet 02	SHEET ADDED	N
Fig. A-FCBAB	FIGURE SOLUTION ADDED	N
Fig. A-FCBAB Sheet 01	SHEET ADDED	N
Fig. A-FCBAB Sheet 02	SHEET ADDED	N
Fig. A-FCCAA	FIGURE SOLUTION ADDED	N
Fig. A-FCCAA Sheet 01	SHEET ADDED	N
Fig. A-FCCAA Sheet 02	SHEET ADDED	N
Fig. A-FCCAB	FIGURE SOLUTION ADDED	N
Fig. A-FCCAB Sheet 01	SHEET ADDED	N
Fig. A-FCCAB Sheet 02	SHEET ADDED	N
Fig. A-FCDAA	FIGURE SOLUTION ADDED	N
Fig. A-FCDAA Sheet 01	SHEET ADDED	N
Fig. A-FCDAA Sheet 02	SHEET ADDED	N
Fig. A-FCDAA Sheet 03	SHEET ADDED	N
Fig. A-FCDAB	FIGURE SOLUTION ADDED	N
Fig. A-FCDAB Sheet 01	SHEET ADDED	N
Fig. A-FCDAB Sheet 02	SHEET ADDED	N
Fig. A-FCDAC	FIGURE SOLUTION ADDED	N
Fig. A-FCDAC Sheet 01	SHEET ADDED	N

Fig. A-FCDAC Sheet 02	SHEET ADDED	N
Fig. A-FCDAC Sheet 03	SHEET ADDED	N
Fig. A-FCEAA	FIGURE SOLUTION ADDED	N
Fig. A-FCEAA Sheet 01	SHEET ADDED	N
Fig. A-FCEAA Sheet 02	SHEET ADDED	N
Fig. A-FCEAB	FIGURE SOLUTION ADDED	N
Fig. A-FCEAB Sheet 01	SHEET ADDED	N
Fig. A-FCEAB Sheet 02	SHEET ADDED	N
Fig. A-FCFAA	FIGURE SOLUTION ADDED	N
Fig. A-FCFAA Sheet 01	SHEET ADDED	N
Fig. A-FCFAA Sheet 02	SHEET ADDED	N
Fig. A-FCFAB	FIGURE SOLUTION ADDED	N
Fig. A-FCFAB Sheet 01	SHEET ADDED	N
Fig. A-FCFAB Sheet 02	SHEET ADDED	N
Fig. A-FDAAA	FIGURE SOLUTION ADDED	N
Fig. A-FDAAA Sheet 01	SHEET ADDED	N
Fig. A-FDAAA Sheet 02	SHEET ADDED	N
Fig. A-FDAAB	FIGURE SOLUTION ADDED	N
Fig. A-FDAAB Sheet 01	SHEET ADDED	N
Fig. A-FDAAB Sheet 02	SHEET ADDED	N
Fig. A-FDBAA	FIGURE SOLUTION ADDED	N
Fig. A-FDBAA Sheet 01	SHEET ADDED	N
Fig. A-FDBAA Sheet 02	SHEET ADDED	N
Fig. A-FDBAB	FIGURE SOLUTION ADDED	N
Fig. A-FDBAB Sheet 01	SHEET ADDED	N
Fig. A-FDBAB Sheet 02	SHEET ADDED	N
Fig. A-FDCAA	FIGURE SOLUTION ADDED	N
Fig. A-FDCAA Sheet 01	SHEET ADDED	N
Fig. A-FDCAA Sheet 02	SHEET ADDED	N
Fig. A-FDCAB	FIGURE SOLUTION ADDED	N
Fig. A-FDCAB Sheet 01	SHEET ADDED	N
Fig. A-FDCAB Sheet 02	SHEET ADDED	N
Fig. A-FDDAA	FIGURE SOLUTION ADDED	N
Fig. A-FDDAA Sheet 01	SHEET ADDED	N
Fig. A-FDDAA Sheet 02	SHEET ADDED	N
Fig. A-FDDAB	FIGURE SOLUTION ADDED	N
Fig. A-FDDAB Sheet 01	SHEET ADDED	N
Fig. A-FDDAB Sheet 02	SHEET ADDED	N
Fig. A-FDDAC	FIGURE SOLUTION ADDED	N
Fig. A-FDDAC Sheet 01	SHEET ADDED	N
Fig. A-FDDAC Sheet 02	SHEET ADDED	N

Fig. A-FDEAA	FIGURE SOLUTION ADDED	N
Fig. A-FDEAA Sheet 01	SHEET ADDED	N
Fig. A-FDEAA Sheet 02	SHEET ADDED	N
Fig. A-FDEAB	FIGURE SOLUTION ADDED	N
Fig. A-FDEAB Sheet 01	SHEET ADDED	N
Fig. A-FDEAB Sheet 02	SHEET ADDED	N
Fig. A-FDFAA	FIGURE SOLUTION ADDED	N
Fig. A-FDFAA Sheet 01	SHEET ADDED	N
Fig. A-FDFAA Sheet 02	SHEET ADDED	N
Fig. A-FDFAB	FIGURE SOLUTION ADDED	N
Fig. A-FDFAB Sheet 01	SHEET ADDED	N
Fig. A-FDFAB Sheet 02	SHEET ADDED	N
Fig. A-FEAAA	FIGURE SOLUTION ADDED	N
Fig. A-FEAAA Sheet 01	SHEET ADDED	N
Fig. A-FEAAA Sheet 02	SHEET ADDED	N
Fig. A-FEBAA	FIGURE SOLUTION ADDED	N
Fig. A-FEBAA Sheet 01	SHEET ADDED	N
Fig. A-FEBAA Sheet 02	SHEET ADDED	N
Fig. A-FECAA	FIGURE SOLUTION ADDED	N
Fig. A-FECAA Sheet 01	SHEET ADDED	N
Fig. A-FECAA Sheet 02	SHEET ADDED	N
Fig. A-FEDAA	FIGURE SOLUTION ADDED	N
Fig. A-FEDAA Sheet 01	SHEET ADDED	N
Fig. A-FEDAA Sheet 02	SHEET ADDED	N
Fig. A-FEGAA	FIGURE SOLUTION ADDED	N
Fig. A-FEGAA Sheet 01	SHEET ADDED	N
Fig. A-FEGAA Sheet 02	SHEET ADDED	N
Fig. A-FEFAA	FIGURE SOLUTION ADDED	N
Fig. A-FEFAA Sheet 01	SHEET ADDED	N
Fig. A-FEFAA Sheet 02	SHEET ADDED	N
Fig. A-FFAAA	FIGURE SOLUTION ADDED	N
Fig. A-FFAAA Sheet 01	SHEET ADDED	N
Fig. A-FFAAA Sheet 02	SHEET ADDED	N
Fig. A-FFBAA	FIGURE SOLUTION ADDED	N
Fig. A-FFBAA Sheet 01	SHEET ADDED	N
Fig. A-FFBAA Sheet 02	SHEET ADDED	N
Fig. A-FFCAA	FIGURE SOLUTION ADDED	N
Fig. A-FFCAA Sheet 01	SHEET ADDED	N
Fig. A-FFCAA Sheet 02	SHEET ADDED	N
Fig. A-FFDAA	FIGURE SOLUTION ADDED	N
Fig. A-FFDAA Sheet 01	SHEET ADDED	N

Fig. A-FFDAA Sheet 02	SHEET ADDED	N
Fig. A-FFEAA	FIGURE SOLUTION ADDED	N
Fig. A-FFEAA Sheet 01	SHEET ADDED	N
Fig. A-FFEAA Sheet 02	SHEET ADDED	N
Fig. A-FFFAA	FIGURE SOLUTION ADDED	N
Fig. A-FFFAA Sheet 01	SHEET ADDED	N
Fig. A-FFFAA Sheet 02	SHEET ADDED	N
Fig. A-FFGAA	FIGURE SOLUTION ADDED	N
Fig. A-FFGAA Sheet 01	SHEET ADDED	N
Fig. A-FFGAA Sheet 02	SHEET ADDED	N
Fig. A-FFHAA	FIGURE SOLUTION ADDED	N
Fig. A-FFHAA Sheet 01	SHEET ADDED	N
Fig. A-FFHAA Sheet 02	SHEET ADDED	N
Fig. A-FFIAA	FIGURE SOLUTION ADDED	N
Fig. A-FFIAA Sheet 01	SHEET ADDED	N
Fig. A-FFIAA Sheet 02	SHEET ADDED	N
Fig. A-FFJAA	FIGURE SOLUTION ADDED	N
Fig. A-FFJAA Sheet 01	SHEET ADDED	N
Fig. A-FFJAA Sheet 02	SHEET ADDED	N
Fig. A-FFKAA	FIGURE SOLUTION ADDED	N
Fig. A-FFKAA Sheet 01	SHEET ADDED	N
Fig. A-FFKAA Sheet 02	SHEET ADDED	N
Fig. A-FFLAA	FIGURE SOLUTION ADDED	N
Fig. A-FFLAA Sheet 01	SHEET ADDED	N
Fig. A-FFLAA Sheet 02	SHEET ADDED	N
Fig. A-FFMAA	FIGURE SOLUTION ADDED	N
Fig. A-FFMAA Sheet 01	SHEET ADDED	N
Fig. A-FFMAA Sheet 02	SHEET ADDED	N
Fig. A-FFNAA	FIGURE SOLUTION ADDED	N
Fig. A-FFNAA Sheet 01	SHEET ADDED	N
Fig. A-FFNAA Sheet 02	SHEET ADDED	N
Fig. A-FFOAA	FIGURE SOLUTION ADDED	N
Fig. A-FFOAA Sheet 01	SHEET ADDED	N
Fig. A-FFOAA Sheet 02	SHEET ADDED	N
Fig. A-FFPAA	FIGURE SOLUTION ADDED	N
Fig. A-FFPAA Sheet 01	SHEET ADDED	N
Fig. A-FFPAA Sheet 02	SHEET ADDED	N
Fig. A-FFQAA	FIGURE SOLUTION ADDED	N
Fig. A-FFQAA Sheet 01	SHEET ADDED	N
Fig. A-FFQAA Sheet 02	SHEET ADDED	N
Fig. A-FFRAA	FIGURE SOLUTION ADDED	N

Fig. A-FFRAA Sheet 01	SHEET ADDED	N
Fig. A-FFRAA Sheet 02	SHEET ADDED	N
Fig. A-FFSAA	FIGURE SOLUTION ADDED	N
Fig. A-FFSAA Sheet 01	SHEET ADDED	N
Fig. A-FFSAA Sheet 02	SHEET ADDED	N
Fig. A-FFTAA	FIGURE SOLUTION ADDED	N
Fig. A-FFTAA Sheet 01	SHEET ADDED	N
Fig. A-FFTAA Sheet 02	SHEET ADDED	N
Fig. A-FFUAA	FIGURE SOLUTION ADDED	N
Fig. A-FFUAA Sheet 01	SHEET ADDED	N
Fig. A-FFUAA Sheet 02	SHEET ADDED	N
Fig. A-FFVAA	FIGURE SOLUTION ADDED	N
Fig. A-FFVAA Sheet 01	SHEET ADDED	N
Fig. A-FFVAA Sheet 02	SHEET ADDED	N
Fig. A-FFWAA	FIGURE SOLUTION ADDED	N
Fig. A-FFWAA Sheet 01	SHEET ADDED	N
Fig. A-FFWAA Sheet 02	SHEET ADDED	N
Fig. A-FFXAA	FIGURE SOLUTION ADDED	N
Fig. A-FFXAA Sheet 01	SHEET ADDED	N
Fig. A-FFXAA Sheet 02	SHEET ADDED	N
Fig. A-FGAAA	FIGURE SOLUTION ADDED	N
Fig. A-FGAAA Sheet 01	SHEET ADDED	N
Fig. A-FGAAA Sheet 02	SHEET ADDED	N
Appendix 01 - Elapsed Time Assumption		
APPENDIX CONTENT	APPENDIX CONTENT UPDATED	R
Fig. A-FAAAA	FIGURE SOLUTION UPDATED	R
Fig. A-FAAAA Sheet 01	SHEET UPDATED	R
Fig. A-FAAAA Sheet 02	SHEET ADDED	N
Fig. A-FAAAA Sheet 03	SHEET ADDED	N
Fig. A-FAAAA Sheet 04	SHEET ADDED	N
Fig. A-FAAAA Sheet 05	SHEET ADDED	N
Fig. A-FAAAA Sheet 06	SHEET ADDED	N
Fig. A-FAAAA Sheet 07	SHEET ADDED	N
Fig. A-FAAAA Sheet 08	SHEET ADDED	N
Fig. A-FAAAA Sheet 09	SHEET ADDED	N
Fig. A-FAAAA Sheet 10	SHEET ADDED	N
Fig. A-FAAAA Sheet 11	SHEET ADDED	N
Fig. A-FAAAA Sheet 12	SHEET ADDED	N
Fig. A-FAAAA Sheet 13	SHEET ADDED	N
Fig. A-FAAAA Sheet 14	SHEET ADDED	N
Fig. A-FAAAA Sheet 15	SHEET ADDED	N

Fig. A-FAAAA Sheet 16	SHEET ADDED	N
Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot		
APPENDIX CONTENT	APPENDIX CONTENT ADDED	N
Fig. A-FACAA	FIGURE SOLUTION ADDED	N
Fig. A-FACAA Sheet 01	SHEET ADDED	N
Fig. A-FACAA Sheet 02	SHEET ADDED	N
Fig. A-FACAA Sheet 03	SHEET ADDED	N
Appendix 03 - Principle of Bush Machining and Installation in the Frame		
APPENDIX CONTENT	APPENDIX CONTENT ADDED	N
Fig. A-FADAA	FIGURE SOLUTION ADDED	N
Fig. A-FADAA Sheet 01	SHEET ADDED	N
Fig. A-FADAA Sheet 02	SHEET ADDED	N
Fig. A-FADAA Sheet 03	SHEET ADDED	N
Appendix 04 - Table of the Components and Configurations		
APPENDIX CONTENT	APPENDIX CONTENT ADDED	N

FILING INSTRUCTIONS

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

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

HISTORY OF PREVIOUS REVISIONS

No previous revision

REVISION SEQUENCE

ORIGINAL: Mar 17/15

REVISION No. : 01 - Sep 20/19

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

MANDATORY MANDATORY MANDATORY

ATA SYSTEM: 53

**TITLE: FUSELAGE - CENTER SECTION - OVERSIZE UPPER FRAME FEET
SPlicing FROM FR41 TO FR46**

****CONF ALL**

MODIFICATIONS

MODIFICATION CLASSIFICATION					
MAJOR	13743S22884				
MINOR	None				

NOTE: As per EASA IR 21, a minor change is one that has no appreciable effect on the mass, balance, structural strength, reliability, operational characteristics affecting the airworthiness of the product. All other changes are major changes.

REASON/DESCRIPTION/OPERATIONAL CONSEQUENCES

During an inspection in accordance with Airworthiness Limitation Items (ALI) Task 53-15-54 on A300-600 aircraft, Frame 43, Frame 44, Frame 45 and Frame 46 were found cracked between stringers 24 to 30 on the aircraft Right Hand (RH) side and Frame 45 was found cracked on the aircraft Left Hand (LH) side.

Undetected cracks on in-service aircraft can lead to the rupture of the frame foot and subsequent cracking of the adjacent frames and fuselage skin with the potential to require an extensive repair and possible impact on pressure loading strength capacity of the structure.

Service Bulletin No. A300-53-6122 was issued to inspect and Service Bulletin No. A300-53-6125 to modify the most fatigue sensitive fastener holes between Frame 41 and Frame 46 with cold expansion.

Resulting from a Widespread Fatigue Damage (WFD) study, the necessity arose to improve the fatigue life of frame feet splicing POST Modification No. 12168S21823 or POST Service Bulletin No. A300-53-6125 (retrofit solution of Modification No. 12168S21823).

For information, when this SB is not embodied, inspections are required as per ALI Task 53-15-58. Previous inspections from Service Bulletin No. A300-53-6122 are cancelled and superseded by ALI Task 53-15-58.

5 DATE: Mar 17/15

SERVICE BULLETIN No.: A300-53-6178

REVISION No.: 01 - Sep 20/19

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SERVICE BULLETIN SUMMARY

This Service Bulletin No. A300-53-6178 requests oversizing the holes already cold expanded via Service Bulletin No. A300-53-6125 or by serial modification 12168S21823 and installing new fasteners with interference fit to improve the fatigue life of the area in order to reach the targeted Limit of Validity (LoV) for the concerned aircraft, as it is defined in A300-600 Airworthiness Limitation Section (ALS) Part 2.

Accomplishment of this Service Bulletin will contribute reaching the targeted LoV for the concerned aircraft, as it is defined in A300-600 ALS Part 2.

GENERAL EVALUATION

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

NOTE (1): Service Bulletin must be accomplished.

NOTE: This Service Bulletin has been validated at original issue on A300-600 aircraft with Manufacturer Serial Number (MSN) 797.

NOTE: A booklet including photographs taken during the validation of this 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
Component COMPA01	2	See SB	Bolts, Nuts, Washers
Component COMPA03	2	See SB	Bolts, Nuts, Washers
Component COMPA05	2	See SB	Bolts, Nuts, Washers
Component COMPA07	2	See SB	Bolts, Nuts, Washers
Component COMPA09	2	See SB	Bolts, Nuts, Washers
Component COMPA11	2	See SB	Bolts, Nuts, Washers
Component COMPA13	1	See SB	Shim, Bush
Component COMPA14	1	See SB	Shim, Support
Component COMPA15	1	See SB	Shim, Support

****CONF 002**

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	QTY PER A/C	PRICE PER A/C (USD)	MAIN PARTS
Component COMPA02	2	See SB	Bolts, Nuts, Washers
Component COMPA04	2	See SB	Bolts, Nuts, Washers
Component COMPA06	2	See SB	Bolts, Nuts, Washers
Component COMPA08	2	See SB	Bolts, Nuts, Washers
Component COMPA10	2	See SB	Bolts, Nuts, Washers
Component COMPA12	2	See SB	Bolts, Nuts, Washers
Component COMPA13	1	See SB	Shim, Bush
Component COMPA14	1	See SB	Shim, Support
Component COMPA15	1	See SB	Shim, Support

****CONF 003**

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	QTY PER A/C	PRICE PER A/C (USD)	MAIN PARTS
Component COMPA01	2	See SB	Bolts, Nuts, Washers
Component COMPA03	2	See SB	Bolts, Nuts, Washers
Component COMPA05	2	See SB	Bolts, Nuts, Washers
Component COMPA07	2	See SB	Bolts, Nuts, Washers
Component COMPA09	2	See SB	Bolts, Nuts, Washers
Component COMPA11	2	See SB	Bolts, Nuts, Washers
Component COMPA13	1	See SB	Shim, Bush
Component COMPA14	1	See SB	Shim, Support
Component COMPA15	1	See SB	Shim, Support
Component COMPA17	1	See SB	Adhesive Tape

****CONF 004**

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	QTY PER A/C	PRICE PER A/C (USD)	MAIN PARTS
Component COMPA02	2	See SB	Bolts, Nuts, Washers
Component COMPA04	2	See SB	Bolts, Nuts, Washers
Component COMPA06	2	See SB	Bolts, Nuts, Washers
Component COMPA08	2	See SB	Bolts, Nuts, Washers
Component COMPA10	2	See SB	Bolts, Nuts, Washers
Component COMPA12	2	See SB	Bolts, Nuts, Washers
Component COMPA13	1	See SB	Shim, Bush

SERVICE BULLETIN SUMMARY

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	QTY PER A/C	PRICE PER A/C (USD)	MAIN PARTS
Component COMPA14	1	See SB	Shim, Support
Component COMPA15	1	See SB	Shim, Support
Component COMPA17	1	See SB	Adhesive Tape

****CONF 005**

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	QTY PER A/C	PRICE PER A/C (USD)	MAIN PARTS
Component COMPA02	2	See SB	Bolts, Nuts, Washers
Component COMPA04	2	See SB	Bolts, Nuts, Washers
Component COMPA06	2	See SB	Bolts, Nuts, Washers
Component COMPA10	2	See SB	Bolts, Nuts, Washers
Component COMPA12	2	See SB	Bolts, Nuts, Washers
Component COMPA13	1	See SB	Shim, Bush
Component COMPA14	1	See SB	Shim, Support
Component COMPA15	1	See SB	Shim, Support
Component COMPA16	2	See SB	Bolts, Nuts, Washers

EFFECTIVITY

****CONF ALL**

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

14S AAW ABR AHK BCS FDX IRA IRM KAC MNB MRJ MSR QSM
 SOP SUD TAR TNO UPS URS UTP

CONCURRENT REQUIREMENTS

None

REFERENCES / REPERCUSSIONS

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

NATURE OF THE WORK

AIRCRAFT	YES
EQUIPMENT	NO
HARD	NO
SOFT	NO
OBRM	NO

MANPOWER

**CONF 001

Task 536178-831-801-001: Modification	
TOTAL MANHOURS	151.00
ELAPSED TIME (HOURS)	29.00

Task 536178-839-801-001: Inspection - ADDITIONAL WORK	
TOTAL MANHOURS	0.15
ELAPSED TIME (HOURS)	0.15

**CONF 002

Task 536178-831-801-001: Modification	
TOTAL MANHOURS	151.00
ELAPSED TIME (HOURS)	29.00

Task 536178-839-801-001: Inspection - ADDITIONAL WORK	
TOTAL MANHOURS	0.15
ELAPSED TIME (HOURS)	0.15

**CONF 003

Task 536178-831-801-001: Modification	
TOTAL MANHOURS	151.00
ELAPSED TIME (HOURS)	29.00

Task 536178-839-801-001: Inspection - ADDITIONAL WORK	
TOTAL MANHOURS	0.15
ELAPSED TIME (HOURS)	0.15

**CONF 004

Task 536178-831-801-001: Modification	
TOTAL MANHOURS	151.00
ELAPSED TIME (HOURS)	29.00

Task 536178-839-801-001: Inspection - ADDITIONAL WORK	
TOTAL MANHOURS	0.15
ELAPSED TIME (HOURS)	0.15

****CONF 005**

Task 536178-831-801-001: Modification	
TOTAL MANHOURS	151.00
ELAPSED TIME (HOURS)	29.00

Task 536178-839-801-001: Inspection - ADDITIONAL WORK	
TOTAL MANHOURS	0.15
ELAPSED TIME (HOURS)	0.15

APPENDICES

****CONF ALL**

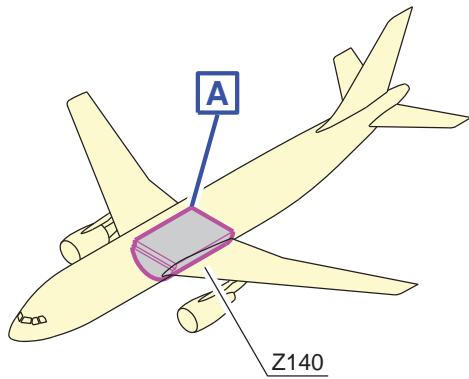
Appendix 01 - Elapsed Time Assumption

Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

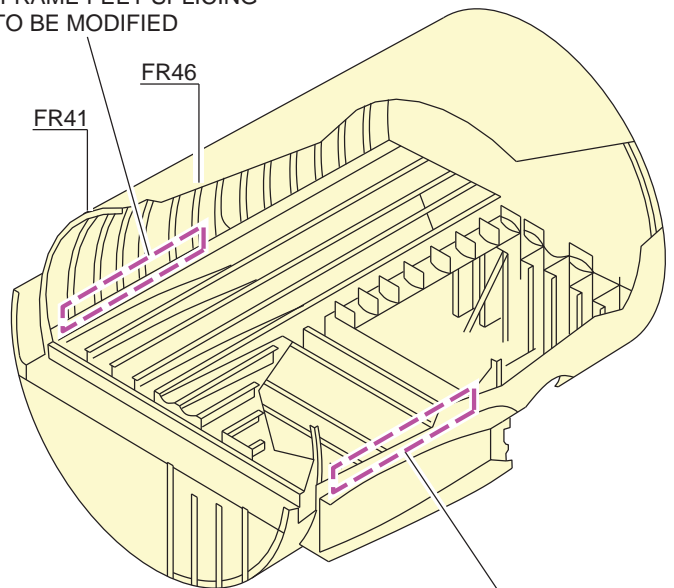
Appendix 03 - Principle of Bush Machining and Installation in the Frame

Appendix 04 - Table of the Components and Configurations

****CONF ALL**



UPPER FRAME FEET SPLICING
TO BE MODIFIED



D_SB_536178_5_SAAA_01_01

Figure A-FSAAA - Sheet 01

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MANDATORY MANDATORY MANDATORY

ATA SYSTEM: 53

**TITLE: FUSELAGE - CENTER SECTION - OVERSIZE UPPER FRAME FEET
SPLICING FROM FR41 TO FR46**

MODIFICATION No.: 13743S22884

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1. PLANNING INFORMATION

****CONF ALL**

A. EFFECTIVITY

NOTE: This modification is applicable by Service Bulletin only.

NOTE: This Service Bulletin is only applicable to aircraft on which Mod. No. 12168S21823 or Service Bulletin No. A300-53-6125 is embodied.

(1) Models

B4-603 B4-605R B4-622 B4-622R C4-605R/FC4-620 F4-605R F4-622R

(2) Effectivity by MSN

0344 0358 0361 0365 0380 0388 0401 0405 0408 0411 0414 0417 0477 0479 0505
0518 0521 0525 0530 0532 0536 0543 0546 0553 0555 0557-0559 0561 0563 0572
0575 0579 0581 0584 0602-0603 0607-0608 0611 0613 0617-0618 0621 0623
0625-0626 0630 0632-0633 0637 0641 0643 0657 0659 0664 0666 0668 0670 0677
0679 0683 0688 0694 0696 0699 0701 0703 0707 0709 0711 0713 0715 0717 0719
0721-0730 0732-0746 0748-0750 0752-0764 0766 0768-0775 0777-0794 0797
0799-0840 0845-0878

5 DATE: Mar 17/15

SERVICE BULLETIN No.: A300-53-6178

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(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
14S	0694 0699 0719 0721 0782 0784 0785 0786 0787
AAW	0788
ABR	0557 0677 0717 0722
AHK	0683 0770 0855 0856 0857 0858 0859 0860 0870 0871
BCS	0602 0617 0621 0637 0641 0670 0679 0703 0711 0724 0729 0730 0737 0740 0743 0753 0783 0797 0836 0837 0872
FDX	0358 0361 0365 0388 0417 0477 0479 0530 0536 0543 0555 0559 0572 0575 0579 0581 0611 0613 0625 0630 0633 0657 0659 0664 0668 0688 0709 0713 0715 0726 0728 0735 0736 0738 0742 0745 0748 0752 0757 0759 0760 0761 0766 0768 0769 0771 0772 0774 0777 0778 0779 0780 0781 0789 0790 0791 0792 0793 0794 0799 0800 0801 0802 0803 0804 0873 0874 0875 0876 0877 0878
IRA	0632 0696 0723 0727
IRM	0380 0401 0405 0408 0411 0414 0518 0546 0553 0608 0618 0623 0701 0773 0838
KAC	0344
MNB	0521 0525 0734 0739 0758
MRJ	0750 0762
MSR	0561 0607
QSM	0584 0603 0744 0749 0764
SOP	0532 0756
SUD	0666 0775
TAR	0505 0558 0563
TNO	0626 0643 0755
UPS	0805 0806 0807 0808 0809 0810 0811 0812 0813 0814 0815 0816 0817 0818 0819 0820 0821 0822 0823 0824 0825 0826 0827 0828 0829 0830 0831 0832 0833 0834 0835 0839 0840 0845 0846 0847 0848 0849 0850 0851 0852 0853 0854 0861 0862 0863 0864 0865 0866 0867 0868 0869
URS	0733
UTP	0707 0725 0732 0741 0746 0754 0763

(4) Configuration by MSN

MSN	CONFIGURATION
0344 0505 0518 0558 0563 0584 0603 0608 0632 0666 0694 0696 0699 0701 0707 0719 0721 0723 0725 0727 0741 0744 0749 0750 0762 0764 0773 0775 0782 0784 0785 0786 0787	002

MSN	CONFIGURATION
0358 0361 0365 0388 0417 0477 0479 0521 0525 0530 0532 0536 0543 0555 0557 0559 0561 0572 0575 0579 0581 0602 0607 0611 0613 0617 0621 0625 0626 0630 0633 0637 0641 0643 0657 0659 0664 0668 0670 0677 0679 0683 0688 0703 0709 0711 0713 0715 0717 0722 0724 0726 0728 0729 0730 0732 0733 0734 0735 0736 0737 0738 0739 0740 0742 0743 0745 0746 0748 0752 0753 0754 0755 0756 0757 0758 0759 0760 0761 0763 0766 0768 0769 0770 0771 0772 0774 0777 0778 0779 0780 0781 0783 0788 0789 0790 0791 0792 0793 0794 0797 0799 0800 0801 0802 0803 0804	004
0380 0401 0405 0408 0411 0414 0546 0553 0618 0623	005
0805 0806 0807 0808 0809 0810 0811 0812 0813 0814 0815 0816 0817 0818 0819 0820 0821 0822 0823 0824 0825 0826 0827 0828 0829 0830 0831 0832 0833 0834 0835 0836 0837 0839 0840 0845 0846 0847 0848 0849 0850 0851 0852 0853 0854 0855 0856 0857 0858 0859 0860 0861 0862 0863 0864 0865 0866 0867 0868 0869 0870 0871 0872 0873 0874 0875 0876 0877 0878	003
0838	001

(5) Configuration definition

****CONF 001**

Config. 001 is valid for PAX aircraft on which Modification No. 12168S21823 is embodied on production line and on which Modification No. 06289D5353 , Modification No. 06289D5454 and Modification No. 06289D5676 are not embodied.

****CONF 002**

Config. 002 is valid for PAX aircraft on which Service Bulletin No. A300-53-6125 is accomplished and on which Modification No. 06289D5353 , Modification No. 06289D5454 and Modification No. 06289D5676 are not embodied.

****CONF 003**

Config. 003 is valid for freighter aircraft on which Modification No. 12168S21823 is embodied on production line.

****CONF 004**

Config. 004 is valid for freighter aircraft on which Service Bulletin No. A300-53-6125 is accomplished.

****CONF 005**

Config. 005 is valid for PAX aircraft on which Service Bulletin No. A300-53-6125 is accomplished and on which Modification No. 06289D5353 , Modification No. 06289D5454 and Modification No. 06289D5676 are embodied.

(6) Material Effectivity

****CONF 001**

MATERIAL	QTY PER A/C	SEE NOTES
Component COMPA01	2	(1)

MATERIAL	QTY PER A/C	SEE NOTES
Component COMPA03	2	(1)
Component COMPA05	2	(1)
Component COMPA07	2	(1)
Component COMPA09	2	(1)
Component COMPA11	2	(1)
Component COMPA13	1	(1)
Component COMPA14	1	(1)
Component COMPA15	1	(1)
Consumable CMLA01	1	

NOTE (1): For the applicable components per aircraft frames versus the configurations, refer to the tables given in Appendix 04.

**CONF 003

MATERIAL	QTY PER A/C	SEE NOTES
Component COMPA01	2	(1)
Component COMPA03	2	(1)
Component COMPA05	2	(1)
Component COMPA07	2	(1)
Component COMPA09	2	(1)
Component COMPA11	2	(1)
Component COMPA13	1	(1)
Component COMPA14	1	(1)
Component COMPA15	1	(1)
Consumable CMLA01	1	
Component COMPA17	1	

NOTE (1): For the applicable components per aircraft frames versus the configurations, refer to the tables given in Appendix 04.

**CONF 002

MATERIAL	QTY PER A/C	SEE NOTES
Component COMPA02	2	(1)
Component COMPA04	2	(1)
Component COMPA06	2	(1)
Component COMPA08	2	(1)
Component COMPA10	2	(1)
Component COMPA12	2	(1)
Component COMPA13	1	(1)
Component COMPA14	1	(1)
Component COMPA15	1	(1)
Consumable CMLA01	1	

NOTE (1): For the applicable components per aircraft frames versus the configurations, refer to the tables given in Appendix 04.

**CONF 004

MATERIAL	QTY PER A/C	SEE NOTES
Component COMPA02	2	(1)
Component COMPA04	2	(1)
Component COMPA06	2	(1)
Component COMPA08	2	(1)
Component COMPA10	2	(1)
Component COMPA12	2	(1)
Component COMPA13	1	(1)
Component COMPA14	1	(1)
Component COMPA15	1	(1)
Consumable CMLA01	1	
Component COMPA17	1	

NOTE (1): For the applicable components per aircraft frames versus the configurations, refer to the tables given in Appendix 04.

**CONF 005

MATERIAL	QTY PER A/C	SEE NOTES
Component COMPA02	2	(1)
Component COMPA04	2	(1)
Component COMPA06	2	(1)
Component COMPA10	2	(1)
Component COMPA12	2	(1)
Component COMPA13	1	(1)
Component COMPA14	1	(1)
Component COMPA15	1	(1)
Component COMPA16	2	(1)
Consumable CMLA01	1	

NOTE (1): For the applicable components per aircraft frames versus the configurations, refer to the tables given in Appendix 04.

**CONF ALL

B. CONCURRENT REQUIREMENTS

None

C. REASON

(1) History

During an inspection in accordance with Airworthiness Limitation Items (ALI) Task 53-15-54 on A300-600 aircraft, Frame 43, Frame 44, Frame 45 and Frame 46 were found cracked between stringers 24 to 30 on the aircraft Right Hand (RH) side and Frame 45 was found cracked on the aircraft Left Hand (LH) side.

Undetected cracks on in-service aircraft can lead to the rupture of the frame foot and subsequent cracking of the adjacent frames and fuselage skin with the potential to require an extensive repair and possible impact on pressure loading strength capacity of the structure.

Service Bulletin No. A300-53-6122 was issued to inspect and Service Bulletin No. A300-53-6125 to modify the most fatigue sensitive fastener holes between Frame 41 and Frame 46 with cold expansion.

Resulting from a Widespread Fatigue Damage (WFD) study, the necessity arose to improve the fatigue life of frame feet splicing POST Modification No. 12168S21823 or POST Service Bulletin No. A300-53-6125 (retrofit solution of Modification No. 12168S21823).

For information, when this SB is not embodied, inspections are required as per ALI Task 53-15-58. Previous inspections from Service Bulletin No. A300-53-6122 are cancelled and superseded by ALI Task 53-15-58.

(2) Objective/Action

This Service Bulletin No. A300-53-6178 requests oversizing the holes already cold expanded via Service Bulletin No. A300-53-6125 or by serial modification 12168S21823 and installing new fasteners with interference fit to improve the fatigue life of the area in order to reach the targeted Limit of Validity (LoV) for the concerned aircraft, as it is defined in A300-600 Airworthiness Limitation Section (ALS) Part 2.

(3) Advantages

Accomplishment of this Service Bulletin will contribute reaching the targeted LoV for the concerned aircraft, as it is defined in A300-600 ALS Part 2.

(4) Operational/Maintenance Consequences

None

D. DESCRIPTION

To accomplish this Service Bulletin it is necessary to :

****CONF 001**

Task 536178-831-801-001: Modification

(1) Remove the Fastener from Hole H1 of Frame 41, LH Side

- █ (2) Remove the Fastener from Hole H1 of Frame 42, LH Side
- █ (3) Remove the Fastener from Hole H1 of Frame 43, LH Side
- █ (4) Remove the Fastener from Hole H1 of Frame 44, LH Side
- █ (5) Remove the Fastener from Hole H1 of Frame 45, LH Side
- █ (6) Remove the Fastener from Hole H1 of Frame 46, LH Side
- █ (7) Remove the Fasteners from Holes H2 to H7 of Frame 41, LH Side
- █ (8) Remove the Fasteners from Holes H2 to H7 of Frame 42, LH Side
- █ (9) Remove the Fasteners from Holes H2 to H8 of Frame 43, LH Side
- █ (10) Remove the Fasteners from Holes H2 to H8 of Frame 44, LH Side
- █ (11) Remove the Fasteners from Holes H2 to H7 of Frame 45, LH Side
- █ (12) Remove the Fasteners from Holes H2 to H7 of Frame 46, LH Side
- █ (13) Remove the Fasteners from Holes H8 and H9 of Frame 41, LH Side
- █ (14) Remove the Fasteners from Holes H8 and H9 of Frame 42, LH Side
- █ (15) Remove the Fasteners from Holes H9 and H10 of Frame 43, LH Side
- █ (16) Remove the Fasteners from Holes H9 and H10 of Frame 44, LH Side
- █ (17) Remove the Fasteners from Holes H8 and H9 of Frame 45, LH Side
- █ (18) Remove the Fasteners from Holes H8 and H9 of Frame 46, LH Side
- █ (19) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, LH Side
- █ (20) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, LH Side
- █ (21) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, LH Side
- █ (22) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, LH Side
- █ (23) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, LH Side
- █ (24) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, LH Side
- █ (25) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, LH Side
- █ (26) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, LH Side
- █ (27) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, LH Side

- (28) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, LH Side
- (29) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, LH Side
- (30) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, LH Side
- (31) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, LH Side
- (32) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, LH Side
- (33) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, LH Side
- (34) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, LH Side
- (35) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, LH Side
- (36) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, LH Side
- (37) Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side
- (38) Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side
- (39) Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side
- (40) Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side
- (41) Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side
- (42) Depending on the Inspection Result, Ream Hole H1 of Frame 46, LH Side
- (43) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side
- (44) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side
- (45) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side
- (46) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side
- (47) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side
- (48) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side
- (49) Install the Fastener on the Hole H1 of Frame 41, LH Side
- (50) Install the Fastener on the Hole H1 of Frame 42, LH Side

- █ (51) Install the Fastener on the Hole H1 of Frame 43, LH Side
- █ (52) Install the Fastener on the Hole H1 of Frame 44, LH Side
- █ (53) Install the Fastener on the Hole H1 of Frame 45, LH Side
- █ (54) Install the Fastener on the Hole H1 of Frame 46, LH Side
- █ (55) Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side
- █ (56) Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side
- █ (57) Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side
- █ (58) Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side
- █ (59) Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side
- █ (60) Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side
- █ (61) Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side
- █ (62) Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side
- █ (63) Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side
- █ (64) Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side
- █ (65) Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side
- █ (66) Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side
- █ (67) Apply Protective Treatment to the Work Area at Frame 41, LH Side
- █ (68) Apply Protective Treatment to the Work Area at Frame 42, LH Side
- █ (69) Apply Protective Treatment to the Work Area at Frame 43, LH Side
- █ (70) Apply Protective Treatment to the Work Area at Frame 44, LH Side
- █ (71) Apply Protective Treatment to the Work Area at Frame 45, LH Side
- █ (72) Apply Protective Treatment to the Work Area at Frame 46, LH Side
- █ (73) Remove the Fastener from Hole H1 of Frame 41, RH Side
- █ (74) Remove the Fastener from Hole H1 of Frame 42, RH Side
- █ (75) Remove the Fastener from Hole H1 of Frame 43, RH Side
- █ (76) Remove the Fastener from Hole H1 of Frame 44, RH Side
- █ (77) Remove the Fastener from Hole H1 of Frame 45, RH Side

- █ (78) Remove the Fastener from Hole H1 of Frame 46, RH Side
- █ (79) Remove the Fasteners from Holes H2 to H7 of Frame 41, RH Side
- █ (80) Remove the Fasteners from Holes H2 to H7 of Frame 42, RH Side
- █ (81) Remove the Fasteners from Holes H2 to H8 of Frame 43, RH Side
- █ (82) Remove the Fasteners from Holes H2 to H8 of Frame 44, RH Side
- █ (83) Remove the Fasteners from Holes H2 to H7 of Frame 45, RH Side
- █ (84) Remove the Fasteners from Holes H2 to H7 of Frame 46, RH Side
- █ (85) Remove the Fasteners from Holes H8 and H9 of Frame 41, RH Side
- █ (86) Remove the Fasteners from Holes H8 and H9 of Frame 42, RH Side
- █ (87) Remove the Fasteners from Holes H9 and H10 of Frame 43, RH Side
- █ (88) Remove the Fasteners from Holes H9 and H10 of Frame 44, RH Side
- █ (89) Remove the Fasteners from Holes H8 and H9 of Frame 45, RH Side
- █ (90) Remove the Fasteners from Holes H8 and H9 of Frame 46, RH Side
- █ (91) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, RH Side
- █ (92) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, RH Side
- █ (93) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, RH Side
- █ (94) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, RH Side
- █ (95) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, RH Side
- █ (96) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, RH Side
- █ (97) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, RH Side
- █ (98) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, RH Side
- █ (99) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, RH Side
- █ (100) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, RH Side
- █ (101) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, RH Side
- █ (102) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, RH Side

Side

(103) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, RH Side

(104) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, RH Side

(105) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, RH Side

(106) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, RH Side

(107) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, RH Side

(108) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, RH Side

(109) Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side

(110) Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side

(111) Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side

(112) Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side

(113) Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side

(114) Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side

(115) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side

(116) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side

(117) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side

(118) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side

(119) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side

(120) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side

(121) Install the Fastener on the Hole H1 of Frame 41, RH Side

(122) Install the Fastener on the Hole H1 of Frame 42, RH Side

(123) Install the Fastener on the Hole H1 of Frame 43, RH Side

(124) Install the Fastener on the Hole H1 of Frame 44, RH Side

(125) Install the Fastener on the Hole H1 of Frame 45, RH Side

- █ (126) Install the Fastener on the Hole H1 of Frame 46, RH Side
- █ (127) Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side
- █ (128) Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side
- █ (129) Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side
- █ (130) Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side
- █ (131) Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side
- █ (132) Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side
- █ (133) Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side
- █ (134) Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side
- █ (135) Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side
- █ (136) Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side
- █ (137) Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side
- █ (138) Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side
- █ (139) Apply Protective Treatment to the Work Area at Frame 41, RH Side
- █ (140) Apply Protective Treatment to the Work Area at Frame 42, RH Side
- █ (141) Apply Protective Treatment to the Work Area at Frame 43, RH Side
- █ (142) Apply Protective Treatment to the Work Area at Frame 44, RH Side
- █ (143) Apply Protective Treatment to the Work Area at Frame 45, RH Side
- █ (144) Apply Protective Treatment to the Work Area at Frame 46, RH Side

Task 536178-839-801-001: Inspection - ADDITIONAL WORK

- █ (1) Do a Check of the Rotating Probe Inspection on Frame 41 to Frame 46

****CONF 002**

Task 536178-831-801-001: Modification

- █ (1) Remove the Fastener from Hole H1 of Frame 41, LH Side
- █ (2) Remove the Fastener from Hole H1 of Frame 42, LH Side
- █ (3) Remove the Fastener from Hole H1 of Frame 43, LH Side
- █ (4) Remove the Fastener from Hole H1 of Frame 44, LH Side

- █ (5) Remove the Fastener from Hole H1 of Frame 45, LH Side
- █ (6) Remove the Fastener from Hole H1 of Frame 46, LH Side
- █ (7) Remove the Fasteners from Holes H2 to H7 of Frame 41, LH Side
- █ (8) Remove the Fasteners from Holes H2 to H7 of Frame 42, LH Side
- █ (9) Remove the Fasteners from Holes H2 to H8 of Frame 43, LH Side
- █ (10) Remove the Fasteners from Holes H2 to H8 of Frame 44, LH Side
- █ (11) Remove the Fasteners from Holes H2 to H7 of Frame 45, LH Side
- █ (12) Remove the Fasteners from Holes H2 to H7 of Frame 46, LH Side
- █ (13) Remove the Fasteners from Holes H8 and H9 of Frame 41, LH Side
- █ (14) Remove the Fasteners from Holes H8 and H9 of Frame 42, LH Side
- █ (15) Remove the Fasteners from Holes H9 and H10 of Frame 43, LH Side
- █ (16) Remove the Fasteners from Holes H9 and H10 of Frame 44, LH Side
- █ (17) Remove the Fasteners from Holes H8 and H9 of Frame 45, LH Side
- █ (18) Remove the Fasteners from Holes H8 and H9 of Frame 46, LH Side
- █ (19) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, LH Side
- █ (20) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, LH Side
- █ (21) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, LH Side
- █ (22) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, LH Side
- █ (23) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, LH Side
- █ (24) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, LH Side
- █ (25) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, LH Side
- █ (26) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, LH Side
- █ (27) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, LH Side
- █ (28) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, LH Side
- █ (29) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, LH Side

- (30) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, LH Side
- (31) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, LH Side
- (32) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, LH Side
- (33) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, LH Side
- (34) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, LH Side
- (35) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, LH Side
- (36) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, LH Side
- (37) Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side
- (38) Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side
- (39) Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side
- (40) Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side
- (41) Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side
- (42) Depending on the Inspection Result, Ream Hole H1 of Frame 46, LH Side
- (43) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side
- (44) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side
- (45) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side
- (46) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side
- (47) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side
- (48) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side
- (49) Install the Fastener on the Hole H1 of Frame 41, LH Side
- (50) Install the Fastener on the Hole H1 of Frame 42, LH Side
- (51) Install the Fastener on the Hole H1 of Frame 43, LH Side
- (52) Install the Fastener on the Hole H1 of Frame 44, LH Side
- (53) Install the Fastener on the Hole H1 of Frame 45, LH Side

- █ (54) Install the Fastener on the Hole H1 of Frame 46, LH Side
- █ (55) Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side
- █ (56) Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side
- █ (57) Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side
- █ (58) Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side
- █ (59) Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side
- █ (60) Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side
- █ (61) Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side
- █ (62) Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side
- █ (63) Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side
- █ (64) Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side
- █ (65) Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side
- █ (66) Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side
- █ (67) Apply Protective Treatment to the Work Area at Frame 41, LH Side
- █ (68) Apply Protective Treatment to the Work Area at Frame 42, LH Side
- █ (69) Apply Protective Treatment to the Work Area at Frame 43, LH Side
- █ (70) Apply Protective Treatment to the Work Area at Frame 44, LH Side
- █ (71) Apply Protective Treatment to the Work Area at Frame 45, LH Side
- █ (72) Apply Protective Treatment to the Work Area at Frame 46, LH Side
- █ (73) Remove the Fastener from Hole H1 of Frame 41, RH Side
- █ (74) Remove the Fastener from Hole H1 of Frame 42, RH Side
- █ (75) Remove the Fastener from Hole H1 of Frame 43, RH Side
- █ (76) Remove the Fastener from Hole H1 of Frame 44, RH Side
- █ (77) Remove the Fastener from Hole H1 of Frame 45, RH Side
- █ (78) Remove the Fastener from Hole H1 of Frame 46, RH Side
- █ (79) Remove the Fasteners from Holes H2 to H7 of Frame 41, RH Side
- █ (80) Remove the Fasteners from Holes H2 to H7 of Frame 42, RH Side

- █ (81) Remove the Fasteners from Holes H2 to H8 of Frame 43, RH Side
- █ (82) Remove the Fasteners from Holes H2 to H8 of Frame 44, RH Side
- █ (83) Remove the Fasteners from Holes H2 to H7 of Frame 45, RH Side
- █ (84) Remove the Fasteners from Holes H2 to H7 of Frame 46, RH Side
- █ (85) Remove the Fasteners from Holes H8 and H9 of Frame 41, RH Side
- █ (86) Remove the Fasteners from Holes H8 and H9 of Frame 42, RH Side
- █ (87) Remove the Fasteners from Holes H9 and H10 of Frame 43, RH Side
- █ (88) Remove the Fasteners from Holes H9 and H10 of Frame 44, RH Side
- █ (89) Remove the Fasteners from Holes H8 and H9 of Frame 45, RH Side
- █ (90) Remove the Fasteners from Holes H8 and H9 of Frame 46, RH Side
- █ (91) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, RH Side
- █ (92) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, RH Side
- █ (93) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, RH Side
- █ (94) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, RH Side
- █ (95) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, RH Side
- █ (96) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, RH Side
- █ (97) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, RH Side
- █ (98) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, RH Side
- █ (99) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, RH Side
- █ (100) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, RH Side
- █ (101) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, RH Side
- █ (102) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, RH Side
- █ (103) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, RH Side
- █ (104) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42,

RH Side

(105) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, RH Side

(106) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, RH Side

(107) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, RH Side

(108) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, RH Side

(109) Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side

(110) Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side

(111) Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side

(112) Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side

(113) Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side

(114) Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side

(115) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side

(116) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side

(117) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side

(118) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side

(119) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side

(120) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side

(121) Install the Fastener on the Hole H1 of Frame 41, RH Side

(122) Install the Fastener on the Hole H1 of Frame 42, RH Side

(123) Install the Fastener on the Hole H1 of Frame 43, RH Side

(124) Install the Fastener on the Hole H1 of Frame 44, RH Side

(125) Install the Fastener on the Hole H1 of Frame 45, RH Side

(126) Install the Fastener on the Hole H1 of Frame 46, RH Side

(127) Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side

(128) Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side

- █ (129) Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side
- █ (130) Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side
- █ (131) Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side
- █ (132) Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side
- █ (133) Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side
- █ (134) Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side
- █ (135) Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side
- █ (136) Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side
- █ (137) Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side
- █ (138) Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side
- █ (139) Apply Protective Treatment to the Work Area at Frame 41, RH Side
- █ (140) Apply Protective Treatment to the Work Area at Frame 42, RH Side
- █ (141) Apply Protective Treatment to the Work Area at Frame 43, RH Side
- █ (142) Apply Protective Treatment to the Work Area at Frame 44, RH Side
- █ (143) Apply Protective Treatment to the Work Area at Frame 45, RH Side
- █ (144) Apply Protective Treatment to the Work Area at Frame 46, RH Side

Task 536178-839-801-001: Inspection - ADDITIONAL WORK

- █ (1) Do a Check of the Rotating Probe Inspection on Frame 41 to Frame 46

****CONF 003**

Task 536178-831-801-001: Modification

- █ (1) Remove the Fastener from Hole H1 of Frame 41, LH Side
- █ (2) Remove the Fastener from Hole H1 of Frame 42, LH Side
- █ (3) Remove the Fastener from Hole H1 of Frame 43, LH Side
- █ (4) Remove the Fastener from Hole H1 of Frame 44, LH Side
- █ (5) Remove the Fastener from Hole H1 of Frame 45, LH Side
- █ (6) Remove the Fastener from Hole H1 of Frame 46, LH Side
- █ (7) Remove the Fasteners from Holes H2 to H7 of Frame 41, LH Side

- █ (8) Remove the Fasteners from Holes H2 to H7 of Frame 42, LH Side
- █ (9) Remove the Fasteners from Holes H2 to H8 of Frame 43, LH Side
- █ (10) Remove the Fasteners from Holes H2 to H8 of Frame 44, LH Side
- █ (11) Remove the Fasteners from Holes H2 to H7 of Frame 45, LH Side
- █ (12) Remove the Fasteners from Holes H2 to H7 of Frame 46, LH Side
- █ (13) Remove the Fasteners from Holes H8 and H9 of Frame 41, LH Side
- █ (14) Remove the Fasteners from Holes H8 and H9 of Frame 42, LH Side
- █ (15) Remove the Fasteners from Holes H9 and H10 of Frame 43, LH Side
- █ (16) Remove the Fasteners from Holes H9 and H10 of Frame 44, LH Side
- █ (17) Remove the Fasteners from Holes H8 and H9 of Frame 45, LH Side
- █ (18) Remove the Fasteners from Holes H8 and H9 of Frame 46, LH Side
- █ (19) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, LH Side
- █ (20) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, LH Side
- █ (21) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, LH Side
- █ (22) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, LH Side
- █ (23) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, LH Side
- █ (24) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, LH Side
- █ (25) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, LH Side
- █ (26) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, LH Side
- █ (27) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, LH Side
- █ (28) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, LH Side
- █ (29) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, LH Side
- █ (30) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, LH Side
- █ (31) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, LH Side

- (32) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, LH Side
- (33) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, LH Side
- (34) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, LH Side
- (35) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, LH Side
- (36) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, LH Side
- (37) Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side
- (38) Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side
- (39) Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side
- (40) Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side
- (41) Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side
- (42) Depending on the Inspection Result, Ream Hole H1 of Frame 46, LH Side
- (43) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side
- (44) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side
- (45) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side
- (46) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side
- (47) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side
- (48) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side
- (49) Install the Fastener on the Hole H1 of Frame 41, LH Side
- (50) Install the Fastener on the Hole H1 of Frame 42, LH Side
- (51) Install the Fastener on the Hole H1 of Frame 43, LH Side
- (52) Install the Fastener on the Hole H1 of Frame 44, LH Side
- (53) Install the Fastener on the Hole H1 of Frame 45, LH Side
- (54) Install the Fastener on the Hole H1 of Frame 46, LH Side
- (55) Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side
- (56) Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side

- █ (57) Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side
- █ (58) Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side
- █ (59) Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side
- █ (60) Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side
- █ (61) Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side
- █ (62) Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side
- █ (63) Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side
- █ (64) Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side
- █ (65) Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side
- █ (66) Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side
- █ (67) Apply Protective Treatment to the Work Area at Frame 41, LH Side
- █ (68) Apply Protective Treatment to the Work Area at Frame 42, LH Side
- █ (69) Apply Protective Treatment to the Work Area at Frame 43, LH Side
- █ (70) Apply Protective Treatment to the Work Area at Frame 44, LH Side
- █ (71) Apply Protective Treatment to the Work Area at Frame 45, LH Side
- █ (72) Apply Protective Treatment to the Work Area at Frame 46, LH Side
- █ (73) Remove the Fastener from Hole H1 of Frame 41, RH Side
- █ (74) Remove the Fastener from Hole H1 of Frame 42, RH Side
- █ (75) Remove the Fastener from Hole H1 of Frame 43, RH Side
- █ (76) Remove the Fastener from Hole H1 of Frame 44, RH Side
- █ (77) Remove the Fastener from Hole H1 of Frame 45, RH Side
- █ (78) Remove the Fastener from Hole H1 of Frame 46, RH Side
- █ (79) Remove the Fasteners from Holes H2 to H7 of Frame 41, RH Side
- █ (80) Remove the Fasteners from Holes H2 to H7 of Frame 42, RH Side
- █ (81) Remove the Fasteners from Holes H2 to H8 of Frame 43, RH Side
- █ (82) Remove the Fasteners from Holes H2 to H8 of Frame 44, RH Side
- █ (83) Remove the Fasteners from Holes H2 to H7 of Frame 45, RH Side

- (84) Remove the Fasteners from Holes H2 to H7 of Frame 46, RH Side
- (85) Remove the Fasteners from Holes H8 and H9 of Frame 41, RH Side
- (86) Remove the Fasteners from Holes H8 and H9 of Frame 42, RH Side
- (87) Remove the Fasteners from Holes H9 and H10 of Frame 43, RH Side
- (88) Remove the Fasteners from Holes H9 and H10 of Frame 44, RH Side
- (89) Remove the Fasteners from Holes H8 and H9 of Frame 45, RH Side
- (90) Remove the Fasteners from Holes H8 and H9 of Frame 46, RH Side
- (91) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, RH Side
- (92) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, RH Side
- (93) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, RH Side
- (94) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, RH Side
- (95) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, RH Side
- (96) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, RH Side
- (97) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, RH Side
- (98) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, RH Side
- (99) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, RH Side
- (100) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, RH Side
- (101) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, RH Side
- (102) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, RH Side
- (103) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, RH Side
- (104) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, RH Side
- (105) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, RH Side
- (106) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44,

RH Side

(107) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, RH Side

(108) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, RH Side

(109) Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side

(110) Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side

(111) Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side

(112) Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side

(113) Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side

(114) Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side

(115) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side

(116) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side

(117) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side

(118) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side

(119) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side

(120) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side

(121) Install the Fastener on the Hole H1 of Frame 41, RH Side

(122) Install the Fastener on the Hole H1 of Frame 42, RH Side

(123) Install the Fastener on the Hole H1 of Frame 43, RH Side

(124) Install the Fastener on the Hole H1 of Frame 44, RH Side

(125) Install the Fastener on the Hole H1 of Frame 45, RH Side

(126) Install the Fastener on the Hole H1 of Frame 46, RH Side

(127) Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side

(128) Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side

(129) Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side

(130) Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side

(131) Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side

- █ (132) Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side
- █ (133) Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side
- █ (134) Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side
- █ (135) Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side
- █ (136) Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side
- █ (137) Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side
- █ (138) Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side
- █ (139) Apply Protective Treatment to the Work Area at Frame 41, RH Side
- █ (140) Apply Protective Treatment to the Work Area at Frame 42, RH Side
- █ (141) Apply Protective Treatment to the Work Area at Frame 43, RH Side
- █ (142) Apply Protective Treatment to the Work Area at Frame 44, RH Side
- █ (143) Apply Protective Treatment to the Work Area at Frame 45, RH Side
- █ (144) Apply Protective Treatment to the Work Area at Frame 46, RH Side

█ Task 536178-839-801-001: Inspection - ADDITIONAL WORK

- █ (1) Do a Check of the Rotating Probe Inspection on Frame 41 to Frame 46

****CONF 004**

█ Task 536178-831-801-001: Modification

- █ (1) Remove the Fastener from Hole H1 of Frame 41, LH Side
- █ (2) Remove the Fastener from Hole H1 of Frame 42, LH Side
- █ (3) Remove the Fastener from Hole H1 of Frame 43, LH Side
- █ (4) Remove the Fastener from Hole H1 of Frame 44, LH Side
- █ (5) Remove the Fastener from Hole H1 of Frame 45, LH Side
- █ (6) Remove the Fastener from Hole H1 of Frame 46, LH Side
- █ (7) Remove the Fasteners from Holes H2 to H7 of Frame 41, LH Side
- █ (8) Remove the Fasteners from Holes H2 to H7 of Frame 42, LH Side
- █ (9) Remove the Fasteners from Holes H2 to H8 of Frame 43, LH Side
- █ (10) Remove the Fasteners from Holes H2 to H8 of Frame 44, LH Side

- (11) Remove the Fasteners from Holes H2 to H7 of Frame 45, LH Side
- (12) Remove the Fasteners from Holes H2 to H7 of Frame 46, LH Side
- (13) Remove the Fasteners from Holes H8 and H9 of Frame 41, LH Side
- (14) Remove the Fasteners from Holes H8 and H9 of Frame 42, LH Side
- (15) Remove the Fasteners from Holes H9 and H10 of Frame 43, LH Side
- (16) Remove the Fasteners from Holes H9 and H10 of Frame 44, LH Side
- (17) Remove the Fasteners from Holes H8 and H9 of Frame 45, LH Side
- (18) Remove the Fasteners from Holes H8 and H9 of Frame 46, LH Side
- (19) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, LH Side
- (20) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, LH Side
- (21) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, LH Side
- (22) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, LH Side
- (23) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, LH Side
- (24) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, LH Side
- (25) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, LH Side
- (26) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, LH Side
- (27) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, LH Side
- (28) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, LH Side
- (29) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, LH Side
- (30) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, LH Side
- (31) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, LH Side
- (32) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, LH Side
- (33) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, LH Side

- (34) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, LH Side
- (35) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, LH Side
- (36) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, LH Side
- (37) Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side
- (38) Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side
- (39) Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side
- (40) Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side
- (41) Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side
- (42) Depending on the Inspection Result, Ream Hole H1 of Frame 46, LH Side
- (43) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side
- (44) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side
- (45) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side
- (46) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side
- (47) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side
- (48) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side
- (49) Install the Fastener on the Hole H1 of Frame 41, LH Side
- (50) Install the Fastener on the Hole H1 of Frame 42, LH Side
- (51) Install the Fastener on the Hole H1 of Frame 43, LH Side
- (52) Install the Fastener on the Hole H1 of Frame 44, LH Side
- (53) Install the Fastener on the Hole H1 of Frame 45, LH Side
- (54) Install the Fastener on the Hole H1 of Frame 46, LH Side
- (55) Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side
- (56) Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side
- (57) Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side
- (58) Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side
- (59) Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side

- █ (60) Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side
- █ (61) Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side
- █ (62) Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side
- █ (63) Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side
- █ (64) Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side
- █ (65) Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side
- █ (66) Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side
- █ (67) Apply Protective Treatment to the Work Area at Frame 41, LH Side
- █ (68) Apply Protective Treatment to the Work Area at Frame 42, LH Side
- █ (69) Apply Protective Treatment to the Work Area at Frame 43, LH Side
- █ (70) Apply Protective Treatment to the Work Area at Frame 44, LH Side
- █ (71) Apply Protective Treatment to the Work Area at Frame 45, LH Side
- █ (72) Apply Protective Treatment to the Work Area at Frame 46, LH Side
- █ (73) Remove the Fastener from Hole H1 of Frame 41, RH Side
- █ (74) Remove the Fastener from Hole H1 of Frame 42, RH Side
- █ (75) Remove the Fastener from Hole H1 of Frame 43, RH Side
- █ (76) Remove the Fastener from Hole H1 of Frame 44, RH Side
- █ (77) Remove the Fastener from Hole H1 of Frame 45, RH Side
- █ (78) Remove the Fastener from Hole H1 of Frame 46, RH Side
- █ (79) Remove the Fasteners from Holes H2 to H7 of Frame 41, RH Side
- █ (80) Remove the Fasteners from Holes H2 to H7 of Frame 42, RH Side
- █ (81) Remove the Fasteners from Holes H2 to H8 of Frame 43, RH Side
- █ (82) Remove the Fasteners from Holes H2 to H8 of Frame 44, RH Side
- █ (83) Remove the Fasteners from Holes H2 to H7 of Frame 45, RH Side
- █ (84) Remove the Fasteners from Holes H2 to H7 of Frame 46, RH Side
- █ (85) Remove the Fasteners from Holes H8 and H9 of Frame 41, RH Side
- █ (86) Remove the Fasteners from Holes H8 and H9 of Frame 42, RH Side

- (87) Remove the Fasteners from Holes H9 and H10 of Frame 43, RH Side
- (88) Remove the Fasteners from Holes H9 and H10 of Frame 44, RH Side
- (89) Remove the Fasteners from Holes H8 and H9 of Frame 45, RH Side
- (90) Remove the Fasteners from Holes H8 and H9 of Frame 46, RH Side
- (91) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, RH Side
- (92) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, RH Side
- (93) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, RH Side
- (94) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, RH Side
- (95) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, RH Side
- (96) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, RH Side
- (97) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, RH Side
- (98) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, RH Side
- (99) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, RH Side
- (100) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, RH Side
- (101) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, RH Side
- (102) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, RH Side
- (103) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, RH Side
- (104) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, RH Side
- (105) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, RH Side
- (106) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, RH Side
- (107) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, RH Side
- (108) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46,

RH Side

(109) Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side

(110) Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side

(111) Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side

(112) Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side

(113) Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side

(114) Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side

(115) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side

(116) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side

(117) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side

(118) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side

(119) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side

(120) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side

(121) Install the Fastener on the Hole H1 of Frame 41, RH Side

(122) Install the Fastener on the Hole H1 of Frame 42, RH Side

(123) Install the Fastener on the Hole H1 of Frame 43, RH Side

(124) Install the Fastener on the Hole H1 of Frame 44, RH Side

(125) Install the Fastener on the Hole H1 of Frame 45, RH Side

(126) Install the Fastener on the Hole H1 of Frame 46, RH Side

(127) Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side

(128) Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side

(129) Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side

(130) Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side

(131) Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side

(132) Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side

(133) Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side

(134) Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side

█ (135) Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side

█ (136) Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side

█ (137) Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side

█ (138) Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side

█ (139) Apply Protective Treatment to the Work Area at Frame 41, RH Side

█ (140) Apply Protective Treatment to the Work Area at Frame 42, RH Side

█ (141) Apply Protective Treatment to the Work Area at Frame 43, RH Side

█ (142) Apply Protective Treatment to the Work Area at Frame 44, RH Side

█ (143) Apply Protective Treatment to the Work Area at Frame 45, RH Side

█ (144) Apply Protective Treatment to the Work Area at Frame 46, RH Side

█ Task 536178-839-801-001: Inspection - ADDITIONAL WORK

█ (1) Do a Check of the Rotating Probe Inspection on Frame 41 to Frame 46

****CONF 005**

█ Task 536178-831-801-001: Modification

█ (1) Remove the Fastener from Hole H1 of Frame 41, LH Side

█ (2) Remove the Fastener from Hole H1 of Frame 42, LH Side

█ (3) Remove the Fastener from Hole H1 of Frame 43, LH Side

█ (4) Remove the Fastener from Hole H1 of Frame 44, LH Side

█ (5) Remove the Fastener from Hole H1 of Frame 45, LH Side

█ (6) Remove the Fastener from Hole H1 of Frame 46, LH Side

█ (7) Remove the Fasteners from Holes H2 to H7 of Frame 41, LH Side

█ (8) Remove the Fasteners from Holes H2 to H7 of Frame 42, LH Side

█ (9) Remove the Fasteners from Holes H2 to H8 of Frame 43, LH Side

█ (10) Remove the Fasteners from Holes H2 to H8 of Frame 44, LH Side

█ (11) Remove the Fasteners from Holes H2 to H7 of Frame 45, LH Side

█ (12) Remove the Fasteners from Holes H2 to H7 of Frame 46, LH Side

█ (13) Remove the Fasteners from Holes H8 and H9 of Frame 41, LH Side

- (14) Remove the Fasteners from Holes H8 and H9 of Frame 42, LH Side
- (15) Remove the Fasteners from Holes H9 and H10 of Frame 43, LH Side
- (16) Remove the Fasteners from Holes H9 and H10 of Frame 44, LH Side
- (17) Remove the Fasteners from Holes H8 and H9 of Frame 45, LH Side
- (18) Remove the Fasteners from Holes H8 and H9 of Frame 46, LH Side
- (19) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, LH Side
- (20) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, LH Side
- (21) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, LH Side
- (22) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, LH Side
- (23) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, LH Side
- (24) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, LH Side
- (25) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, LH Side
- (26) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, LH Side
- (27) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, LH Side
- (28) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, LH Side
- (29) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, LH Side
- (30) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, LH Side
- (31) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, LH Side
- (32) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, LH Side
- (33) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, LH Side
- (34) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, LH Side
- (35) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, LH Side

- █ (36) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, LH Side
- █ (37) Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side
- █ (38) Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side
- █ (39) Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side
- █ (40) Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side
- █ (41) Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side
- █ (42) Depending on the Inspection Result, Ream Hole H1 of Frame 46, LH Side
- █ (43) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side
- █ (44) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side
- █ (45) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side
- █ (46) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side
- █ (47) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side
- █ (48) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side
- █ (49) Install the Fastener on the Hole H1 of Frame 41, LH Side
- █ (50) Install the Fastener on the Hole H1 of Frame 42, LH Side
- █ (51) Install the Fastener on the Hole H1 of Frame 43, LH Side
- █ (52) Install the Fastener on the Hole H1 of Frame 44, LH Side
- █ (53) Install the Fastener on the Hole H1 of Frame 45, LH Side
- █ (54) Install the Fastener on the Hole H1 of Frame 46, LH Side
- █ (55) Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side
- █ (56) Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side
- █ (57) Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side
- █ (58) Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side
- █ (59) Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side
- █ (60) Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side
- █ (61) Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side
- █ (62) Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side

- █ (63) Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side
- █ (64) Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side
- █ (65) Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side
- █ (66) Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side
- █ (67) Apply Protective Treatment to the Work Area at Frame 41, LH Side
- █ (68) Apply Protective Treatment to the Work Area at Frame 42, LH Side
- █ (69) Apply Protective Treatment to the Work Area at Frame 43, LH Side
- █ (70) Apply Protective Treatment to the Work Area at Frame 44, LH Side
- █ (71) Apply Protective Treatment to the Work Area at Frame 45, LH Side
- █ (72) Apply Protective Treatment to the Work Area at Frame 46, LH Side
- █ (73) Remove the Fastener from Hole H1 of Frame 41, RH Side
- █ (74) Remove the Fastener from Hole H1 of Frame 42, RH Side
- █ (75) Remove the Fastener from Hole H1 of Frame 43, RH Side
- █ (76) Remove the Fastener from Hole H1 of Frame 44, RH Side
- █ (77) Remove the Fastener from Hole H1 of Frame 45, RH Side
- █ (78) Remove the Fastener from Hole H1 of Frame 46, RH Side
- █ (79) Remove the Fasteners from Holes H2 to H7 of Frame 41, RH Side
- █ (80) Remove the Fasteners from Holes H2 to H7 of Frame 42, RH Side
- █ (81) Remove the Fasteners from Holes H2 to H8 of Frame 43, RH Side
- █ (82) Remove the Fasteners from Holes H2 to H8 of Frame 44, RH Side
- █ (83) Remove the Fasteners from Holes H2 to H7 of Frame 45, RH Side
- █ (84) Remove the Fasteners from Holes H2 to H7 of Frame 46, RH Side
- █ (85) Remove the Fasteners from Holes H8 and H9 of Frame 41, RH Side
- █ (86) Remove the Fasteners from Holes H8 and H9 of Frame 42, RH Side
- █ (87) Remove the Fasteners from Holes H9 and H10 of Frame 43, RH Side
- █ (88) Remove the Fasteners from Holes H9 and H10 of Frame 44, RH Side
- █ (89) Remove the Fasteners from Holes H8 and H9 of Frame 45, RH Side

- (90) Remove the Fasteners from Holes H8 and H9 of Frame 46, RH Side
- (91) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, RH Side
- (92) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, RH Side
- (93) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, RH Side
- (94) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, RH Side
- (95) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, RH Side
- (96) Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, RH Side
- (97) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, RH Side
- (98) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, RH Side
- (99) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, RH Side
- (100) Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, RH Side
- (101) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, RH Side
- (102) Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, RH Side
- (103) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, RH Side
- (104) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, RH Side
- (105) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, RH Side
- (106) Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, RH Side
- (107) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, RH Side
- (108) Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, RH Side
- (109) Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side
- (110) Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side

- █ (111) Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side
- █ (112) Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side
- █ (113) Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side
- █ (114) Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side
- █ (115) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side
- █ (116) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side
- █ (117) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side
- █ (118) Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side
- █ (119) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side
- █ (120) Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side
- █ (121) Install the Fastener on the Hole H1 of Frame 41, RH Side
- █ (122) Install the Fastener on the Hole H1 of Frame 42, RH Side
- █ (123) Install the Fastener on the Hole H1 of Frame 43, RH Side
- █ (124) Install the Fastener on the Hole H1 of Frame 44, RH Side
- █ (125) Install the Fastener on the Hole H1 of Frame 45, RH Side
- █ (126) Install the Fastener on the Hole H1 of Frame 46, RH Side
- █ (127) Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side
- █ (128) Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side
- █ (129) Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side
- █ (130) Install the Fastener on the Holes H2 to H7 of Frame 44, RH Side
- █ (131) Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side
- █ (132) Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side
- █ (133) Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side
- █ (134) Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side
- █ (135) Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side
- █ (136) Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side
- █ (137) Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side

(138) Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side

(139) Apply Protective Treatment to the Work Area at Frame 41, RH Side

(140) Apply Protective Treatment to the Work Area at Frame 42, RH Side

(141) Apply Protective Treatment to the Work Area at Frame 43, RH Side

(142) Apply Protective Treatment to the Work Area at Frame 44, RH Side

(143) Apply Protective Treatment to the Work Area at Frame 45, RH Side

(144) Apply Protective Treatment to the Work Area at Frame 46, RH Side

Task 536178-839-801-001: Inspection - ADDITIONAL WORK

(1) Do a Check of the Rotating Probe Inspection on Frame 41 to Frame 46

****CONF ALL**

E. COMPLIANCE

(1) Classification

MANDATORY: Service Bulletin must be accomplished.

(2) Accomplishment Timescale

****CONF 001**

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

Table 1, Config. 001 - Oversize Upper Frame Feet Splicing from FR41 to FR46			
Condition	Action	Compliance time (Whichever occurs first)	Repetitive interval
All aircraft	Do the oversizing of the holes from FR41 to FR46 in accordance with TASK 536178-831-801-001	27100 Flight cycle (FC) / 47300 Flight Hour (FH) from aircraft first flight	None

NOTE: No additional inspection is to be performed. Additional modification is to be performed before reaching 24500 FC or 42700 FH from this Service Bulletin No. A300-53-6178 accomplishment, whichever occurs first. Contact AIRBUS 6 months prior to the projected need.

Table 2, Config. 001 - Inspect if the Rotating Probe Inspection of the Fastener Holes on Frame 41 to Frame 46 has been done - ADDITIONAL WORK

Condition	Action	Compliance time (Whichever occurs first)	Repetitive interval
Aircraft with the Service Bulletin No. A300-53-6178 embodied at Revision 00	Check if the rotating probe inspection of the fasteners holes on Frame 41 to Frame 46 has been done in accordance with TASK 536178-839-801 001 Inspection - ADDITIONAL WORK	3800 FC or 6200 FH (from Service Bulletin No. A300-53-6178 embodiment)	None
Rotating probe inspection has been done	No further action	None	None
Rotating probe inspection has not been done	Contact AIRBUS	Before next flight	None

****CONF 002**

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

Table 1, Config. 002 - Oversize Upper Frame Feet Splicing from FR41 to FR46

Condition	Action	Compliance time (Whichever occurs first)	Repetitive interval
All aircraft	Do the oversizing of the holes from FR41 to FR46 in accordance with TASK 536178-831-801-001	27100 FC / 47300 FH after the accomplishment of the Service Bulletin No. A300-53-6125	None

NOTE: No additional inspection is to be performed. Additional modification is to be performed before reaching 24500 FC or 42700 FH from this Service Bulletin No. A300-53-6178 accomplishment, whichever occurs first. Contact AIRBUS 6 months prior to the projected need.

Table 2, Config. 002 - Inspect if the Rotating Probe Inspection of the Fastener Holes on Frame 41 to Frame 46 has been done - ADDITIONAL WORK

Condition	Action	Compliance time (Whichever occurs first)	Repetitive interval
Aircraft with the Service Bulletin No. A300-53-6178 embodied at Revision 00	Check if the rotating probe inspection of the fasteners holes on Frame 41 to Frame 46 has been done in accordance with TASK 536178-839-801 001 Inspection - ADDITIONAL WORK	3800 FC or 6200 FH from Service Bulletin No. A300-53-6178 embodiment	None
Rotating probe inspection has been done.	No further action	None	None
Rotating probe inspection has not been done.	Contact AIRBUS	Before next flight	None

****CONF 003**

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

Table 1, Config. 003 - Oversize Upper Frame Feet Splicing from FR41 to FR46

Condition	Action	Compliance time (Whichever occurs first)	Repetitive interval
All aircraft	Do the oversizing of the holes from FR41 to FR46 in accordance with TASK 536178-831-801-001	27100 FC / 47300 FH from aircraft first flight	None

NOTE: No additional inspection is to be performed. Additional modification is to be performed before reaching 24500 FC or 42700 FH from this Service Bulletin No. A300-53-6178 accomplishment, whichever occurs first. Contact AIRBUS 6 months prior to the projected need.

Table 2, Config. 003 - Inspect if the Rotating Probe Inspection of the Fastener Holes on Frame 41 to Frame 46 has been done - ADDITIONAL WORK

Condition	Action	Compliance time (Whichever occurs first)	Repetitive interval
Aircraft with the Service Bulletin No. A300-53-6178 embodied at Revision 00	Check if the rotating probe inspection of the fasteners holes on Frame 41 to Frame 46 has been done in accordance with TASK 536178-839-801 001 Inspection - ADDITIONAL WORK	3800 FC or 6200 FH from Service Bulletin No. A300-53-6178 embodiment	None
Rotating probe inspection has been done.	No further action	None	None
Rotating probe inspection has not been done.	Contact AIRBUS	Before next flight	None

****CONF 004**

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

Table 1, Config. 004 - Oversize Upper Frame Feet Splicing from FR41 to FR46

Condition	Action	Compliance time (Whichever occurs first)	Repetitive interval
All aircraft	Do the oversizing of the holes from FR41 to FR46 in accordance with TASK 536178-831-801-001	27100 FC / 47300 FH after the accomplishment of the Service Bulletin No. A300-53-6125	None

NOTE: No additional inspection is to be performed. Additional modification is to be performed before reaching 24500 FC or 42700 FH from this Service Bulletin No. A300-53-6178 accomplishment, whichever occurs first. Contact AIRBUS 6 months prior to the projected need.

Table 2, Config. 004 - Inspect if the Rotating Probe Inspection of the Fastener Holes on Frame 41 to Frame 46 has been done - ADDITIONAL WORK

Condition	Action	Compliance time (Whichever occurs first)	Repetitive interval
Aircraft with the Service Bulletin No. A300-53-6178 embodied at Revision 00	Check if the rotating probe inspection of the fasteners holes on Frame 41 to Frame 46 has been done in accordance with TASK 536178-839-801 001 Inspection - ADDITIONAL WORK	3800 FC or 6200 FH from Service Bulletin No. A300-53-6178 embodiment	None
Rotating probe inspection has been done.	No further action	None	None
Rotating probe inspection has not been done.	Contact AIRBUS	Before next flight	None

****CONF 005**

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

Table 1, Config. 005 - Oversize Upper Frame Feet Splicing from FR41 to FR46

Condition	Action	Compliance time (Whichever occurs first)	Repetitive interval
All aircraft	Do the oversizing of the holes from FR41 to FR46 in accordance with TASK 536178-831-801-001	27100 FC / 47300 FH after the accomplishment of the Service Bulletin No. A300-53-6125	None

NOTE: No additional inspection is to be performed. Additional modification is to be performed before reaching 24500 FC or 42700 FH from this Service Bulletin No. A300-53-6178 accomplishment, whichever occurs first. Contact AIRBUS 6 months prior to the projected need.

Table 2, Config. 005 - Inspect if the Rotating Probe Inspection of the Fastener Holes on Frame 41 to Frame 46 has been done - ADDITIONAL WORK

Condition	Action	Compliance time (Whichever occurs first)	Repetitive interval
Aircraft with the Service Bulletin No. A300-53-6178 embodied at Revision 00	Check if the rotating probe inspection of the fasteners holes on Frame 41 to Frame 46 has been done in accordance with TASK 536178-839-801 001 Inspection - ADDITIONAL WORK	3800 FC or 6200 FC from Service Bulletin No. A300-53-6178 embodiment	None
Rotating probe inspection has been done.	No further action	None	None
Rotating probe inspection has not been done.	Contact AIRBUS	Before next flight	None

****CONF ALL**

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 536178-831-801-001: Modification	
Get Access	5.00
On Aircraft	
Remove the Fastener from Hole H1 of Frame 41, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 42, LH Side	0.50

Task 536178-831-801-001: Modification	
Remove the Fastener from Hole H1 of Frame 43, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 44, LH Side	0.75
Remove the Fastener from Hole H1 of Frame 45, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 46, LH Side	0.50
Remove the Fasteners from Holes H2 to H7 of Frame 41, LH Side	2.00
Remove the Fasteners from Holes H2 to H7 of Frame 42, LH Side	2.00
Remove the Fasteners from Holes H2 to H8 of Frame 43, LH Side	2.00
Remove the Fasteners from Holes H2 to H8 of Frame 44, LH Side	2.50
Remove the Fasteners from Holes H2 to H7 of Frame 45, LH Side	2.00
Remove the Fasteners from Holes H2 to H7 of Frame 46, LH Side	2.00
Remove the Fasteners from Holes H8 and H9 of Frame 41, LH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 42, LH Side	0.75
Remove the Fasteners from Holes H9 and H10 of Frame 43, LH Side	0.75
Remove the Fasteners from Holes H9 and H10 of Frame 44, LH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 45, LH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 46, LH Side	0.75
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, LH Side	0.50

Task 536178-831-801-001: Modification	
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, LH Side	0.50
Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 46, LH Side	0.25
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side	1.00

Task 536178-831-801-001: Modification	
Install the Fastener on the Hole H1 of Frame 41, LH Side	0.50
Install the Fastener on the Hole H1 of Frame 42, LH Side	0.50
Install the Fastener on the Hole H1 of Frame 43, LH Side	0.50
Install the Fastener on the Hole H1 of Frame 44, LH Side	0.75
Install the Fastener on the Hole H1 of Frame 45, LH Side	0.50
Install the Fastener on the Hole H1 of Frame 46, LH Side	0.50
Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side	3.00
Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side	3.00
Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side	3.50
Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side	3.00
Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side	1.50
Apply Protective Treatment to the Work Area at Frame 41, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 42, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 43, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 44, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 45, LH Side	0.50

Task 536178-831-801-001: Modification	
Apply Protective Treatment to the Work Area at Frame 46, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 41, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 42, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 43, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 44, RH Side	0.75
Remove the Fastener from Hole H1 of Frame 45, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 46, RH Side	0.50
Remove the Fasteners from Holes H2 to H7 of Frame 41, RH Side	2.00
Remove the Fasteners from Holes H2 to H7 of Frame 42, RH Side	2.00
Remove the Fasteners from Holes H2 to H8 of Frame 43, RH Side	2.00
Remove the Fasteners from Holes H2 to H8 of Frame 44, RH Side	2.50
Remove the Fasteners from Holes H2 to H7 of Frame 45, RH Side	2.00
Remove the Fasteners from Holes H2 to H7 of Frame 46, RH Side	2.00
Remove the Fasteners from Holes H8 and H9 of Frame 41, RH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 42, RH Side	0.75
Remove the Fasteners from Holes H9 and H10 of Frame 43, RH Side	0.75
Remove the Fasteners from Holes H9 and H10 of Frame 44, RH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 45, RH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 46, RH Side	0.75
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, RH Side	0.50

Task 536178-831-801-001: Modification	
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, RH Side	0.50
Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side	0.25
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side	1.00

Task 536178-831-801-001: Modification	
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side	1.00
Install the Fastener on the Hole H1 of Frame 41, RH Side	0.50
Install the Fastener on the Hole H1 of Frame 42, RH Side	0.50
Install the Fastener on the Hole H1 of Frame 43, RH Side	0.50
Install the Fastener on the Hole H1 of Frame 44, RH Side	0.75
Install the Fastener on the Hole H1 of Frame 45, RH Side	0.50
Install the Fastener on the Hole H1 of Frame 46, RH Side	0.50
Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side	3.00
Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side	3.00
Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side	3.50
Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side	3.00
Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side	1.50
Apply Protective Treatment to the Work Area at Frame 41, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 42, RH Side	0.50

Task 536178-831-801-001: Modification	
Apply Protective Treatment to the Work Area at Frame 43, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 44, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 45, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 46, RH Side	0.50
Close-Up	5.00
TOTAL MANHOURS	151.00
ELAPSED TIME (HOURS)	29.00

Task 536178-839-801-001: Inspection - ADDITIONAL WORK	
On Aircraft	
Do a Check of the Rotating Probe Inspection on Frame 41 to Frame 46	0.15
TOTAL MANHOURS	0.15
ELAPSED TIME (HOURS)	0.15

NOTE: For an explanation of the man-hours and elapsed time, refer to Gantt Chart, [Fig. A-FAAAA](#) given in Appendix 01.

****CONF 002**

Task 536178-831-801-001: Modification	
Get Access	5.00
On Aircraft	
Remove the Fastener from Hole H1 of Frame 41, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 42, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 43, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 44, LH Side	0.75
Remove the Fastener from Hole H1 of Frame 45, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 46, LH Side	0.50
Remove the Fasteners from Holes H2 to H7 of Frame 41, LH Side	2.00
Remove the Fasteners from Holes H2 to H7 of Frame 42, LH Side	2.00
Remove the Fasteners from Holes H2 to H8 of Frame 43, LH Side	2.00
Remove the Fasteners from Holes H2 to H8 of Frame 44, LH Side	2.50

Task 536178-831-801-001: Modification	
Remove the Fasteners from Holes H2 to H7 of Frame 45, LH Side	2.00
Remove the Fasteners from Holes H2 to H7 of Frame 46, LH Side	2.00
Remove the Fasteners from Holes H8 and H9 of Frame 41, LH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 42, LH Side	0.75
Remove the Fasteners from Holes H9 and H10 of Frame 43, LH Side	0.75
Remove the Fasteners from Holes H9 and H10 of Frame 44, LH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 45, LH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 46, LH Side	0.75
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, LH Side	0.50

Task 536178-831-801-001: Modification	
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, LH Side	0.50
Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 46, LH Side	0.25
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side	1.00
Install the Fastener on the Hole H1 of Frame 41, LH Side	0.50
Install the Fastener on the Hole H1 of Frame 42, LH Side	0.50
Install the Fastener on the Hole H1 of Frame 43, LH Side	0.50
Install the Fastener on the Hole H1 of Frame 44, LH Side	0.75
Install the Fastener on the Hole H1 of Frame 45, LH Side	0.50
Install the Fastener on the Hole H1 of Frame 46, LH Side	0.50
Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side	3.00

Task 536178-831-801-001: Modification	
Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side	3.00
Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side	3.50
Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side	3.00
Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side	1.50
Apply Protective Treatment to the Work Area at Frame 41, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 42, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 43, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 44, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 45, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 46, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 41, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 42, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 43, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 44, RH Side	0.75
Remove the Fastener from Hole H1 of Frame 45, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 46, RH Side	0.50
Remove the Fasteners from Holes H2 to H7 of Frame 41, RH Side	2.00

Task 536178-831-801-001: Modification	
Remove the Fasteners from Holes H2 to H7 of Frame 42, RH Side	2.00
Remove the Fasteners from Holes H2 to H8 of Frame 43, RH Side	2.00
Remove the Fasteners from Holes H2 to H8 of Frame 44, RH Side	2.50
Remove the Fasteners from Holes H2 to H7 of Frame 45, RH Side	2.00
Remove the Fasteners from Holes H2 to H7 of Frame 46, RH Side	2.00
Remove the Fasteners from Holes H8 and H9 of Frame 41, RH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 42, RH Side	0.75
Remove the Fasteners from Holes H9 and H10 of Frame 43, RH Side	0.75
Remove the Fasteners from Holes H9 and H10 of Frame 44, RH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 45, RH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 46, RH Side	0.75
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, RH Side	0.50

Task 536178-831-801-001: Modification	
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, RH Side	0.50
Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side	0.25
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side	1.00
Install the Fastener on the Hole H1 of Frame 41, RH Side	0.50
Install the Fastener on the Hole H1 of Frame 42, RH Side	0.50
Install the Fastener on the Hole H1 of Frame 43, RH Side	0.50
Install the Fastener on the Hole H1 of Frame 44, RH Side	0.75
Install the Fastener on the Hole H1 of Frame 45, RH Side	0.50

Task 536178-831-801-001: Modification	
Install the Fastener on the Hole H1 of Frame 46, RH Side	0.50
Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side	3.00
Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side	3.00
Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side	3.50
Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side	3.00
Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side	1.50
Apply Protective Treatment to the Work Area at Frame 41, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 42, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 43, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 44, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 45, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 46, RH Side	0.50
Close-Up	5.00
TOTAL MANHOURS	151.00
ELAPSED TIME (HOURS)	29.00
Task 536178-839-801-001: Inspection - ADDITIONAL WORK	
On Aircraft	
Do a Check of the Rotating Probe Inspection on Frame 41 to Frame 46	0.15

Task 536178-839-801-001: Inspection - ADDITIONAL WORK	
TOTAL MANHOURS	0.15
ELAPSED TIME (HOURS)	0.15

NOTE: For an explanation of the man-hours and elapsed time, refer to Gantt Chart, [Fig. A-FAAAA](#) given in Appendix 01.

****CONF 003**

Task 536178-831-801-001: Modification	
Get Access	5.00
On Aircraft	
Remove the Fastener from Hole H1 of Frame 41, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 42, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 43, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 44, LH Side	0.75
Remove the Fastener from Hole H1 of Frame 45, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 46, LH Side	0.50
Remove the Fasteners from Holes H2 to H7 of Frame 41, LH Side	2.00
Remove the Fasteners from Holes H2 to H7 of Frame 42, LH Side	2.00
Remove the Fasteners from Holes H2 to H8 of Frame 43, LH Side	2.00
Remove the Fasteners from Holes H2 to H8 of Frame 44, LH Side	2.50
Remove the Fasteners from Holes H2 to H7 of Frame 45, LH Side	2.00
Remove the Fasteners from Holes H2 to H7 of Frame 46, LH Side	2.00
Remove the Fasteners from Holes H8 and H9 of Frame 41, LH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 42, LH Side	0.75
Remove the Fasteners from Holes H9 and H10 of Frame 43, LH Side	0.75
Remove the Fasteners from Holes H9 and H10 of Frame 44, LH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 45, LH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 46, LH Side	0.75

Task 536178-831-801-001: Modification	
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, LH Side	0.50
Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side	0.25

Task 536178-831-801-001: Modification	
Depending on the Inspection Result, Ream Hole H1 of Frame 46, LH Side	0.25
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side	1.00
Install the Fastener on the Hole H1 of Frame 41, LH Side	0.50
Install the Fastener on the Hole H1 of Frame 42, LH Side	0.50
Install the Fastener on the Hole H1 of Frame 43, LH Side	0.50
Install the Fastener on the Hole H1 of Frame 44, LH Side	0.75
Install the Fastener on the Hole H1 of Frame 45, LH Side	0.50
Install the Fastener on the Hole H1 of Frame 46, LH Side	0.50
Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side	3.00
Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side	3.00
Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side	3.50
Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side	3.00
Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side	1.50

Task 536178-831-801-001: Modification	
Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side	1.50
Apply Protective Treatment to the Work Area at Frame 41, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 42, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 43, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 44, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 45, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 46, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 41, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 42, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 43, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 44, RH Side	0.75
Remove the Fastener from Hole H1 of Frame 45, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 46, RH Side	0.50
Remove the Fasteners from Holes H2 to H7 of Frame 41, RH Side	2.00
Remove the Fasteners from Holes H2 to H7 of Frame 42, RH Side	2.00
Remove the Fasteners from Holes H2 to H8 of Frame 43, RH Side	2.00
Remove the Fasteners from Holes H2 to H8 of Frame 44, RH Side	2.50
Remove the Fasteners from Holes H2 to H7 of Frame 45, RH Side	2.00
Remove the Fasteners from Holes H2 to H7 of Frame 46, RH Side	2.00
Remove the Fasteners from Holes H8 and H9 of Frame 41, RH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 42, RH Side	0.75
Remove the Fasteners from Holes H9 and H10 of Frame 43, RH Side	0.75

Task 536178-831-801-001: Modification	
Remove the Fasteners from Holes H9 and H10 of Frame 44, RH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 45, RH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 46, RH Side	0.75
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, RH Side	0.50
Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side	0.25

Task 536178-831-801-001: Modification	
Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side	0.25
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side	1.00
Install the Fastener on the Hole H1 of Frame 41, RH Side	0.50
Install the Fastener on the Hole H1 of Frame 42, RH Side	0.50
Install the Fastener on the Hole H1 of Frame 43, RH Side	0.50
Install the Fastener on the Hole H1 of Frame 44, RH Side	0.75
Install the Fastener on the Hole H1 of Frame 45, RH Side	0.50
Install the Fastener on the Hole H1 of Frame 46, RH Side	0.50
Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side	3.00
Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side	3.00
Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side	3.50
Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side	3.00
Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side	1.50

Task 536178-831-801-001: Modification	
Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side	1.50
Apply Protective Treatment to the Work Area at Frame 41, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 42, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 43, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 44, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 45, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 46, RH Side	0.50
Close-Up	5.00
TOTAL MANHOURS	151.00
ELAPSED TIME (HOURS)	29.00

Task 536178-839-801-001: Inspection - ADDITIONAL WORK	
On Aircraft	
Do a Check of the Rotating Probe Inspection on Frame 41 to Frame 46	0.15
TOTAL MANHOURS	0.15
ELAPSED TIME (HOURS)	0.15

NOTE: For an explanation of the man-hours and elapsed time, refer to Gantt Chart, [Fig. A-FAAAA](#) given in Appendix 01.

****CONF 004**

Task 536178-831-801-001: Modification	
Get Access	5.00
On Aircraft	
Remove the Fastener from Hole H1 of Frame 41, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 42, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 43, LH Side	0.50

Task 536178-831-801-001: Modification	
Remove the Fastener from Hole H1 of Frame 44, LH Side	0.75
Remove the Fastener from Hole H1 of Frame 45, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 46, LH Side	0.50
Remove the Fasteners from Holes H2 to H7 of Frame 41, LH Side	2.00
Remove the Fasteners from Holes H2 to H7 of Frame 42, LH Side	2.00
Remove the Fasteners from Holes H2 to H8 of Frame 43, LH Side	2.00
Remove the Fasteners from Holes H2 to H8 of Frame 44, LH Side	2.50
Remove the Fasteners from Holes H2 to H7 of Frame 45, LH Side	2.00
Remove the Fasteners from Holes H2 to H7 of Frame 46, LH Side	2.00
Remove the Fasteners from Holes H8 and H9 of Frame 41, LH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 42, LH Side	0.75
Remove the Fasteners from Holes H9 and H10 of Frame 43, LH Side	0.75
Remove the Fasteners from Holes H9 and H10 of Frame 44, LH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 45, LH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 46, LH Side	0.75
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, LH Side	0.50

Task 536178-831-801-001: Modification	
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, LH Side	0.50
Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 46, LH Side	0.25
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side	1.00
Install the Fastener on the Hole H1 of Frame 41, LH Side	0.50

Task 536178-831-801-001: Modification	
Install the Fastener on the Hole H1 of Frame 42, LH Side	0.50
Install the Fastener on the Hole H1 of Frame 43, LH Side	0.50
Install the Fastener on the Hole H1 of Frame 44, LH Side	0.75
Install the Fastener on the Hole H1 of Frame 45, LH Side	0.50
Install the Fastener on the Hole H1 of Frame 46, LH Side	0.50
Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side	3.00
Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side	3.00
Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side	3.50
Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side	3.00
Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side	1.50
Apply Protective Treatment to the Work Area at Frame 41, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 42, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 43, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 44, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 45, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 46, LH Side	0.50

Task 536178-831-801-001: Modification	
Remove the Fastener from Hole H1 of Frame 41, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 42, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 43, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 44, RH Side	0.75
Remove the Fastener from Hole H1 of Frame 45, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 46, RH Side	0.50
Remove the Fasteners from Holes H2 to H7 of Frame 41, RH Side	2.00
Remove the Fasteners from Holes H2 to H7 of Frame 42, RH Side	2.00
Remove the Fasteners from Holes H2 to H8 of Frame 43, RH Side	2.00
Remove the Fasteners from Holes H2 to H8 of Frame 44, RH Side	2.50
Remove the Fasteners from Holes H2 to H7 of Frame 45, RH Side	2.00
Remove the Fasteners from Holes H2 to H7 of Frame 46, RH Side	2.00
Remove the Fasteners from Holes H8 and H9 of Frame 41, RH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 42, RH Side	0.75
Remove the Fasteners from Holes H9 and H10 of Frame 43, RH Side	0.75
Remove the Fasteners from Holes H9 and H10 of Frame 44, RH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 45, RH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 46, RH Side	0.75
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, RH Side	0.50

Task 536178-831-801-001: Modification	
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, RH Side	0.50
Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side	0.25
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side	1.00

Task 536178-831-801-001: Modification	
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side	1.00
Install the Fastener on the Hole H1 of Frame 41, RH Side	0.50
Install the Fastener on the Hole H1 of Frame 42, RH Side	0.50
Install the Fastener on the Hole H1 of Frame 43, RH Side	0.50
Install the Fastener on the Hole H1 of Frame 44, RH Side	0.75
Install the Fastener on the Hole H1 of Frame 45, RH Side	0.50
Install the Fastener on the Hole H1 of Frame 46, RH Side	0.50
Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side	3.00
Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side	3.00
Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side	3.50
Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side	3.00
Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side	1.50
Apply Protective Treatment to the Work Area at Frame 41, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 42, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 43, RH Side	0.50

Task 536178-831-801-001: Modification	
Apply Protective Treatment to the Work Area at Frame 44, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 45, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 46, RH Side	0.50
Close-Up	5.00
TOTAL MANHOURS	151.00
ELAPSED TIME (HOURS)	29.00

Task 536178-839-801-001: Inspection - ADDITIONAL WORK	
On Aircraft	
Do a Check of the Rotating Probe Inspection on Frame 41 to Frame 46	0.15
TOTAL MANHOURS	0.15
ELAPSED TIME (HOURS)	0.15

NOTE: For an explanation of the man-hours and elapsed time, refer to Gantt Chart, [Fig. A-FAAAA](#) given in Appendix 01.

****CONF 005**

Task 536178-831-801-001: Modification	
Get Access	5.00
On Aircraft	
Remove the Fastener from Hole H1 of Frame 41, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 42, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 43, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 44, LH Side	0.75
Remove the Fastener from Hole H1 of Frame 45, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 46, LH Side	0.50
Remove the Fasteners from Holes H2 to H7 of Frame 41, LH Side	2.00
Remove the Fasteners from Holes H2 to H7 of Frame 42, LH Side	2.00
Remove the Fasteners from Holes H2 to H8 of Frame 43, LH Side	2.00
Remove the Fasteners from Holes H2 to H8 of Frame 44, LH Side	2.50
Remove the Fasteners from Holes H2 to H7 of Frame 45, LH Side	2.00

Task 536178-831-801-001: Modification	
Remove the Fasteners from Holes H2 to H7 of Frame 46, LH Side	2.00
Remove the Fasteners from Holes H8 and H9 of Frame 41, LH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 42, LH Side	0.75
Remove the Fasteners from Holes H9 and H10 of Frame 43, LH Side	0.75
Remove the Fasteners from Holes H9 and H10 of Frame 44, LH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 45, LH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 46, LH Side	0.75
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, LH Side	0.50

Task 536178-831-801-001: Modification	
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, LH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, LH Side	0.50
Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 46, LH Side	0.25
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side	1.00
Install the Fastener on the Hole H1 of Frame 41, LH Side	0.50
Install the Fastener on the Hole H1 of Frame 42, LH Side	0.50
Install the Fastener on the Hole H1 of Frame 43, LH Side	0.50
Install the Fastener on the Hole H1 of Frame 44, LH Side	0.75
Install the Fastener on the Hole H1 of Frame 45, LH Side	0.50
Install the Fastener on the Hole H1 of Frame 46, LH Side	0.50
Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side	3.00
Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side	3.00

Task 536178-831-801-001: Modification	
Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side	3.50
Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side	3.00
Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side	1.50
Apply Protective Treatment to the Work Area at Frame 41, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 42, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 43, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 44, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 45, LH Side	0.50
Apply Protective Treatment to the Work Area at Frame 46, LH Side	0.50
Remove the Fastener from Hole H1 of Frame 41, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 42, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 43, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 44, RH Side	0.75
Remove the Fastener from Hole H1 of Frame 45, RH Side	0.50
Remove the Fastener from Hole H1 of Frame 46, RH Side	0.50
Remove the Fasteners from Holes H2 to H7 of Frame 41, RH Side	2.00
Remove the Fasteners from Holes H2 to H7 of Frame 42, RH Side	2.00

Task 536178-831-801-001: Modification	
Remove the Fasteners from Holes H2 to H8 of Frame 43, RH Side	2.00
Remove the Fasteners from Holes H2 to H8 of Frame 44, RH Side	2.50
Remove the Fasteners from Holes H2 to H7 of Frame 45, RH Side	2.00
Remove the Fasteners from Holes H2 to H7 of Frame 46, RH Side	2.00
Remove the Fasteners from Holes H8 and H9 of Frame 41, RH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 42, RH Side	0.75
Remove the Fasteners from Holes H9 and H10 of Frame 43, RH Side	0.75
Remove the Fasteners from Holes H9 and H10 of Frame 44, RH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 45, RH Side	0.75
Remove the Fasteners from Holes H8 and H9 of Frame 46, RH Side	0.75
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, RH Side	0.50

Task 536178-831-801-001: Modification	
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, RH Side	0.50
Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, RH Side	0.50
Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side	0.25
Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side	0.25
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side	1.00
Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side	1.00
Install the Fastener on the Hole H1 of Frame 41, RH Side	0.50
Install the Fastener on the Hole H1 of Frame 42, RH Side	0.50
Install the Fastener on the Hole H1 of Frame 43, RH Side	0.50
Install the Fastener on the Hole H1 of Frame 44, RH Side	0.75
Install the Fastener on the Hole H1 of Frame 45, RH Side	0.50
Install the Fastener on the Hole H1 of Frame 46, RH Side	0.50

Task 536178-831-801-001: Modification	
Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side	3.00
Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side	3.00
Install the Fastener on the Holes H2 to H7 of Frame 44, RH Side	3.50
Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side	3.00
Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side	3.00
Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side	1.50
Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side	1.50
Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side	1.50
Apply Protective Treatment to the Work Area at Frame 41, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 42, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 43, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 44, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 45, RH Side	0.50
Apply Protective Treatment to the Work Area at Frame 46, RH Side	0.50
Close-Up	5.00
TOTAL MANHOURS	151.00
ELAPSED TIME (HOURS)	29.00

Task 536178-839-801-001: Inspection - ADDITIONAL WORK	
On Aircraft	
Do a Check of the Rotating Probe Inspection on Frame 41 to Frame 46	0.15
TOTAL MANHOURS	0.15
ELAPSED TIME (HOURS)	0.15

NOTE: For an explanation of the man-hours and elapsed time, refer to Gantt Chart, [Fig. A-FAAAA](#) given in Appendix 01.

****CONF ALL**

H. WEIGHT AND BALANCE

Not Changed

I. ELECTRICAL LOAD DATA

Not Changed

J. REFERENCES

****CONF 001**

Airworthiness Limitation Item (ALI)	53-15-54 53-15-58		
Airworthiness Limitation Section (ALS)	Part 2		
Aircraft Maintenance Manual (AMM)	06-21-00 20-21-12 25-21-00 25-23-31	06-31-53 20-28-11 25-22-11	06-41-00 24-00-00 25-23-21
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-51-20	20-55-00	
Non Destructive Test Manual (NTM)	51-10-01	51-10-18	
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-24-00 51-40-30 51-75-10	51-40-00 51-40-40	51-40-20 51-40-44

****CONF 002**

Airworthiness Limitation Item (ALI)	53-15-54 53-15-58		
Airworthiness Limitation Section (ALS)	Part 2		
Aircraft Maintenance Manual (AMM)	06-21-00 20-21-12 25-21-00 25-23-31	06-31-53 20-28-11 25-22-11	06-41-00 24-00-00 25-23-21
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-51-20	20-55-00	
Non Destructive Test Manual (NTM)	51-10-01	51-10-18	
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-24-00 51-40-30 51-75-10	51-40-00 51-40-40	51-40-20 51-40-44

****CONF 003**

Airworthiness Limitation Item (ALI)	53-15-54 53-15-58
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Airworthiness Limitation Section (ALS)	Part 2		
Aircraft Maintenance Manual (AMM)	06-21-00 20-21-12 25-22-11 53-10-25	06-31-53 20-28-11 25-58-22	06-41-00 24-00-00 26-19-12
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-51-20	20-55-00	
Non Destructive Test Manual (NTM)	51-10-01	51-10-18	
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-24-00 51-40-30 51-75-10	51-40-00 51-40-40	51-40-20 51-40-44

****CONF 004**

Airworthiness Limitation Item (ALI)	53-15-54 53-15-58		
Airworthiness Limitation Section (ALS)	Part 2		
Aircraft Maintenance Manual (AMM)	06-21-00 20-21-12 25-22-11 53-10-25	06-31-53 20-28-11 25-58-22	06-41-00 24-00-00 26-19-12
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-51-20	20-55-00	
Non Destructive Test Manual (NTM)	51-10-01	51-10-18	
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-24-00 51-40-30 51-75-10	51-40-00 51-40-40	51-40-20 51-40-44

****CONF 005**

Airworthiness Limitation Item (ALI)	53-15-54 53-15-58		
Airworthiness Limitation Section (ALS)	Part 2		
Aircraft Maintenance Manual (AMM)	06-21-00 20-21-12 25-21-00 25-23-31	06-31-53 20-28-11 25-22-11	06-41-00 24-00-00 25-23-21
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-51-20	20-55-00	
Non Destructive Test Manual (NTM)	51-10-01	51-10-18	
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-24-00 51-40-30 51-75-10	51-40-00 51-40-40	51-40-20 51-40-44

****CONF ALL**

K. PUBLICATION AFFECTED

None

5 DATE: Mar 17/15

SERVICE BULLETIN No.: A300-53-6178

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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

For standard hardware the purchase order shall be addressed to AIRBUS. Quote the number of this Service Bulletin, the MSN and, if applicable the Retrofit Information Letter (RIL) reference. Please send your request to:

Component COMPA01 Component COMPA02 Component COMPA03 Component COMPA04 Component COMPA05 Component COMPA06 Component COMPA07 Component COMPA08 Component COMPA09 Component COMPA10 Component COMPA11 Component COMPA12 Component COMPA16 Component COMPA17	AIRBUS Material, Logistics and Suppliers Standard Parts For ordering by internet: http://spares.airbus.com or via SPEC2000 For ordering by email: Please be informed that ifd.spares@airbus.com has changed and it has been replaced by your Single Point of Contact (SPOC) operating within the Customer Order Fulfilment (COF) If you do not know your SPOC and need assistance please call on +49 40 5076 4002 Phone: +49 (0) 40 50 76 40 03
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Customers with aircraft shown in the effectivity of this Service Bulletin should send a purchase order to AIRBUS. Quote the number of this Service Bulletin. The address is:

Component COMPA13 Component COMPA14 Component COMPA15	AIRBUS Material, Logistics and Suppliers IFD - In Flight Desk Weg beim Jaeger 150 D-22335 HAMBURG GERMANY For ordering by internet: http://spares.airbus.com For ordering by fax: +49 40 50 76 4012 For ordering by email: Please be informed that ifd.spares@airbus.com has changed and it has been replaced by your Single Point of Contact (SPOC) operating within the Customer Order Fulfilment (COF) If you do not know your SPOC and need assistance please call on +49 40 5076 4002
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(2) Price and Availability

Component COMPA01

Operator supplied standard hardware parts required to accomplish this Service Bulletin, are to be supplied from the operator's stock.

Component COMPA02

Operator supplied standard hardware parts required to accomplish this Service Bulletin, are to be supplied from the operator's stock.

Component COMPA03

Operator supplied standard hardware parts required to accomplish this Service Bulletin, are to be supplied from the operator's stock.

Component COMPA04

Operator supplied standard hardware parts required to accomplish this Service Bulletin, are to be supplied from the operator's stock.

Component COMPA05

Operator supplied standard hardware parts required to accomplish this Service Bulletin, are to be supplied from the operator's stock.

Component COMPA06

Operator supplied standard hardware parts required to accomplish this Service Bulletin, are to be supplied from the operator's stock.

Component COMPA07

Operator supplied standard hardware parts required to accomplish this Service Bulletin, are to be supplied from the operator's stock.

Component COMPA08

Operator supplied standard hardware parts required to accomplish this Service Bulletin, are to be supplied from the operator's stock.

Component COMPA09

Operator supplied standard hardware parts required to accomplish this Service Bulletin, are to be supplied from the operator's stock.

Component COMPA10

Operator supplied standard hardware parts required to accomplish this Service Bulletin, are to be supplied from the operator's stock.

Component COMPA11

Operator supplied standard hardware parts required to accomplish this Service Bulletin, are to be supplied from the operator's stock.

Component COMPA12

Operator supplied standard hardware parts required to accomplish this Service Bulletin, are to be supplied from the operator's stock.

Component COMPA13

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

Component COMPA14

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

Component COMPA15

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

Component COMPA16

Operator supplied standard hardware parts required to accomplish this Service Bulletin, are to be supplied from the operator's stock.

Component COMPA17

Operator supplied standard hardware parts required to accomplish this Service Bulletin, are to be supplied from the operator's stock.

B. INDUSTRY SUPPORT INFORMATION

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

C. LIST OF COMPONENTS

No Kit

D. LIST OF MATERIALS - OPERATOR SUPPLIED

(1) Consumable Materials

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound- Water Displacing	12ABC1	As required	

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Paste Adhesive - Epoxy Potting Structure	13FBB2	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

(2) Components

Component COMPA01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
3	EN6115K6-7	7	BOLT				
4	ASNA2529-6	8	NUT				
5	EN6115K5Y8	7	BOLT				
6	ASNA2529-5	9	NUT				
7	NSA5368-516B	9	WASHER				
8	EN6115K5X7	7	BOLT				
9	EN6115K5-7	7	BOLT				
10	EN6115K4-8	1	BOLT				
11	ASNA2529-4	1	NUT				
12	EN6115K6-6	1	BOLT				
13	EN6115K5Y7	1	BOLT				
14	EN6115K5X6	1	BOLT				
15	EN6115K5-6	2	BOLT				
16	EN6115K5Y6	1	BOLT				
17	EN6115K5X5	1	BOLT				
18	EN6115K5-5	1	BOLT				
19	EN6115K5-8	1	BOLT				
38	EN6115K6X6	1	BOLT				
39	EN6115K6X7	5	BOLT				
42	EN6115K6Y7	1	BOLT				
43	EN6115K6Y8	5	BOLT				
46	NSA5368-616B	6	WASHER				
47	NSA5379-5W	2	WASHER				

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

Component COMPA02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
3	EN6115K6-7	7	BOLT				
4	ASNA2529-6	8	NUT				

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
5	EN6115K5Y8	7	BOLT				
6	ASNA2529-5	9	NUT				
7	NSA5368-516B	9	WASHER				
10	EN6115K4-8	1	BOLT				
11	ASNA2529-4	1	NUT				
12	EN6115K6-6	1	BOLT				
13	EN6115K5Y7	1	BOLT				
15	EN6115K5-6	1	BOLT				
16	EN6115K5Y6	1	BOLT				
17	EN6115K5X5	1	BOLT				
18	EN6115K5-5	1	BOLT				
19	EN6115K5-8	1	BOLT				
38	EN6115K6X6	1	BOLT				
39	EN6115K6X7	5	BOLT				
42	EN6115K6Y7	1	BOLT				
43	EN6115K6Y8	5	BOLT				
46	NSA5368-616B	6	WASHER				
47	NSA5379-5W	2	WASHER				

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

Component COMPA03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
3	EN6115K6-7	7	BOLT				
4	ASNA2529-6	8	NUT				
5	EN6115K5Y8	7	BOLT				
6	ASNA2529-5	9	NUT				
7	NSA5368-516B	9	WASHER				
8	EN6115K5X7	7	BOLT				
9	EN6115K5-7	7	BOLT				
10	EN6115K4-8	1	BOLT				
11	ASNA2529-4	1	NUT				
12	EN6115K6-6	1	BOLT				
13	EN6115K5Y7	1	BOLT				
14	EN6115K5X6	1	BOLT				
15	EN6115K5-6	2	BOLT				
16	EN6115K5Y6	1	BOLT				
17	EN6115K5X5	1	BOLT				
18	EN6115K5-5	1	BOLT				

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
19	EN6115K5-8	1	BOLT				
38	EN6115K6X6	1	BOLT				
39	EN6115K6X7	5	BOLT				
42	EN6115K6Y7	1	BOLT				
43	EN6115K6Y8	5	BOLT				
46	NSA5368-616B	6	WASHER				
47	NSA5379-5W	2	WASHER				

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

Component COMPA04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
3	EN6115K6-7	7	BOLT				
4	ASNA2529-6	8	NUT				
5	EN6115K5Y8	7	BOLT				
6	ASNA2529-5	9	NUT				
7	NSA5368-516B	9	WASHER				
10	EN6115K4-8	1	BOLT				
11	ASNA2529-4	1	NUT				
12	EN6115K6-6	1	BOLT				
13	EN6115K5Y7	1	BOLT				
15	EN6115K5-6	1	BOLT				
16	EN6115K5Y6	1	BOLT				
17	EN6115K5X5	1	BOLT				
18	EN6115K5-5	1	BOLT				
19	EN6115K5-8	1	BOLT				
38	EN6115K6X6	1	BOLT				
39	EN6115K6X7	5	BOLT				
42	EN6115K6Y7	1	BOLT				
43	EN6115K6Y8	1	BOLT				
46	NSA5368-616B	6	WASHER				
47	NSA5379-5W	2	WASHER				

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

Component COMPA05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
3	EN6115K6-7	7	BOLT				
4	ASNA2529-6	8	NUT				
5	EN6115K5Y8	7	BOLT				
6	ASNA2529-5	9	NUT				
7	NSA5368-516B	9	WASHER				
8	EN6115K5X7	7	BOLT				
9	EN6115K5-7	7	BOLT				
11	ASNA2529-4	1	NUT				
12	EN6115K6-6	1	BOLT				
13	EN6115K5Y7	1	BOLT				
14	EN6115K5X6	1	BOLT				
15	EN6115K5-6	2	BOLT				
16	EN6115K5Y6	1	BOLT				
17	EN6115K5X5	1	BOLT				
18	EN6115K5-5	1	BOLT				
19	EN6115K5-8	1	BOLT				
38	EN6115K4-9	1	BOLT				
38	EN6115K6X6	1	BOLT				
39	EN6115K6X7	5	BOLT				
42	EN6115K6Y7	1	BOLT				
43	EN6115K6Y8	5	BOLT				
46	NSA5368-616B	6	WASHER				
47	NSA5379-5W	2	WASHER				

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

Component COMPA06

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
3	EN6115K6-7	7	BOLT				
4	ASNA2529-6	8	NUT				
5	EN6115K5Y8	7	BOLT				
6	ASNA2529-5	9	NUT				
7	NSA5368-516B	9	WASHER				
11	ASNA2529-4	1	NUT				
12	EN6115K6-6	1	BOLT				
13	EN6115K5Y7	1	BOLT				
15	EN6115K5-6	1	BOLT				

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
16	EN6115K5Y6	1	BOLT				
17	EN6115K5X5	1	BOLT				
18	EN6115K5-5	1	BOLT				
19	EN6115K5-8	1	BOLT				
38	EN6115K4-9	1	BOLT				
38	EN6115K6X6	1	BOLT				
39	EN6115K6X7	5	BOLT				
42	EN6115K6Y7	1	BOLT				
43	EN6115K6Y8	5	BOLT				
46	NSA5368-616B	6	WASHER				
47	NSA5379-5W	2	WASHER				

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

Component COMPA07

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
3	EN6115K6-7	1	BOLT				
4	ASNA2529-6	9	NUT				
5	EN6115K5Y8	1	BOLT				
6	ASNA2529-5	10	NUT				
7	NSA5368-516B	10	WASHER				
8	EN6115K5X7	1	BOLT				
9	EN6115K5-7	2	BOLT				
11	ASNA2529-4	1	NUT				
13	EN6115K5Y7	1	BOLT				
14	EN6115K5X6	1	BOLT				
15	EN6115K5-6	1	BOLT				
19	EN6115K5-8	7	BOLT				
21	EN6115K4-11	1	BOLT				
22	EN6115K6-9	2	BOLT				
23	EN6115K5Y10	2	BOLT				
24	EN6115K5X9	2	BOLT				
25	EN6115K5-9	2	BOLT				
26	EN6115K6-8	6	BOLT				
27	EN6115K5Y9	6	BOLT				
28	EN6115K5X8	6	BOLT				
30	ASNA2027V4-8	1	BOLT				
31	NSA5075-8	1	NUT				
39	EN6115K6X7	1	BOLT				

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
40	EN6115K6X8	5	BOLT				
41	EN6115K6X9	1	BOLT				
43	EN6115K6Y8	1	BOLT				
44	EN6115K6Y9	5	BOLT				
45	EN6115K6Y10	1	BOLT				
46	NSA5368-616B	7	WASHER				
47	NSA5379-5W	2	WASHER				

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

Component COMPA08

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
3	EN6115K6-7	1	BOLT				
4	ASNA2529-6	9	NUT				
5	EN6115K5Y8	1	BOLT				
6	ASNA2529-5	10	NUT				
7	NSA5368-516B	10	WASHER				
9	EN6115K5-7	1	BOLT				
11	ASNA2529-4	1	NUT				
13	EN6115K5Y7	1	BOLT				
14	EN6115K5X6	1	BOLT				
15	EN6115K5-6	1	BOLT				
19	EN6115K5-8	1	BOLT				
21	EN6115K4-11	1	BOLT				
22	EN6115K6-9	2	BOLT				
23	EN6115K5Y10	2	BOLT				
26	EN6115K6-8	6	BOLT				
27	EN6115K5Y9	6	BOLT				
30	ASNA2027V4-8	1	BOLT				
31	NSA5075-8	1	NUT				
39	EN6115K6X7	1	BOLT				
40	EN6115K6X8	5	BOLT				
41	EN6115K6X9	1	BOLT				
43	EN6115K6Y8	1	BOLT				
44	EN6115K6Y9	5	BOLT				
45	EN6115K6Y10	1	BOLT				
46	NSA5368-616B	7	WASHER				
47	NSA5379-5W	2	WASHER				

SERVICE BULLETIN

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

Component COMPA09

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
3	EN6115K6-7	1	BOLT				
4	ASNA2529-6	8	NUT				
5	EN6115K5Y8	1	BOLT				
6	ASNA2529-5	9	NUT				
7	NSA5368-516B	9	WASHER				
8	EN6115K5X7	1	BOLT				
9	EN6115K5-7	2	BOLT				
11	ASNA2529-4	1	NUT				
13	EN6115K5Y7	1	BOLT				
14	EN6115K5X6	1	BOLT				
15	EN6115K5-6	1	BOLT				
19	EN6115K5-8	8	BOLT				
26	EN6115K6-8	7	BOLT				
27	EN6115K5Y9	7	BOLT				
28	EN6115K5X8	7	BOLT				
38	EN6115K4-9	1	BOLT				
39	EN6115K6X7	1	BOLT				
40	EN6115K6X8	5	BOLT				
43	EN6115K6Y8	1	BOLT				
44	EN6115K6Y9	5	BOLT				
46	NSA5368-616B	1	WASHER				
47	NSA5379-5W	2	WASHER				

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

Component COMPA10

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
3	EN6115K6-7	1	BOLT				
4	ASNA2529-6	8	NUT				
5	EN6115K5Y8	1	BOLT				

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
6	ASNA2529-5	9	NUT				
7	NSA5368-516B	9	WASHER				
9	EN6115K5-7	1	BOLT				
11	ASNA2529-4	1	NUT				
13	EN6115K5Y7	1	BOLT				
14	EN6115K5X6	1	BOLT				
15	EN6115K5-6	1	BOLT				
19	EN6115K5-8	1	BOLT				
26	EN6115K6-8	7	BOLT				
27	EN6115K5Y9	7	BOLT				
38	EN6115K4-9	1	BOLT				
39	EN6115K6X7	1	BOLT				
40	EN6115K6X8	5	BOLT				
43	EN6115K6Y8	1	BOLT				
44	EN6115K6Y9	5	BOLT				
46	NSA5368-616B	1	WASHER				
47	NSA5379-5W	2	WASHER				

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

Component COMPA11

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
4	ASNA2529-6	8	NUT				
6	ASNA2529-5	11	NUT				
7	NSA5368-516B	9	WASHER				
9	EN6115K5-7	1	BOLT				
11	ASNA2529-4	1	NUT				
13	EN6115K5Y7	1	BOLT				
14	EN6115K5X6	1	BOLT				
15	EN6115K5-6	1	BOLT				
19	EN6115K5-8	9	BOLT				
26	EN6115K6-8	8	BOLT				
27	EN6115K5Y9	8	BOLT				
28	EN6115K5X8	8	BOLT				
38	EN6115K4-9	1	BOLT				
40	EN6115K6X8	6	BOLT				
44	EN6115K6Y9	6	BOLT				
46	NSA5368-616B	6	WASHER				
47	NSA5379-5W	2	WASHER				

SERVICE BULLETIN

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

Component COMPA12

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
4	ASNA2529-6	8	NUT				
6	ASNA2529-5	9	NUT				
7	NSA5368-516B	9	WASHER				
9	EN6115K5-7	1	BOLT				
11	ASNA2529-4	1	NUT				
13	EN6115K5Y7	1	BOLT				
14	EN6115K5X6	1	BOLT				
15	EN6115K5-6	1	BOLT				
19	EN6115K5-8	1	BOLT				
26	EN6115K6-8	8	BOLT				
27	EN6115K5Y9	8	BOLT				
38	EN6115K4-9	1	BOLT				
40	EN6115K6X8	6	BOLT				
44	EN6115K6Y9	6	BOLT				
46	NSA5368-616B	6	WASHER				
47	NSA5379-5W	2	WASHER				

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

Component COMPA13

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	A5381309320000	6	SHIM				
2	A5381278720600	4	BUSH				
36	A5381278720200	1	BUSH				
37	A5381278720400	3	BUSH				

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

Component COMPA14

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	A5381309320000	6	SHIM				
2	A5381278720600	2	BUSH				
36	A5381278720200	1	BUSH				
37	A5381278720400	3	BUSH				

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

Component COMPA15

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
20	A2521327620000	1	SUPPORT				
29	A2521327620100	1	SUPPORT				
32	A2521326620200	2	SHIM				

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

Component COMPA16

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
3	EN6115K6-7	1	BOLT				
4	ASNA2529-6	9	NUT				
5	EN6115K5Y8	1	BOLT				
6	ASNA2529-5	10	NUT				
7	NSA5368-516B	10	WASHER				
9	EN6115K5-7	1	BOLT				
11	ASNA2529-4	1	NUT				
13	EN6115K5Y7	1	BOLT				
14	EN6115K5X6	1	BOLT				
15	EN6115K5-6	1	BOLT				
19	EN6115K5-8	1	BOLT				
21	EN6115K4-11	1	BOLT				
22	EN6115K6-9	2	BOLT				
23	EN6115K5Y10	2	BOLT				
26	EN6115K6-8	6	BOLT				
27	EN6115K5Y9	6	BOLT				
30	ASNA2027V4-8	1	BOLT				
31	NSA5075-8	1	NUT				
35	ASNA2050DCJ3215	2	RIVET				
39	EN6115K6X7	1	BOLT				
40	EN6115K6X8	5	BOLT				
41	EN6115K6X9	1	BOLT				
43	EN6115K6Y8	1	BOLT				

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
44	EN6115K6Y9	5	BOLT				
45	EN6115K6Y10	1	BOLT				
46	NSA5368-616B	7	WASHER				
47	NSA5379-5W	2	WASHER				

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

Component COMPA17

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
	DAN382G20	1 (M)	TAPE				

NOTE: The quantity given for the PN DAN382G20 is only for the connection between two pipes. The PN DAN382G20 must be orderer as necessary.

NOTE: The above list of components contains items with a Shelf Life of less than or equal to 24 months which must be ordered when you intend to accomplish the Service Bulletin

(3) Equipment

None

E. PARTS TO BE RE-IDENTIFIED BY OPERATOR

None

F. TOOLING

None

3. ACCOMPLISHMENT INSTRUCTIONS

Task 536178-831-801-001 - Modification

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

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

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

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

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: The purpose of flowcharts is to supplement the information given in the Procedure and Compliance paragraphs and not to serve as the primary source for tasks or compliance times given in this Service Bulletin.

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

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

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

Task Associated Data

**CONF 001

Zone	
241 242	
Manpower	
TOTAL MANHOURS	151.00
ELAPSED TIME (HOURS)	29.00

**CONF 002

Zone	
241 242	
Manpower	
TOTAL MANHOURS	151.00
ELAPSED TIME (HOURS)	29.00

**CONF 003

Zone	
241 242	
Manpower	
TOTAL MANHOURS	151.00
ELAPSED TIME (HOURS)	29.00

**CONF 004

Zone	
241 242	
Manpower	
TOTAL MANHOURS	151.00
ELAPSED TIME (HOURS)	29.00

**CONF 005

Zone	
241 242	
Manpower	
TOTAL MANHOURS	151.00
ELAPSED TIME (HOURS)	29.00

****CONF ALL**

A. GENERAL

****CONF 001**

(1) Subtask 536178-910-001-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-21-00, Page Block 001 06-31-53, Page Block 001 06-41-00, Page Block 001 20-21-12, Page Block 001 20-28-11, Page Block 001
Consumable Material List (CML)	
Elec. Std. Practices Manual (ESPM)	20-51-20
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-75-10

- (a) For the specification of materials (Mat. No.) given in this Service Bulletin, refer to the Consumable Material List (CML).
- (b) For the Frame (FR) identification, refer to AMM 06-31-53, Page Block 001.
- (c) For the identification of zones, refer to AMM 06-21-00, Page Block 001.
- (d) For the identification of access panels, refer to AMM 06-41-00, Page Block 001.
- (e) To torque tighten the standard threaded fasteners, refer to AMM 20-21-12, Page Block 001.
- (f) Remove and install fasteners in accordance with SRM 51-40-20.
- (g) Renew the protective finish in accordance with SRM 51-75-10.
- (h) Obtain fastener hole diameters and drill data in accordance with SRM 51-40-40.
- (i) For the electrical bonding, refer to ESPM 20-51-20 and AMM 20-28-11, Page Block 001.
- (j) Obtain alternative and substitute fastener data in accordance with SRM 51-40-30.
- (k) 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.

- (l) 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.

(2) Subtask 536178-839-001-001 - 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 536178-910-001-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-21-00, Page Block 001 06-31-53, Page Block 001 06-41-00, Page Block 001 20-21-12, Page Block 001 20-28-11, Page Block 001
Consumable Material List (CML)	
Elec. Std. Practices Manual (ESPM)	20-51-20
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-75-10

- (a) For the specification of materials (Mat. No.) given in this Service Bulletin, refer to the Consumable Material List (CML).
- (b) For the Frame (FR) identification, refer to AMM 06-31-53, Page Block 001.
- (c) For the identification of zones, refer to AMM 06-21-00, Page Block 001.
- (d) For the identification of access panels, refer to AMM 06-41-00, Page Block 001.
- (e) To torque tighten the standard threaded fasteners, refer to AMM 20-21-12, Page Block 001.
- (f) Remove and install fasteners in accordance with SRM 51-40-20.
- (g) Renew the protective finish in accordance with SRM 51-75-10.
- (h) Obtain fastener hole diameters and drill data in accordance with SRM 51-40-40.

- (i) For the electrical bonding, refer to ESPM 20-51-20 and AMM 20-28-11, Page Block 001.
- (j) Obtain alternative and substitute fastener data in accordance with SRM 51-40-30.
- (k) 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.
- (l) 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.

(2) Subtask 536178-839-001-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

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

****CONF 003**

(1) Subtask 536178-910-001-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-21-00, Page Block 001 06-31-53, Page Block 001 06-41-00, Page Block 001 20-21-12, Page Block 001 20-28-11, Page Block 001
Consumable Material List (CML)	
Elec. Std. Practices Manual (ESPM)	20-51-20
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-75-10

- (a) For the specification of materials (Mat. No.) given in this Service Bulletin, refer to the Consumable Material List (CML).
- (b) For the Frame (FR) identification, refer to AMM 06-31-53, Page Block 001.
- (c) For the identification of zones, refer to AMM 06-21-00, Page Block 001.
- (d) For the identification of access panels, refer to AMM 06-41-00, Page Block 001.

- (e) To torque tighten the standard threaded fasteners, refer to AMM 20-21-12, Page Block 001.
- (f) Remove and install fasteners in accordance with SRM 51-40-20.
- (g) Renew the protective finish in accordance with SRM 51-75-10.
- (h) Obtain fastener hole diameters and drill data in accordance with SRM 51-40-40.
- (i) For the electrical bonding, refer to ESPM 20-51-20 and AMM 20-28-11, Page Block 001.
- (j) Obtain alternative and substitute fastener data in accordance with SRM 51-40-30.
- (k) 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.
- (l) 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.

(2) Subtask 536178-839-001-001 - 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 536178-910-001-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-21-00, Page Block 001 06-31-53, Page Block 001 06-41-00, Page Block 001 20-21-12, Page Block 001 20-28-11, Page Block 001
Consumable Material List (CML)	
Elec. Std. Practices Manual (ESPM)	20-51-20
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-75-10

- (a) For the specification of materials (Mat. No.) given in this Service Bulletin, refer to the Consumable Material List (CML).
- (b) For the Frame (FR) identification, refer to AMM 06-31-53, Page Block 001.
- (c) For the identification of zones, refer to AMM 06-21-00, Page Block 001.
- (d) For the identification of access panels, refer to AMM 06-41-00, Page Block 001.
- (e) To torque tighten the standard threaded fasteners, refer to AMM 20-21-12, Page Block 001.
- (f) Remove and install fasteners in accordance with SRM 51-40-20.
- (g) Renew the protective finish in accordance with SRM 51-75-10.
- (h) Obtain fastener hole diameters and drill data in accordance with SRM 51-40-40.
- (i) For the electrical bonding, refer to ESPM 20-51-20 and AMM 20-28-11, Page Block 001.
- (j) Obtain alternative and substitute fastener data in accordance with SRM 51-40-30.
- (k) 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.
- (l) 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.

(2) Subtask 536178-839-001-001 - 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 536178-910-001-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-21-00, Page Block 001 06-31-53, Page Block 001 06-41-00, Page Block 001 20-21-12, Page Block 001 20-28-11, Page Block 001
Consumable Material List (CML)	
Elec. Std. Practices Manual (ESPM)	20-51-20
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-75-10

- (a) For the specification of materials (Mat. No.) given in this Service Bulletin, refer to the Consumable Material List (CML).
- (b) For the Frame (FR) identification, refer to AMM 06-31-53, Page Block 001.
- (c) For the identification of zones, refer to AMM 06-21-00, Page Block 001.
- (d) For the identification of access panels, refer to AMM 06-41-00, Page Block 001.
- (e) To torque tighten the standard threaded fasteners, refer to AMM 20-21-12, Page Block 001.
- (f) Remove and install fasteners in accordance with SRM 51-40-20.
- (g) Renew the protective finish in accordance with SRM 51-75-10.
- (h) Obtain fastener hole diameters and drill data in accordance with SRM 51-40-40.
- (i) For the electrical bonding, refer to ESPM 20-51-20 and AMM 20-28-11, Page Block 001.
- (j) Obtain alternative and substitute fastener data in accordance with SRM 51-40-30.
- (k) 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.
- (l) 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.

(2) Subtask 536178-839-001-001 - 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 536178-941-001-001 - Job Set-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	24-00-00, Page Block 301 25-21-00, Page Block 401 25-22-11, Page Block 401 25-23-31, Page Block 401

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 24-00-00, Page Block 301.
- (b) Put an access platform in position at zones 241 and 242.
- (c) Between Frame 41 and Frame 46, remove the passenger seats, refer to AMM 25-21-00, Page Block 401.
- (d) Between Frame 41 and Frame 46, remove the passenger-compartment lining-panels, refer to AMM 25-23-31, Page Block 401.
- (e) Between Frame 41 and Frame 46, remove the heat and sound insulation blankets, refer to AMM 25-22-11, Page Block 401.

****CONF 002**

(1) Subtask 536178-941-001-001 - Job Set-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	24-00-00, Page Block 301 25-21-00, Page Block 401 25-22-11, Page Block 401 25-23-31, Page Block 401

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 24-00-00, Page Block 301.
- (b) Put an access platform in position at zones 241 and 242.
- (c) Between Frame 41 and Frame 46, remove the passenger seats, refer to AMM 25-21-00, Page Block 401.
- (d) Between Frame 41 and Frame 46, remove the passenger-compartment lining-panels, refer to AMM 25-23-31, Page Block 401.
- (e) Between Frame 41 and Frame 46, remove the heat and sound insulation blankets, refer to AMM 25-22-11, Page Block 401.

****CONF 003**

(1) Subtask 536178-941-001-002 - Job Set-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	24-00-00, Page Block 301 25-22-11, Page Block 401 25-58-22, Page Block 401 26-19-12, Page Block 401 53-10-25, Page Block 401
Fig. A-FGAAA Principle for the Removal and the Installation of the Smoke Detector Pipes in the Modification Area	Sheet 01 Sheet 02

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 24-00-00, Page Block 301.
- (b) Put an access platform in position at zones 241 and 242.
- (c) Between Frame 41 and Frame 46, remove the main deck cargo lining-panels, refer to AMM 25-58-22, Page Block 401.
- (d) If installed between Frame 41 and Frame 42, remove the smoke detectors FIN 5WU, 7WU, 10WU and 12WU, refer to AMM 26-19-12, Page Block 401.
- (e) Remove the necessary smoke detector pipes between Frame 41 and Frame 46:
Refer to [Fig. A-FGAAA](#)
 - Record the location(s) of the pipe(s) that need to be removed.
 - Remove and discard the necessary adhesive tape.

- Remove and retain the pipe(s) and all the associated hardware.
- (f) Remove the floor panels 242XJ, 241XJ, 242YJ and 241YJ between Frame 45 and Frame 47, refer to AMM 53-10-25, Page Block 401.
- (g) Between Frame 41 and Frame 46, remove the heat and sound insulation blankets, refer to AMM 25-22-11, Page Block 401.

****CONF 004**

(1) Subtask 536178-941-001-002 - Job Set-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	24-00-00, Page Block 301 25-22-11, Page Block 401 25-58-22, Page Block 401 26-19-12, Page Block 401 53-10-25, Page Block 401
Fig. A-FGAAA Principle for the Removal and the Installation of the Smoke Detector Pipes in the Modification Area	Sheet 01 Sheet 02

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 24-00-00, Page Block 301.
- (b) Put an access platform in position at zones 241 and 242.
- (c) Between Frame 41 and Frame 46, remove the main deck cargo lining-panels, refer to AMM 25-58-22, Page Block 401.
- (d) If installed between Frame 41 and Frame 42, remove the smoke detectors FIN 5WU, 7WU, 10WU and 12WU, refer to AMM 26-19-12, Page Block 401.
- (e) Remove the necessary smoke detector pipes between Frame 41 and Frame 46:
Refer to [Fig. A-FGAAA](#)
 - Record the location(s) of the pipe(s) that need to be removed.
 - Remove and discard the necessary adhesive tape.
 - Remove and retain the pipe(s) and all the associated hardware.
- (f) Remove the floor panels 242XJ, 241XJ, 242YJ and 241YJ between Frame 45 and Frame 47, refer to AMM 53-10-25, Page Block 401.

- (g) Between Frame 41 and Frame 46, remove the heat and sound insulation blankets, refer to AMM 25-22-11, Page Block 401.

****CONF 005**

(1) Subtask 536178-941-001-001 - Job Set-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	24-00-00, Page Block 301 25-21-00, Page Block 401 25-22-11, Page Block 401 25-23-31, Page Block 401

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 24-00-00, Page Block 301.
- (b) Put an access platform in position at zones 241 and 242.
- (c) Between Frame 41 and Frame 46, remove the passenger seats, refer to AMM 25-21-00, Page Block 401.
- (d) Between Frame 41 and Frame 46, remove the passenger-compartment lining-panels, refer to AMM 25-23-31, Page Block 401.
- (e) Between Frame 41 and Frame 46, remove the heat and sound insulation blankets, refer to AMM 25-22-11, Page Block 401.

****CONF ALL**

C. PROCEDURE

****CONF 001**

(1) Subtask 536178-000-001-001 - Remove the Fastener from Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBAAA Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBAAA](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(2) Subtask 536178-000-002-001 - Remove the Fastener from Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBBAA Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBBAA](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(3) Subtask 536178-000-003-001 - Remove the Fastener from Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBCAA Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBCAA](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required	
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and

Non Aqueous Cleaner - General	08BAA9	As required	
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(4) Subtask 536178-000-004-001 - Remove the Fastener from Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBDAA Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fasteners:

Refer to [Fig. A-FBDAA](#)

In accordance with SRM 51-40-20

1 At hole H11:

1	Shim	Item (32)	Retain
1	Bolt	Item (30)	Discard
1	Nut	Item (31)	Discard

2 At hole H1:

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(5) Subtask 536178-000-005-001 - Remove the Fastener from Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBEAA Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBEAA](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(6) Subtask 536178-000-006-001 - Remove the Fastener from Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBFAA Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBFAA](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(7) Subtask 536178-000-007-001 - Remove the Fasteners from Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCAAA Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCAAA](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(8) Subtask 536178-000-008-001 - Remove the Fasteners from Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCBAA Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCBAA](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(9) Subtask 536178-000-009-001 - Remove the Fasteners from Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCCAA Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCCAA](#)

In accordance with SRM 51-40-20

7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(10) Subtask 536178-000-010-001 - Remove the Fasteners from Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	2.50
Minimum number of person	1
Subtask elapsed time	2.50
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCDAA Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fasteners and the support:

Refer to [Fig. A-FCDAA](#)

In accordance with SRM 51-40-20

1	Support	Item (20)	Retain
7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(11) Subtask 536178-000-011-001 - Remove the Fasteners from Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCEAA Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCEAA](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(12) Subtask 536178-000-012-001 - Remove the Fasteners from Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCFAA Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCFAA](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
----------------------------	--------	-------------

and

Non Aqueous Cleaner - General	08BAA9	As required
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(13) Subtask 536178-000-013-001 - Remove the Fasteners from Holes H8 and H9 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDAAA Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDAAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDAAA](#).

(c) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(14) Subtask 536178-000-014-001 - Remove the Fasteners from Holes H8 and H9 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDBAA Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDBAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDBAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(15) Subtask 536178-000-015-001 - Remove the Fasteners from Holes H9 and H10 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDCAA Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDCAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDCAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
 Cleaner - General

(16) Subtask 536178-000-016-001 - Remove the Fasteners from Holes H9 and H10 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDDAA Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDDAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDDAA](#).

(c) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(17) Subtask 536178-000-017-001 - Remove the Fasteners from Holes H8 and H9 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDEAA Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDEAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDEAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(18) Subtask 536178-000-018-001 - Remove the Fasteners from Holes H8 and H9 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDFAA Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDFAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDFAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(19) Subtask 536178-250-001-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFAAA Flowchart for the Hole H1 of Frame 41, LH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFAAA](#) and [Fig. A-FEAAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-001 001 Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-013 001 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-013 001 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):

a Do SUBTASK 536178-831-013 001 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (b).

4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):

a Do SUBTASK 536178-831-013 001 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (a).

(20) Subtask 536178-250-002-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFBAA Flowchart for the Hole H1 of Frame 42, LH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFBAA](#) and [Fig. A-FEBAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-002 001 Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-014 001 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-014 001 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-014 001 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-014 001 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (a).

(21) Subtask 536178-250-003-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFCAA Flowchart for the Hole H1 of Frame 43, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFCAA](#) and [Fig. A-FECAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-003 001 Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.
 - Refer to NTM 51-10-18 and NTM 51-10-01
 - Refer to [Fig. A-FECAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-015 001 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-015 001 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-015 001 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-015 001 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (a).

(22) Subtask 536178-250-004-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFDAA Flowchart for the Hole H1 of Frame 44, LH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFDAA](#) and [Fig. A-FEDAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-004 001 Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-016 001 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-016 001 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-016 001 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-016 001 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (a).

(23) Subtask 536178-250-005-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFEAA Flowchart for the Hole H1 of Frame 45, LH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFEAA](#) and [Fig. A-FEGAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-005 001 Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-017 001 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-017 001 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-017 001 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-017 001 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (a).

(24) Subtask 536178-250-006-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FFFAA Flowchart for the Hole H1 of Frame 46, LH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFFAA](#) and [Fig. A-FEFAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-006 001 Depending on the Inspection Result, Ream Hole H1 of Frame 46, LH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-018 001 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-018 001 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-018 001 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-018 001 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (a).

(25) Subtask 536178-250-007-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFMAA Flowchart for the Hole H2 to H7 from Frame 41, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFMAA](#) and [Fig. A-FEAAA](#)

- 1 If crack found:
 - a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-007 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side .
 - b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-001 001 Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side workstep (b).

2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-001 001 Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side workstep (a).

(26) Subtask 536178-250-008-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFNAA Flowchart for the Hole H2 to H7 from Frame 42, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFNAA](#) and [Fig. A-FEBAA](#)

- 1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-008 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-002 001 Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side workstep (b).

- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-002 001 Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side workstep (a).

(27) Subtask 536178-250-009-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFOAA Flowchart for the Hole H2 to H8 from Frame 43, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFOAA](#) and [Fig. A-FECAA](#)

1 If crack found:

a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-009 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

- f If crack removed and the current hole diameter \leq 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-003 001 Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-003 001 Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side workstep (a).

(28) Subtask 536178-250-010-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFPAA Flowchart for the Hole H2 to H8 from Frame 44, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFPAA](#) and [Fig. A-FEDAA](#)

- 1 If crack found:
 - a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-010 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side .

- b Do an eddy-current rotating probe testing of the holes H2 to H8.
Refer to NTM 51-10-18 and NTM 51-10-01
Refer to [Fig. A-FEDAA](#)
- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):
<1> Do workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
<1> Do the SUBTASK 536178-400-004 001 Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-004 001 Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side workstep (a).

(29) Subtask 536178-250-011-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FFQAA Flowchart for the Hole H2 to H7 from Frame 45, LH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFQAA](#) and [Fig. A-FEGAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-011 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-005 001 Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side workstep (b).

2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-005 001 Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side workstep (a).

(30) Subtask 536178-250-012-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFRAA Flowchart for the Hole H2 to H7 from Frame 46, LH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFRAA](#) and [Fig. A-FEFAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-012 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-006 001 Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-006 001 Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side workstep (a).

(31) Subtask 536178-250-013-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

- (a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:
 - 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
 - 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.

- (b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 41, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

1 If cracks found:

- a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

- a Do the SUBTASK 536178-831-019 001 Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side

(32) Subtask 536178-250-014-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

- (a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

- a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

- a Apply the instructions given in the following worksteps.

- (b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 42, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-020 001 Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side

(33) Subtask 536178-250-015-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 43, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

- a Do the SUBTASK 536178-831-021 001 Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side

(34) Subtask 536178-250-016-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:

1 If bush installed:

- a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

- a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 44, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

1 If cracks found:

- a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

- a Do the SUBTASK 536178-831-022 001 Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side

(35) Subtask 536178-250-017-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 45, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-023 001 Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side

(36) Subtask 536178-250-018-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

- 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 46, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

- 1 If cracks found:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no cracks found:
 - a Do the SUBTASK 536178-831-024 001 Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side

(37) Subtask 536178-831-001-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBAAA Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBAAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(38) Subtask 536178-831-002-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBBAA Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBBAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(39) Subtask 536178-831-003-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBCAA Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBCAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(40) Subtask 536178-831-004-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBDAA Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBDAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(41) Subtask 536178-831-005-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBEAA Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBEAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(42) Subtask 536178-831-006-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBFAA Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBFAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(43) Subtask 536178-831-007-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCAAA Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCAAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(44) Subtask 536178-831-008-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCBAA Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCBAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(45) Subtask 536178-831-009-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCCAA Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCCAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(46) Subtask 536178-831-010-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCDAA Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCDAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(47) Subtask 536178-831-011-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCEAA Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCEAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(48) Subtask 536178-831-012-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCFAA Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCFAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(49) Subtask 536178-831-013-001 - Install the Fastener on the Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Component COMPA01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBAAA Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBAAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1

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1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBAAA](#)

- 1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.
- 2 Clean the drilled area.
- 3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBAAA](#)

1	Bush	A5381278720600	Item 2
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- 4 Ream the hole on the bush Item 2 to the applicable fastener diameter in accordance with SRM 51-40-40 (transition fit).
- 5 Temporarily put in position the shim Item 1.
- 6 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.
- 7 Clean the drilled area.
- 8 Install the fastener in transition fit:

Refer to [Fig. A-FBAAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K4-8	Item 10
1	Nut	ASNA2529-4	Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

- (c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBAAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(50) Subtask 536178-831-014-001 - Install the Fastener on the Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Component COMPA03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44

References	
Fig. A-FBBAA Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAA](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBBAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X7	Item 8

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1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAA](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBBAA](#)

1	Bush	A5381278720600	Item 2
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4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBBAA](#)

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K4-8	Item 10
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1	Nut	ASNA2529-4	Item 11
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NOTE: If spotfacing necessary, contact AIRBUS.

(c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAA](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBBAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1

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1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4

NOTE: If spotfacing necessary, contact AIRBUS.

(51) Subtask 536178-831-015-001 - Install the Fastener on the Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Component COMPA05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
11	ASNA2529-4	1	NUT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
36	A5381278720200	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBCAA Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAA](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBCAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Shim A5381309320000 Item 1

1 Bolt EN6115K5X7 Item 8

1 Nut ASNA2529-5 Item 6

or

1 Shim A5381309320000 Item 1

1 Bolt EN6115K5-7 Item 9

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAA](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBCAA](#)

1 Bush A5381278720200 Item 36

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBCAA](#)

1 Shim A5381309320000 Item 1

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1 Bolt EN6115K4-9 Item 38

1 Nut ASNA2529-4 Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAA](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBCAA](#)

1 Shim A5381309320000 Item 1

1 Bolt EN6115K6-7 Item 3

1 Nut ASNA2529-6 Item 4

or

1 Shim A5381309320000 Item 1

1 Bolt EN6115K5Y8 Item 5

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

or

1 Shim A5381309320000 Item 1

1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(52) Subtask 536178-831-016-001 - Install the Fastener on the Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Component COMPA07				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
21	EN6115K4-11	1	BOLT	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	
24	EN6115K5X9	1	BOLT	
25	EN6115K5-9	1	BOLT	
30	ASNA2027V4-8	1	BOLT	
31	NSA5075-8	1	NUT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

Component COMPA15				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
20	A2521327620000	1	SUPPORT	
32	A2521326620200	1	SHIM	

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

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Paste Adhesive - Epoxy Potting Structure	13FBB2	As required	

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBDAA Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAA](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBDAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Temporarily put in position the support Item (20).
 - 3 Mark the position of the holes H1 and H2 on the support Item (20).
 - 4 Drill the holes on the support Item (20) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).
- Refer to [Fig. A-FBDAA](#)
- 5 Temporarily put in position the shim Item 1.
 - 6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
 - 7 Clean the drilled area.
 - 8 Install the support:

Refer to [Fig. A-FBDAA](#)

1	Support	Item (20)	Retained at removal
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with:

1	Shim	Item (32)	Retained at removal
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1	Bolt	ASNA2027V4-8	Item 30
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1	Nut	NSA5075-8	Item 31
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NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
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and at hole H1:

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K6-9	Item 22
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1	Nut	ASNA2529-6	Item 4
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or

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K5Y10	Item 23
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1	Nut	ASNA2529-5	Item 6
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1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X9	Item 24
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-9	Item 25
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAA](#)

1 If hole diameter H1 of the support Item (20) is greater than 6.35 mm (0.25 in):

a Discard the retained support Item (20).

2 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

3 Clean the drilled area.

4 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBDAA](#)

1	Bush	A5381278720400	Item 37
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5 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

6 Temporarily put in position the support Item (20) or 20.

If the support has been discard, use:

1	Support	A2521327620000	Item 20
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7 Mark the position of the holes H1 and H2 on the support Item (20) or 20.

8 Drill the holes on the support Item (20) or 20 to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAA](#)

9 Temporarily put in position the shim Item 1.

10 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

11 Clean the drilled area.

12 Install the support:

Refer to [Fig. A-FBDAA](#)

1	Support	Item (20)	Retained at removal
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If the support Item (20) has been discard:

1	Support	A2521327620000	Item 20
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with:

At Hole 11:

1	Shim	Item (32)	Retained at removal
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If the support Item (20) has been discard:

1	Shim	A2521326620200	Item 32
---	------	----------------	---------

1	Bolt	ASNA2027V4-8	Item 30
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1	Nut	NSA5075-8	Item 31
---	-----	-----------	---------

NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
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and at hole H1:

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K4-11	Item 21
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1	Nut	ASNA2529-4	Item 11
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NOTE: If spotfacing necessary, contact AIRBUS.

(c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAA](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBDAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the support Item (20).

3 Mark the position of the holes H1 and H2 on the support Item (20).

4 Drill the holes on the support Item (20) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAA](#)

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the support:

Refer to [Fig. A-FBDAA](#)

1	Support	Item (20)	Retained at removal
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with:

1	Shim	Item (32)	Retained at removal
---	------	-----------	---------------------

1	Bolt	ASNA2027V4-8	Item 30
---	------	--------------	---------

1	Nut	NSA5075-8	Item 31
---	-----	-----------	---------

NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
--	--------	-------------

and at hole H1:

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X9	Item 24
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-9	Item 25
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(53) Subtask 536178-831-017-001 - Install the Fastener on the Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Component COMPA09				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBEAA Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAA](#)

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Temporarily put in position the shim Item 1.
- 3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

- 4 Clean the drilled area.

- 5 Install the fastener with high interference:

Refer to [Fig. A-FBEAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAA](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBEAA](#)

1	Bush	A5381278720400	Item 37
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4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBEAA](#)

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K4-9	Item 38
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1	Nut	ASNA2529-4	Item 11
---	-----	------------	---------

NOTE: If spotfacing necessary, contact AIRBUS.

- (c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAA](#)

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Temporarily put in position the shim Item 1.
- 3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 4 Clean the drilled area.
- 5 Install the fastener with high interference:

Refer to [Fig. A-FBEAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(54) Subtask 536178-831-018-001 - Install the Fastener on the Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Component COMPA11				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44

References	
Fig. A-FBFAA Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAA](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBFAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6

or

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAA](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBFAA](#)

1	Bush	A5381278720400	Item 37
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4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in clearance fit:

Refer to [Fig. A-FBFAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K4-9	Item 38
1	Nut	ASNA2529-4	Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAA](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBFAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1

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1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(55) Subtask 536178-400-001-001 - Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
8	EN6115K5X7	5	BOLT	
9	EN6115K5-7	5	BOLT	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001

References	
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCAAA Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCAAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAA](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X7	Item 8

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5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack removed and the current hole diameter < 9.40 mm (0.370 in):

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig.](#)

[A-FCAAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAA](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X7	Item 8
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		

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1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(56) Subtask 536178-400-002-001 - Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
8	EN6115K5X7	5	BOLT	
9	EN6115K5-7	5	BOLT	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCBAA Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCBAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCBAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCBAA](#)

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5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X7	Item 8
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12

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1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCBAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCBAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCBAA](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39

5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X7	Item 8
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Bolt EN6115K5X6 Item 14

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(57) Subtask 536178-400-003-001 - Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
8	EN6115K5X7	5	BOLT	
9	EN6115K5-7	5	BOLT	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCCAA Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCCAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAA](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		

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5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X7	Item 8
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCCAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAA](#)

5 Bolt EN6115K6Y8 Item 43

5 Nut ASNA2529-6 Item 4

5 Washer NSA5368-616B Item 46
or

5 Bolt EN6115K6X7 Item 39

5 Nut ASNA2529-6 Item 4
or

5 Bolt EN6115K6-7 Item 3

5 Nut ASNA2529-6 Item 4
or

5 Bolt EN6115K5Y8 Item 5

5 Nut ASNA2529-5 Item 6

5 Washer NSA5368-516B Item 7
or

5 Bolt EN6115K5X7 Item 8

SERVICE BULLETIN

5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(58) Subtask 536178-400-004-001 - Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	3.50
Minimum number of person	1
Subtask elapsed time	3.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA07				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	7	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	7	NUT	
7	NSA5368-516B	7	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
19	EN6115K5-8	5	BOLT	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	
24	EN6115K5X9	1	BOLT	
25	EN6115K5-9	1	BOLT	
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
28	EN6115K5X8	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
41	EN6115K6X9	1	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
45	EN6115K6Y10	1	BOLT	
46	NSA5368-616B	7	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001

References	
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCDA Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCDA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDA](#)

1	Bolt	EN6115K6Y10	Item 45
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X9	Item 41
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6

1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X9	Item 24
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-9	Item 25
1	Nut	ASNA2529-5	Item 6
	and		
5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X8	Item 28
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-8	Item 19
5	Nut	ASNA2529-5	Item 6
	and		

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1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCDA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDA](#)

1	Bolt	EN6115K6Y10	Item 45
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X9	Item 41
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X9	Item 24
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-9	Item 25
1	Nut	ASNA2529-5	Item 6
	and		
5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40

5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X8	Item 28
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-8	Item 19
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6

or

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(59) Subtask 536178-400-005-001 - Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA09				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
19	EN6115K5-8	5	BOLT	
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
28	EN6115K5X8	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCEAA Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCEAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAA](#)

5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		

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5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X8	Item 28
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-8	Item 19
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCEAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAA](#)

5 Bolt EN6115K6Y9 Item 44

5 Nut ASNA2529-6 Item 4

5 Washer NSA5368-616B Item 46
or

5 Bolt EN6115K6X8 Item 40

5 Nut ASNA2529-6 Item 4
or

5 Bolt EN6115K6-8 Item 26

5 Nut ASNA2529-6 Item 4
or

5 Bolt EN6115K5Y9 Item 27

5 Nut ASNA2529-5 Item 6

5 Washer NSA5368-516B Item 7
or

5 Bolt EN6115K5X8 Item 28

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5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-8	Item 19
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(60) Subtask 536178-400-006-001 - Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA11				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	6	NUT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
19	EN6115K5-8	6	BOLT	
26	EN6115K6-8	6	BOLT	
27	EN6115K5Y9	6	BOLT	
28	EN6115K5X8	6	BOLT	
40	EN6115K6X8	6	BOLT	
44	EN6115K6Y9	6	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCFAA Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAA](#)

6	Bolt	EN6115K6Y9	Item 44
6	Nut	ASNA2529-6	Item 4
6	Washer	NSA5368-616B	Item 46
	or		
6	Bolt	EN6115K6X8	Item 40
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K6-8	Item 26
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K5Y9	Item 27
6	Nut	ASNA2529-5	Item 6
6	Washer	NSA5368-516B	Item 7
	or		
6	Bolt	EN6115K5X8	Item 28
6	Nut	ASNA2529-5	Item 6
	or		
6	Bolt	EN6115K5-8	Item 19
6	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAA](#)

6	Bolt	EN6115K6Y9	Item 44
6	Nut	ASNA2529-6	Item 4
6	Washer	NSA5368-616B	Item 46
	or		
6	Bolt	EN6115K6X8	Item 40
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K6-8	Item 26
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K5Y9	Item 27
6	Nut	ASNA2529-5	Item 6
6	Washer	NSA5368-516B	Item 7
	or		
6	Bolt	EN6115K5X8	Item 28
6	Nut	ASNA2529-5	Item 6
	or		
6	Bolt	EN6115K5-8	Item 19

6 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(61) Subtask 536178-831-019-001 - Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDAAA Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

References	
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDAAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDAAA](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or if hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install in transition fit:

Refer to [Fig. A-FDAAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDAAA](#)

SERVICE BULLETIN

1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X5	Item 17
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-5	Item 18
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or if hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fastener in transition fit:

Refer to [Fig. A-FDAAA](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(62) Subtask 536178-831-020-001 - Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDBAA Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDBAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAA](#)

1	Bolt	EN6115K6-7	Item 3
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1	Nut	ASNA2529-6	Item 4
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or

1	Bolt	EN6115K5Y8	Item 5
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1	Nut	ASNA2529-5	Item 6
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1	Washer	NSA5368-516B	Item 7
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or

1	Bolt	EN6115K5X7	Item 8
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1	Nut	ASNA2529-5	Item 6
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or

1	Bolt	EN6115K5-7	Item 9
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1	Nut	ASNA2529-5	Item 6
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NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDBAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAA](#)

1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Bolt EN6115K5X5 Item 17

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-5 Item 18

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAA](#)

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

1 Washer NSA5379-5W Item 47

(63) Subtask 536178-831-021-001 - Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDCAA Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02
Fig. A-FECA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDCAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAA](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDCAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAA](#)

1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

- or
- 1 Bolt EN6115K5X5 Item 17
- 1 Nut ASNA2529-5 Item 6
- or
- 1 Bolt EN6115K5-5 Item 18
- 1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAA](#)

- 1 Bolt EN6115K5-6 Item 15
- 1 Nut ASNA2529-5 Item 6
- 1 Washer NSA5379-5W Item 47

(64) Subtask 536178-831-022-001 - Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA07				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	3	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	2	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDDAA Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDDAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAA](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDDAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAA](#)

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

- or
- 1 Bolt EN6115K5X6 Item 14
- 1 Nut ASNA2529-5 Item 6
- or
- 1 Bolt EN6115K5-6 Item 15
- 1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAA](#)

- 1 Bolt EN6115K5-7 Item 9
- 1 Nut ASNA2529-5 Item 6
- 1 Washer NSA5379-5W Item 47

(65) Subtask 536178-831-023-001 - Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA09				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	2	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDEAA Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDEAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAA](#)

1	Bolt	EN6115K6-8	Item 26
---	------	------------	---------

1	Nut	ASNA2529-6	Item 4
---	-----	------------	--------

or

1	Bolt	EN6115K5Y9	Item 27
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
---	--------	--------------	--------

or

1	Bolt	EN6115K5X8	Item 28
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

or

1	Bolt	EN6115K5-8	Item 19
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDEAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAA](#)

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

- or
- 1 Bolt EN6115K5X6 Item 14
- 1 Nut ASNA2529-5 Item 6
- or
- 1 Bolt EN6115K5-6 Item 15
- 1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAA](#)

- 1 Bolt EN6115K5-7 Item 9
- 1 Nut ASNA2529-5 Item 6
- 1 Washer NSA5379-5W Item 47

(66) Subtask 536178-831-024-001 - Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA11				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	4	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	2	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDFAA Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDFAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAA](#)

1	Bolt	EN6115K6-8	Item 26
---	------	------------	---------

1	Nut	ASNA2529-6	Item 4
---	-----	------------	--------

or

1	Bolt	EN6115K5Y9	Item 27
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
---	--------	--------------	--------

or

1	Bolt	EN6115K5X8	Item 28
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

or

1	Bolt	EN6115K5-8	Item 19
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDFAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAA](#)

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

- or
- 1 Bolt EN6115K5X6 Item 14
- 1 Nut ASNA2529-5 Item 6
- or
- 1 Bolt EN6115K5-6 Item 15
- 1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAA](#)

- 1 Bolt EN6115K5-7 Item 9
- 1 Nut ASNA2529-5 Item 6
- 1 Washer NSA5379-5W Item 47

(67) Subtask 536178-800-001 - Apply Protective Treatment to the Work Area at Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBAAA Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCAAA Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02
Fig. A-FDAAA Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBAAA](#), [Fig. A-FCAAA](#) and [Fig. A-FDAAA](#)

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
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and apply finish:

Top Coat Polyurethane - Grey Internal Structure	04JME4	As required
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(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(68) Subtask 536178-800-002-001 - Apply Protective Treatment to the Work Area at Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBBAA Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCBAA Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02
Fig. A-FDBAA Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBBAA](#), [Fig. A-FBBAA](#) and [Fig. A-FCBAA](#)

SERVICE BULLETIN

Primer 04EAC2 As required
 Polyurethane Paint
 - Corrosion
 Inhibiting

and apply finish:

Top Coat 04JME4 As required
 Polyurethane - Grey
 Internal Structure

(b) Apply on the work area below the floor level:

Corrosion 12ABC1 As required
 Preventive
 Compound-Water
 Displacing

(69) Subtask 536178-800-003-001 - Apply Protective Treatment to the Work Area at Frame 43, LH Side

Work Zones and Access Panels			
Zone	Access/Work location		
241	Work location	Frame 43	

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBCAA Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

References	
Fig. A-FCCAA Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02
Fig. A-FDCAA Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBCAA](#), [Fig. A-FBCAA](#) and [Fig. A-FCCAA](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion		
Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey		
Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion	12ABC1	As required
Preventive		
Compound-Water		
Displacing		

(70) Subtask 536178-800-004-001 - Apply Protective Treatment to the Work Area at Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBDAA Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCDAA Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02 Sheet 03
Fig. A-FDDAA Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBDAA](#), [Fig. A-FCDAA](#) and [Fig. A-FDDAA](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(71) Subtask 536178-800-005-001 - Apply Protective Treatment to the Work Area at Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBEAA Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCEAA Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02
Fig. A-FDEAA Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBEAA](#), [Fig. A-FCEAA](#) and [Fig. A-FDEAA](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion Inhibiting		

and apply finish:

Top Coat 04JME4 As required
 Polyurethane - Grey
 Internal Structure

(b) Apply on the work area below the floor level:

Corrosion 12ABC1 As required
 Preventive
 Compound-Water
 Displacing

(72) Subtask 536178-800-006-001 - Apply Protective Treatment to the Work Area at Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBFAA Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCFAA Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02
Fig. A-FDFAA Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBFAA](#), [Fig. A-FCFAA](#) and [Fig. A-FDFAA](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(73) Subtask 536178-000-019-001 - Remove the Fastener from Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBAAA Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBAAA](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(74) Subtask 536178-000-020-001 - Remove the Fastener from Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBBAA Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBBAA](#)

In accordance with SRM 51-40-20

1 Bolt Item (3) Discard

1 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(75) Subtask 536178-000-021-001 - Remove the Fastener from Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBCAA Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBCAA](#)

In accordance with SRM 51-40-20

1 Bolt Item (3) Discard

1 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(76) Subtask 536178-000-022-001 - Remove the Fastener from Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBDAA Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fasteners:

Refer to [Fig. A-FBDAA](#)

In accordance with SRM 51-40-20

1 At hole H11:

1 Shim Item (32) Retain

1 Bolt Item (30) Discard

- 1 Nut Item (31) Discard
- 2 At hole H1:
- 1 Bolt Item (3) Discard
- 1 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(77) Subtask 536178-000-023-001 - Remove the Fastener from Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBEAA Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBEAA](#)

In accordance with SRM 51-40-20

- 1 Bolt Item (3) Discard
- 1 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(78) Subtask 536178-000-024-001 - Remove the Fastener from Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBFAA Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBFAA](#)

In accordance with SRM 51-40-20

- 1 Bolt Item (3) Discard
- 1 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(79) Subtask 536178-000-025-001 - Remove the Fasteners from Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCAAA Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCAAA](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(80) Subtask 536178-000-026-001 - Remove the Fasteners from Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCBAA Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCBAA](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(81) Subtask 536178-000-027-001 - Remove the Fasteners from Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCCAA Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCCAA](#)

In accordance with SRM 51-40-20

7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(82) Subtask 536178-000-028-001 - Remove the Fasteners from Holes H2 to H8 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	2.50
Minimum number of person	1
Subtask elapsed time	2.50
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCDA Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fasteners and the support:

Refer to [Fig. A-FCDA](#)

In accordance with SRM 51-40-20

1	Support	Item (20)	Retain
7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(83) Subtask 536178-000-029-001 - Remove the Fasteners from Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
Zone	Access/Work location		
242	Work location	Frame 45	

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCEAA Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCEAA](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(84) Subtask 536178-000-030-001 - Remove the Fasteners from Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCFAA Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCFAA](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(85) Subtask 536178-000-031-001 - Remove the Fasteners from Holes H8 and H9 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDAAA Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDAAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDAAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(86) Subtask 536178-000-032-001 - Remove the Fasteners from Holes H8 and H9 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDBAA Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDBAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDBAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(87) Subtask 536178-000-033-001 - Remove the Fasteners from Holes H9 and H10 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDCAA Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDCAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDCAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(88) Subtask 536178-000-034-001 - Remove the Fasteners from Holes H9 and H10 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDDAA Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDDAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDDAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(89) Subtask 536178-000-035-001 - Remove the Fasteners from Holes H8 and H9 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDEAA Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDEAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDEAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(90) Subtask 536178-000-036-001 - Remove the Fasteners from Holes H8 and H9 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDFAA Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDFAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDFAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(91) Subtask 536178-250-019-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFGAA Flowchart for the Hole H1 of Frame 41, RH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFGAA](#) and [Fig. A-FEAAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-025 001 Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-037 001 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-037 001 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-037 001 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-037 001 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (a).

(92) Subtask 536178-250-020-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFHAA Flowchart for the Hole H1 of Frame 42, RH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFHAA](#) and [Fig. A-FEBAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-026 001 Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-038 001 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-038 001 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-038 001 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-038 001 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (a).

(93) Subtask 536178-250-021-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFIA Flowchart for the Hole H1 of Frame 43, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFIA](#) and [Fig. A-FECA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-027 001 Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-039 001 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-039 001 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-039 001 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-039 001 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (a).

(94) Subtask 536178-250-022-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFJAA Flowchart for the Hole H1 of Frame 44, RH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFJAA](#) and [Fig. A-FEDAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-028 001 Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-040 001 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-040 001 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-040 001 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-040 001 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (a).

(95) Subtask 536178-250-023-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFKAA Flowchart for the Hole H1 of Frame 45, RH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFKAA](#) and [Fig. A-FEGAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-029 001 Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.
 - Refer to NTM 51-10-18 and NTM 51-10-01
 - Refer to [Fig. A-FEGAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-041 001 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-041 001 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-041 001 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-041 001 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (a).

(96) Subtask 536178-250-024-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FFLAA Flowchart for the Hole H1 of Frame 46, RH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFLAA](#) and [Fig. A-FEFAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-030 001 Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-042 001 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-042 001 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-042 001 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-042 001 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (a).

(97) Subtask 536178-250-025-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFSAA Flowchart for the Hole H2 to H7 from Frame 41, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFSAA](#) and [Fig. A-FEAAA](#)

- 1 If crack found:
 - a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-031 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side .
 - b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-007 001 Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side workstep (b).

2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-007 001 Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side workstep (a).

(98) Subtask 536178-250-026-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFTAA Flowchart for the Hole H2 to H7 from Frame 42, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFTAA](#) and [Fig. A-FEBAA](#)

- 1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-032 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-008 001 Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side workstep (b).

- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-008 001 Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side workstep (a).

(99) Subtask 536178-250-027-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFUAA Flowchart for the Hole H2 to H8 from Frame 43, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFUAA](#) and [Fig. A-FECAA](#)

1 If crack found:

a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-033 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

- f If crack removed and the current hole diameter \leq 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-009 001 Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-009 001 Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side workstep (a).

(100)Subtask 536178-250-028-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFVAA Flowchart for the Hole H2 to H8 from Frame 44, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFVAA](#) and [Fig. A-FEDAA](#)

- 1 If crack found:
 - a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-034 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side .

- b Do an eddy-current rotating probe testing of the holes H2 to H8.
Refer to NTM 51-10-18 and NTM 51-10-01
Refer to [Fig. A-FEDAA](#)
- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):
<1> Do workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
<1> Do the SUBTASK 536178-400-010 001 Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
a Do the SUBTASK 536178-400-010 001 Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side workstep (a).

(101)Subtask 536178-250-029-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FFWAA Flowchart for the Hole H2 to H7 from Frame 45, RH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFWAA](#) and [Fig. A-FEGAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-035 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-011 001 Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side workstep (b).

2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-011 001 Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side workstep (a).

(102)Subtask 536178-250-030-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFXAA Flowchart for the Hole H2 to H7 from Frame 46, RH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFXAA](#) and [Fig. A-FEFAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-036 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-012 001 Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-012 001 Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side workstep (a).

(103)Subtask 536178-250-031-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

- (a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:
 - 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
 - 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.

- (b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 41, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-043 001 Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side

(104)Subtask 536178-250-032-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

- (a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

- (b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 42, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-044 001 Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side

(105)Subtask 536178-250-033-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 43, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

- a Do the SUBTASK 536178-831-045 001 Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side

(106)Subtask 536178-250-034-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:

1 If bush installed:

- a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

- a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 44, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

1 If cracks found:

- a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

- a Do the SUBTASK 536178-831-046 001 Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side

(107)Subtask 536178-250-035-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

- (a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:
 - 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
 - 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.
- (b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 45, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

- 1 If cracks found:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no cracks found:
 - a Do the SUBTASK 536178-831-047 001 Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side

(108)Subtask 536178-250-036-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

- (a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:
 - 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
 - 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.
- (b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 46, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

- 1 If cracks found:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no cracks found:
 - a Do the SUBTASK 536178-831-048 001 Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side

(109)Subtask 536178-831-025-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBAAA Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS GREATER THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBAAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(110)Subtask 536178-831-026-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBBAA Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBBAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(111)Subtask 536178-831-027-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBCAA Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBCAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(112)Subtask 536178-831-028-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBDAA Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBDAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(113)Subtask 536178-831-029-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBEAA Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBEAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(114)Subtask 536178-831-030-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBFAA Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBFAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(115)Subtask 536178-831-031-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCAAA Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCAAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(116)Subtask 536178-831-032-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCBAA Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCBAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(117)Subtask 536178-831-033-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCCAA Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCCAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(118)Subtask 536178-831-034-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCDA Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCDA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(119)Subtask 536178-831-035-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCEAA Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCEAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(120)Subtask 536178-831-036-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCFAA Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCFAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(121)Subtask 536178-831-037-001 - Install the Fastener on the Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Component COMPA01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBAAA Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBAAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1

SERVICE BULLETIN

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBAAA](#)

- 1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.
- 2 Clean the drilled area.
- 3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBAAA](#)

1	Bush	A5381278720600	Item 2
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- 4 Ream the hole on the bush Item 2 to the applicable fastener diameter in accordance with SRM 51-40-40 (transition fit).
- 5 Temporarily put in position the shim Item 1.
- 6 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.
- 7 Clean the drilled area.
- 8 Install the fastener in transition fit:

Refer to [Fig. A-FBAAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K4-8	Item 10
1	Nut	ASNA2529-4	Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

- (c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Temporarily put in position the shim Item 1.

- 4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

- 5 Clean the drilled area.

- 6 Install the fastener with high interference:

Refer to [Fig. A-FBAAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(122)Subtask 536178-831-038-001 - Install the Fastener on the Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Component COMPA03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44

References	
Fig. A-FBBAA Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAA](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBBAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X7	Item 8

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1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAA](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBBAA](#)

1	Bush	A5381278720600	Item 2
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4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBBAA](#)

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K4-8	Item 10
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1	Nut	ASNA2529-4	Item 11
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NOTE: If spotfacing necessary, contact AIRBUS.

(c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAA](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBBAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1

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1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4

NOTE: If spotfacing necessary, contact AIRBUS.

(123)Subtask 536178-831-039-001 - Install the Fastener on the Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Component COMPA05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
11	ASNA2529-4	1	NUT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
36	A5381278720200	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBCAA Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAA](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBCAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Shim A5381309320000 Item 1

1 Bolt EN6115K5X7 Item 8

1 Nut ASNA2529-5 Item 6

or

1 Shim A5381309320000 Item 1

1 Bolt EN6115K5-7 Item 9

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAA](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBCAA](#)

1 Bush A5381278720200 Item 36

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBCAA](#)

1 Shim A5381309320000 Item 1

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1 Bolt EN6115K4-9 Item 38

1 Nut ASNA2529-4 Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAA](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBCAA](#)

1 Shim A5381309320000 Item 1

1 Bolt EN6115K6-7 Item 3

1 Nut ASNA2529-6 Item 4

or

1 Shim A5381309320000 Item 1

1 Bolt EN6115K5Y8 Item 5

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

or

1 Shim A5381309320000 Item 1

1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(124)Subtask 536178-831-040-001 - Install the Fastener on the Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Component COMPA07				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
21	EN6115K4-11	1	BOLT	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	
24	EN6115K5X9	1	BOLT	
25	EN6115K5-9	1	BOLT	
30	ASNA2027V4-8	1	BOLT	
31	NSA5075-8	1	NUT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

Component COMPA15				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
29	A2521327620100	1	SUPPORT	
32	A2521326620200	1	SHIM	

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

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Paste Adhesive - Epoxy Potting Structure	13FBB2	As required	

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBDAA Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAA](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBDAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Temporarily put in position the support Item (29).
- 3 Mark the position of the holes H1 and H2 on the support Item (29).
- 4 Drill the holes on the support Item (29) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAA](#)

- 5 Temporarily put in position the shim Item 1.
- 6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 7 Clean the drilled area.
- 8 Install the support:

Refer to [Fig. A-FBDAA](#)

1	Support	Item (29)	Retained at removal
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with:

1	Shim	Item (32)	Retained at removal
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1	Bolt	ASNA2027V4-8	Item 30
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1	Nut	NSA5075-8	Item 31
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NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
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and at hole H1:

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K6-9	Item 22
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1	Nut	ASNA2529-6	Item 4
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or

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K5Y10	Item 23
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1	Nut	ASNA2529-5	Item 6
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1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X9	Item 24
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-9	Item 25
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAA](#)

1 If hole diameter H1 of the support Item (29) is greater than 6.35 mm (0.25 in):

a Discard the retained support Item (29).

2 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

3 Clean the drilled area.

4 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBDAA](#)

1	Bush	A5381278720400	Item 37
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5 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

6 Temporarily put in position the support Item (29) or 29.

If the support has been discard, use:

1	Support	A2521327620100	Item 29
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7 Mark the position of the holes H1 and H2 on the support Item (29) or 29.

8 Drill the holes on the support Item (29) or 29 to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAA](#)

9 Temporarily put in position the shim Item 1.

10 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

11 Clean the drilled area.

12 Install the support:

Refer to [Fig. A-FBDAA](#)

1	Support	Item (29)	Retained at removal
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If the support Item (29) has been discard:

1	Support	A2521327620100	Item 29
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with:

At Hole 11:

1	Shim	Item (32)	Retained at removal
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If the support Item (29) has been discard:

1	Shim	A2521326620200	Item 32
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1	Bolt	ASNA2027V4-8	Item 30
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1	Nut	NSA5075-8	Item 31
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NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
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and at hole H1:

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K4-11	Item 21
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1	Nut	ASNA2529-4	Item 11
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NOTE: If spotfacing necessary, contact AIRBUS.

(c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAA](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBDAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the support Item (29).

3 Mark the position of the holes H1 and H2 on the support Item (29).

4 Drill the holes on the support Item (29) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAA](#)

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the support:

Refer to [Fig. A-FBDAA](#)

1	Support	Item (29)	Retained at removal
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with:

1	Shim	Item (32)	Retained at removal
---	------	-----------	---------------------

1	Bolt	ASNA2027V4-8	Item 30
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1	Nut	NSA5075-8	Item 31
---	-----	-----------	---------

NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
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and at hole H1:

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X9	Item 24
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-9	Item 25
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(125)Subtask 536178-831-041-001 - Install the Fastener on the Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Component COMPA09				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBEAA Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAA](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBEAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAA](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBEAA](#)

1	Bush	A5381278720400	Item 37
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4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBEAA](#)

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K4-9	Item 38
---	------	------------	---------

1	Nut	ASNA2529-4	Item 11
---	-----	------------	---------

NOTE: If spotfacing necessary, contact AIRBUS.

- (c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAA](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBEAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(126)Subtask 536178-831-042-001 - Install the Fastener on the Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Component COMPA11				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44

References	
Fig. A-FBFAA Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAA](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBFAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6

or

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAA](#)

- 1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.
- 2 Clean the drilled area.
- 3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBFAA](#)

1	Bush	A5381278720400	Item 37
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- 4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).
- 5 Temporarily put in position the shim Item 1.
- 6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 7 Clean the drilled area.
- 8 Install the fasteners in clearance fit:

Refer to [Fig. A-FBFAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K4-9	Item 38
1	Nut	ASNA2529-4	Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAA](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBFAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1

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1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(127)Subtask 536178-400-007-001 - Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
8	EN6115K5X7	5	BOLT	
9	EN6115K5-7	5	BOLT	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001

References	
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCAAA Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCAAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAA](#)

a At Hole H2 to H5, and H7:

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		

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5	Bolt	EN6115K5X7	Item 8
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6
	<u>b</u> At hole H6:		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack removed and the current hole diameter < 9.40 mm (0.370 in):

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCAAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAA](#)

a At Hole H2 to H5, and H7:

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X7	Item 8
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6

b At hole H6:

1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(128)Subtask 536178-400-008-001 - Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
8	EN6115K5X7	5	BOLT	
9	EN6115K5-7	5	BOLT	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCBAA Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCBAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCBAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCBAA](#)

5 Bolt EN6115K6Y8 Item 43

5 Nut ASNA2529-6 Item 4

5 Washer NSA5368-616B Item 46

or

5 Bolt EN6115K6X7 Item 39

5 Nut ASNA2529-6 Item 4

or

5 Bolt EN6115K6-7 Item 3

5 Nut ASNA2529-6 Item 4

or

5 Bolt EN6115K5Y8 Item 5

5 Nut ASNA2529-5 Item 6

5 Washer NSA5368-516B Item 7

or

5 Bolt EN6115K5X7 Item 8

5 Nut ASNA2529-5 Item 6

or

5 Bolt EN6115K5-7 Item 9

5 Nut ASNA2529-5 Item 6

and

1 Bolt EN6115K6Y7 Item 42

1 Nut ASNA2529-6 Item 4

1 Washer NSA5368-616B Item 46

or

1 Bolt EN6115K6X6 Item 38

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1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCBAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCBAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCBAA](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4

5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X7	Item 8
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		

SERVICE BULLETIN

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(129)Subtask 536178-400-009-001 - Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
8	EN6115K5X7	5	BOLT	
9	EN6115K5-7	5	BOLT	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
38	EN6115K6X6	1	BOLT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCCAA Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCCAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAA](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4

		or		
5	Bolt		EN6115K6-7	Item 3
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K5Y8	Item 5
5	Nut		ASNA2529-5	Item 6
5	Washer		NSA5368-516B	Item 7
		or		
5	Bolt		EN6115K5X7	Item 8
5	Nut		ASNA2529-5	Item 6
		or		
5	Bolt		EN6115K5-7	Item 9
5	Nut		ASNA2529-5	Item 6
		and		
1	Bolt		EN6115K6Y7	Item 42
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X6	Item 38
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-6	Item 12
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y7	Item 13
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7
		or		

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1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCCAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAA](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5

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5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X7	Item 8
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(130)Subtask 536178-400-010-001 - Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	3.50
Minimum number of person	1
Subtask elapsed time	3.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA07				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	7	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	7	NUT	
7	NSA5368-516B	7	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
19	EN6115K5-8	5	BOLT	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	
24	EN6115K5X9	1	BOLT	
25	EN6115K5-9	1	BOLT	
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
28	EN6115K5X8	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
41	EN6115K6X9	1	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
45	EN6115K6Y10	1	BOLT	
46	NSA5368-616B	7	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001

References	
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCDA Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCDA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDA](#)

1	Bolt	EN6115K6Y10	Item 45
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X9	Item 41
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6

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1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X9	Item 24
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-9	Item 25
1	Nut	ASNA2529-5	Item 6
	and		
5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X8	Item 28
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-8	Item 19
5	Nut	ASNA2529-5	Item 6
	and		

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1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCDA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDA](#)

1	Bolt	EN6115K6Y10	Item 45
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X9	Item 41
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X9	Item 24
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-9	Item 25
1	Nut	ASNA2529-5	Item 6
	and		
5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40

5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X8	Item 28
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-8	Item 19
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Bolt EN6115K5X7 Item 8

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-7 Item 9

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(131)Subtask 536178-400-011-001 - Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA09				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
19	EN6115K5-8	5	BOLT	
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
28	EN6115K5X8	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCEAA Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCEAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAA](#)

5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		

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5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X8	Item 28
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-8	Item 19
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCEAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAA](#)

5 Bolt EN6115K6Y9 Item 44

5 Nut ASNA2529-6 Item 4

5 Washer NSA5368-616B Item 46
or

5 Bolt EN6115K6X8 Item 40

5 Nut ASNA2529-6 Item 4
or

5 Bolt EN6115K6-8 Item 26

5 Nut ASNA2529-6 Item 4
or

5 Bolt EN6115K5Y9 Item 27

5 Nut ASNA2529-5 Item 6

5 Washer NSA5368-516B Item 7
or

5 Bolt EN6115K5X8 Item 28

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5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-8	Item 19
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(132)Subtask 536178-400-012-001 - Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA11				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	6	NUT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
19	EN6115K5-8	6	BOLT	
26	EN6115K6-8	6	BOLT	
27	EN6115K5Y9	6	BOLT	
28	EN6115K5X8	6	BOLT	
40	EN6115K6X8	6	BOLT	
44	EN6115K6Y9	6	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCFAA Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAA](#)

6	Bolt	EN6115K6Y9	Item 44
6	Nut	ASNA2529-6	Item 4
6	Washer	NSA5368-616B	Item 46
	or		
6	Bolt	EN6115K6X8	Item 40
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K6-8	Item 26
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K5Y9	Item 27
6	Nut	ASNA2529-5	Item 6
6	Washer	NSA5368-516B	Item 7
	or		
6	Bolt	EN6115K5X8	Item 28
6	Nut	ASNA2529-5	Item 6
	or		
6	Bolt	EN6115K5-8	Item 19
6	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAA](#)

6	Bolt	EN6115K6Y9	Item 44
6	Nut	ASNA2529-6	Item 4
6	Washer	NSA5368-616B	Item 46
	or		
6	Bolt	EN6115K6X8	Item 40
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K6-8	Item 26
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K5Y9	Item 27
6	Nut	ASNA2529-5	Item 6
6	Washer	NSA5368-516B	Item 7
	or		
6	Bolt	EN6115K5X8	Item 28
6	Nut	ASNA2529-5	Item 6
	or		
6	Bolt	EN6115K5-8	Item 19

6 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(133)Subtask 536178-831-043-001 - Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDAAA Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

References	
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDAAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDAAA](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or if hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install in transition fit:

Refer to [Fig. A-FDAAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDAAA](#)

1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X5	Item 17
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-5	Item 18
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or if hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fastener in transition fit:

Refer to [Fig. A-FDAAA](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(134)Subtask 536178-831-044-001 - Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDBAA Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDBAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAA](#)

1	Bolt	EN6115K6-7	Item 3
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1	Nut	ASNA2529-6	Item 4
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or

1	Bolt	EN6115K5Y8	Item 5
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1	Nut	ASNA2529-5	Item 6
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1	Washer	NSA5368-516B	Item 7
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or

1	Bolt	EN6115K5X7	Item 8
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1	Nut	ASNA2529-5	Item 6
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or

1	Bolt	EN6115K5-7	Item 9
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1	Nut	ASNA2529-5	Item 6
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NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If $(\text{edge distance}) / (\text{hole diameter} + 0.8 \text{ mm}) \geq 1.30$ and the hole diameter $\leq 7.92 \text{ mm}$ (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDBAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If $(\text{edge distance}) / (\text{hole diameter} + 1.6 \text{ mm}) \geq 1.27$:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAA](#)

1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Bolt EN6115K5X5 Item 17

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-5 Item 18

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAA](#)

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

1 Washer NSA5379-5W Item 47

(135)Subtask 536178-831-045-001 - Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDCAA Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02
Fig. A-FECA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDCAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAA](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If $(\text{edge distance}) / (\text{hole diameter} + 0.8 \text{ mm}) \geq 1.30$ and the hole diameter $\leq 7.92 \text{ mm}$ (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDCAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If $(\text{edge distance}) / (\text{hole diameter} + 1.6 \text{ mm}) \geq 1.27$:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAA](#)

1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Bolt EN6115K5X5 Item 17

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-5 Item 18

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAA](#)

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

1 Washer NSA5379-5W Item 47

(136)Subtask 536178-831-046-001 - Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA07				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	3	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	2	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDDAA Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDDAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAA](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDDAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAA](#)

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

- or
- 1 Bolt EN6115K5X6 Item 14
- 1 Nut ASNA2529-5 Item 6
- or
- 1 Bolt EN6115K5-6 Item 15
- 1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAA](#)

- 1 Bolt EN6115K5-7 Item 9
- 1 Nut ASNA2529-5 Item 6
- 1 Washer NSA5379-5W Item 47

(137)Subtask 536178-831-047-001 - Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA09				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	2	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDEAA Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDEAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAA](#)

1	Bolt	EN6115K6-8	Item 26
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1	Nut	ASNA2529-6	Item 4
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or

1	Bolt	EN6115K5Y9	Item 27
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
---	--------	--------------	--------

or

1	Bolt	EN6115K5X8	Item 28
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

or

1	Bolt	EN6115K5-8	Item 19
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDEAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAA](#)

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6

or

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAA](#)

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(138)Subtask 536178-831-048-001 - Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA11				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	2	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDFAA Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDFAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAA](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDFAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAA](#)

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6

or

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAA](#)

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(139)Subtask 536178-800-007-001 - Apply Protective Treatment to the Work Area at Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBAAA Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCAAA Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02
Fig. A-FDAAA Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBAAA](#), [Fig. A-FCAAA](#) and [Fig. A-FDAAA](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion	12ABC1	As required
Preventive		
Compound-Water		
Displacing		

(140)Subtask 536178-800-008-001 - Apply Protective Treatment to the Work Area at Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBBAA Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCBAA Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02
Fig. A-FDBAA Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBBAA](#), [Fig. A-FBBAA](#) and [Fig. A-FCBAA](#)

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
---	--------	-------------

and apply finish:

Top Coat Polyurethane - Grey Internal Structure	04JME4	As required
---	--------	-------------

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(141)Subtask 536178-800-009-001 - Apply Protective Treatment to the Work Area at Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10

References	
Fig. A-FBCAA Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCCAA Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02
Fig. A-FDCAA Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBCAA](#), [Fig. A-FBCAA](#) and [Fig. A-FCCAA](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion		
Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey		
Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion	12ABC1	As required
Preventive		
Compound-Water		
Displacing		

(142)Subtask 536178-800-010-001 - Apply Protective Treatment to the Work Area at Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBDAA Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCDAA Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02 Sheet 03
Fig. A-FDDAA Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBDAA](#), [Fig. A-FCDAA](#) and [Fig. A-FDDAA](#)

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
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and apply finish:

Top Coat Polyurethane - Grey Internal Structure	04JME4	As required
---	--------	-------------

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(143)Subtask 536178-800-011-001 - Apply Protective Treatment to the Work Area at Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBEAA Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCEAA Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02
Fig. A-FDEAA Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBEAA](#), [Fig. A-FCEAA](#) and [Fig. A-FDEAA](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey		
Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion	12ABC1	As required
Preventive		
Compound-Water		
Displacing		

(144)Subtask 536178-800-012-001 - Apply Protective Treatment to the Work Area at Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBFAA Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCFAA Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

References	
Fig. A-FDFAA Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBFAA](#), [Fig. A-FCFAA](#) and [Fig. A-FDFAA](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion		
Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey		
Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion	12ABC1	As required
Preventive		
Compound-Water		
Displacing		

****CONF 002**

(1) Subtask 536178-000-001-002 - Remove the Fastener from Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	

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

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBAAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBAAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
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1	Nut	Item (4)	Discard
---	-----	----------	---------

b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(2) Subtask 536178-000-002-002 - Remove the Fastener from Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBBAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBBAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
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1	Nut	Item (4)	Discard
---	-----	----------	---------

b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous 08BAA9 As required
Cleaner - General

(3) Subtask 536178-000-003-002 - Remove the Fastener from Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBCAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBCAB](#)

In accordance with SRM 51-40-20

- 1 Bolt Item (3) Discard
- 1 Nut Item (4) Discard

b Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(4) Subtask 536178-000-004-002 - Remove the Fastener from Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBDAB Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

- (a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBDAB](#)

- 1 If the frame foot is cut:

- a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fasteners:

Refer to [Fig. A-FBDAB](#)

In accordance with SRM 51-40-20

<1> At hole H11:

1	Shim	Item (32)	Retain
1	Bolt	Item (30)	Discard
1	Nut	Item (31)	Discard

<2> At hole H1:

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

b Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(5) Subtask 536178-000-005-002 - Remove the Fastener from Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBEAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBEAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
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1	Nut	Item (4)	Discard
---	-----	----------	---------

b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(6) Subtask 536178-000-006-002 - Remove the Fastener from Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBFAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBFAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
---	------	----------	---------

1	Nut	Item (4)	Discard
---	-----	----------	---------

b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(7) Subtask 536178-000-007-001 - Remove the Fasteners from Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCAAB](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(8) Subtask 536178-000-008-001 - Remove the Fasteners from Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCBAB](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(9) Subtask 536178-000-009-001 - Remove the Fasteners from Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCCAB](#)

In accordance with SRM 51-40-20

7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(10) Subtask 536178-000-010-003 - Remove the Fasteners from Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	2.50
Minimum number of person	1
Subtask elapsed time	2.50
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCDAB Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCDAB](#)

In accordance with SRM 51-40-20

7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(c) If the frame foot is not cut:

1 Remove the support:

1 Support Item (20) Retain

(11) Subtask 536178-000-011-001 - Remove the Fasteners from Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCEAB](#)

In accordance with SRM 51-40-20

6 Bolt Item (3) Discard

6 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(12) Subtask 536178-000-012-001 - Remove the Fasteners from Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCFAB](#)

In accordance with SRM 51-40-20

6 Bolt Item (3) Discard

6 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(13) Subtask 536178-000-013-002 - Remove the Fasteners from Holes H8 and H9 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDAAB Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDAAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDAAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(14) Subtask 536178-000-014-002 - Remove the Fasteners from Holes H8 and H9 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDBAB Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDBAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDBAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(15) Subtask 536178-000-015-002 - Remove the Fasteners from Holes H9 and H10 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDCAB Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDCAB](#)

In accordance with SRM 51-40-20

- 2 Bolt Item (3) Discard
- 2 Nut Item (4) Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDCAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(16) Subtask 536178-000-016-002 - Remove the Fasteners from Holes H9 and H10 of Frame 44, LH Side

Work Zones and Access Panels			
Zone	Access/Work location		
241	Work location	Frame 44	

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDDAB Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDDAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDDAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(17) Subtask 536178-000-017-002 - Remove the Fasteners from Holes H8 and H9 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20

References	
Fig. A-FDEAB Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDEAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDEAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(18) Subtask 536178-000-018-002 - Remove the Fasteners from Holes H8 and H9 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	

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

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDFAB Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Remove the Fasteners:

Refer to [Fig. A-FDFAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDFAB](#).

(c) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(19) Subtask 536178-250-001-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFAAA Flowchart for the Hole H1 of Frame 41, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFAAA](#) and [Fig. A-FEAAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-001 001 Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-013 002 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-013 002 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-013 002 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-013 002 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (a).

(20) Subtask 536178-250-002-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFBAA Flowchart for the Hole H1 of Frame 42, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFBAA](#) and [Fig. A-FEBAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-002 001 Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-014 002 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-014 002 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-014 002 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-014 002 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (a).

(21) Subtask 536178-250-003-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFCAA Flowchart for the Hole H1 of Frame 43, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFCAA](#) and [Fig. A-FECAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-003 001 Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-015 002 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-015 002 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-015 002 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-015 002 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (a).

(22) Subtask 536178-250-004-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFDAA Flowchart for the Hole H1 of Frame 44, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFDAA](#) and [Fig. A-FEDAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-004 001 Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-016 002 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-016 002 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-016 002 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-016 002 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (a).

(23) Subtask 536178-250-005-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FFEAA Flowchart for the Hole H1 of Frame 45, LH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFEAA](#) and [Fig. A-FEGAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-005 001 Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-017 002 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-017 002 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-017 002 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-017 002 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (a).

(24) Subtask 536178-250-006-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFFAA Flowchart for the Hole H1 of Frame 46, LH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFFAA](#) and [Fig. A-FEFAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-004 001 Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-018 002 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-018 002 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-018 002 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (b).
- 4 If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-018 002 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (a).

(25) Subtask 536178-250-007-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFMAA Flowchart for the Hole H2 to H7 from Frame 41, LH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFMAA](#) and [Fig. A-FEAAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-007 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-001 002 Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side workstep (b).

2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-001 002 Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side workstep (a).

(26) Subtask 536178-250-008-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFNAA Flowchart for the Hole H2 to H7 from Frame 42, LH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFNAA](#) and [Fig. A-FEBAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-008 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-002 002 Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-002 002 Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side workstep (a).

(27) Subtask 536178-250-009-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFOAA Flowchart for the Hole H2 to H8 from Frame 43, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFOAA](#) and [Fig. A-FECA](#)

- 1 If crack found:
 - a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-009 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side .
 - b Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)
 - c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.
 - d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.
 - e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.
 - f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-003 002 Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-003 002 Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side workstep (a).

(28) Subtask 536178-250-010-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFPAA Flowchart for the Hole H2 to H8 from Frame 44, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFPAA](#) and [Fig. A-FEDAA](#)

1 If crack found:

a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-010 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

- f If crack removed and the current hole diameter \leq 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-004 002 Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-004 002 Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side workstep (a).

(29) Subtask 536178-250-011-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFQAA Flowchart for the Hole H2 to H7 from Frame 45, LH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFQAA](#) and [Fig. A-FEGAA](#)

- 1 If crack found:
 - a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-011 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side .

- b Do an eddy-current rotating probe testing of the holes H2 to H7.
Refer to NTM 51-10-18 and NTM 51-10-01
Refer to [Fig. A-FEGAA](#)
- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):
<1> Do workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
<1> Do the SUBTASK 536178-400-005 002 Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-005 002 Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side workstep (a).

(30) Subtask 536178-250-012-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FFRAA Flowchart for the Hole H2 to H7 from Frame 46, LH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFRAA](#) and [Fig. A-FEFAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-012 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-006 002 Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side workstep (b).

2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-006 002 Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side workstep (a).

(31) Subtask 536178-250-013-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 41, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-019 002 Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side

(32) Subtask 536178-250-014-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

- 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 42, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

- 1 If cracks found:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no cracks found:
 - a Do the SUBTASK 536178-831-020 002 Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side

(33) Subtask 536178-250-015-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:

- 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 43, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECA](#)

- 1 If cracks found:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no cracks found:
 - a Do the SUBTASK 536178-831-021 002 Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side

(34) Subtask 536178-250-016-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:

- 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 44, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

- 1 If cracks found:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no cracks found:
 - a Do the SUBTASK 536178-831-022 002 Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side

(35) Subtask 536178-250-017-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

- (a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:
 - 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
 - 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.
- (b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 45, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

- 1 If cracks found:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no cracks found:
 - a Do the SUBTASK 536178-831-023 002 Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side

(36) Subtask 536178-250-018-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 46, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-024 002 Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side

(37) Subtask 536178-831-001-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBAAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(38) Subtask 536178-831-002-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBBAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(39) Subtask 536178-831-003-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBCAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(40) Subtask 536178-831-004-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBDAB Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBDAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(41) Subtask 536178-831-005-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBEAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(42) Subtask 536178-831-006-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBFAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(43) Subtask 536178-831-007-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCAAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(44) Subtask 536178-831-008-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCBAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(45) Subtask 536178-831-009-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCCAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(46) Subtask 536178-831-010-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCDAB Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCDAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(47) Subtask 536178-831-011-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCEAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(48) Subtask 536178-831-012-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCFAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(49) Subtask 536178-831-013-002 - Install the Fastener on the Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Component COMPA02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBAAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBAAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBAAB](#)

1	Bush	A5381278720600	Item 2
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4 Ream the hole on the bush Item 2 to the applicable fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBAAB](#)

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K4-8	Item 10
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1	Nut	ASNA2529-4	Item 11
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NOTE: If spotfacing necessary, contact AIRBUS.

- (e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAB](#). It must be as near the current hole diameter + 0.80

mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.
- 3 Temporarily put in position the shim Item 1.
- 4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.
- 5 Clean the drilled area.
- 6 Install the fastener with high interference:

Refer to [Fig. A-FBAAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(50) Subtask 536178-831-014-002 - Install the Fastener on the Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Component COMPA04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

- (a) If the fastener at hole H1 has not been removed:
 - 1 No further action required for the hole H1 only.
- (b) If the fastener at hole H1 has been removed:
 - 1 Apply the instruction given in the following steps.
- (c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):
 - Refer to AMM 20-21-12, Page Block 001
 - In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30
 - Refer to [Fig. A-FBBAB](#)

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.
- 3 Temporarily put in position the shim Item 1.
- 4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 5 Clean the drilled area.
- 6 Install the fastener with high interference:

Refer to [Fig. A-FBBAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAB](#)

- 1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.
- 2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBBAB](#)

1 Bush A5381278720600 Item 2

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBBAB](#)

1 Shim A5381309320000 Item 1

1 Bolt EN6115K4-8 Item 10

1 Nut ASNA2529-4 Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter ≤ 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBBAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(51) Subtask 536178-831-015-002 - Install the Fastener on the Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Component COMPA06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
36	A5381278720200	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAB](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBCAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBCAB](#)

1	Bush	A5381278720200	Item 36
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4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in clearance fit:

Refer to [Fig. A-FBCAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K4-9	Item 38
1	Nut	ASNA2529-4	Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBCAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6

1 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(52) Subtask 536178-831-016-002 - Install the Fastener on the Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Component COMPA08				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
21	EN6115K4-11	1	BOLT	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	
30	ASNA2027V4-8	1	BOLT	
31	NSA5075-8	1	NUT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

Component COMPA15				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
20	A2521327620000	1	SUPPORT	
32	A2521326620200	1	SHIM	

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

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Paste Adhesive - Epoxy Potting Structure	13FBB2	As required	

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBDAB Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

- (a) If the fastener at hole H1 has not been removed:
 - 1 No further action required for the hole H1 only.
- (b) If the fastener at hole H1 has been removed:
 - 1 Apply the instruction given in the following steps.
- (c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):
 - Refer to AMM 20-21-12, Page Block 001
 - Refer to AMM 20-21-12, Page Block 001
 - In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30
 - Refer to [Fig. A-FBDAB](#)
 - 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.
 - NOTE:** Find the final hole diameter in the fasteners table given in [Fig. A-FBDAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.
 - 2 Temporarily put in position the support Item (20).
 - 3 Mark the position of the holes H1 and H2 on the support Item (20).

4 Drill the holes on the support Item (20) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAB](#)

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the support:

Refer to [Fig. A-FBDAB](#)

1	Support	Item (20)	Retained at removal
---	---------	-----------	---------------------

with:

1	Shim	Item (32)	Retained at removal
---	------	-----------	---------------------

1	Bolt	ASNA2027V4-8	Item 30
---	------	--------------	---------

1	Nut	NSA5075-8	Item 31
---	-----	-----------	---------

NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
--	--------	-------------

and at hole H1:

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K6-9	Item 22
---	------	------------	---------

1	Nut	ASNA2529-6	Item 4
---	-----	------------	--------

or

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K5Y10	Item 23
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1	Nut	ASNA2529-5	Item 6
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1	Washer	NSA5368-516B	Item 7
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NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAB](#)

- 1 If hole diameter H1 of the support Item (20) is greater than 6.35 mm (0.25 in):
 - a Discard the retained support Item (20).
- 2 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.
- 3 Clean the drilled area.
- 4 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBDAB](#)

1 Bush A5381278720400 Item 37

- 5 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).
- 6 Temporarily put in position the support Item (20).

If the support has been discard, use:

1 Support A2521327620000 Item 20

- 7 Mark the position of the holes H1 and H2 on the support Item (20) or 20.
- 8 Drill the holes on the support Item (20) or 20 to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAB](#)

- 9 Temporarily put in position the shim Item 1.
- 10 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 11 Clean the drilled area.
- 12 Install the support:

Refer to [Fig. A-FBDAB](#)

1 Support Item (20) Retained at removal

If the support Item (20) has been discard:

1 Support A2521327620000 Item 20

with:

At Hole 11:

1 Shim Item (32) Retained at removal

If the support Item (20) has been discard:

1 Shim A2521326620200 Item 32

1 Bolt ASNA2027V4-8 Item 30

1 Nut NSA5075-8 Item 31

NOTE: Install the shim Item (32) with:

Paste Adhesive - 13FBB2 As required
Epoxy Potting
Structure

and at hole H1:

1 Shim A5381309320000 Item 1

1 Bolt EN6115K4-11 Item 21

1 Nut ASNA2529-4 Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBDAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the support Item (20).

3 Mark the position of the holes H1 and H2 on the support Item (20).

4 Drill the holes on the support Item (20) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAB](#)

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the support:

Refer to [Fig. A-FBDAB](#)

1	Support	Item (20)	Retained at removal
---	---------	-----------	---------------------

with:

1	Shim	Item (32)	Retained at removal
---	------	-----------	---------------------

1	Bolt	ASNA2027V4-8	Item 30
---	------	--------------	---------

1	Nut	NSA5075-8	Item 31
---	-----	-----------	---------

NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
--	--------	-------------

and at hole H1:

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K6-9	Item 22
---	------	------------	---------

1	Nut	ASNA2529-6	Item 4
---	-----	------------	--------

or

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K5Y10	Item 23
---	------	-------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
---	--------	--------------	--------

NOTE: If spotfacing necessary, contact AIRBUS.

(53) Subtask 536178-831-017-002 - Install the Fastener on the Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Component COMPA10				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAB](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBEAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBEAB](#)

1	Bush	A5381278720400	Item 37
---	------	----------------	---------

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBEAB](#)

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K4-9	Item 38
---	------	------------	---------

1	Nut	ASNA2529-4	Item 11
---	-----	------------	---------

NOTE: If spotfacing necessary, contact AIRBUS.

- (e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAB](#)

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Temporarily put in position the shim Item 1.
- 3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 4 Clean the drilled area.
- 5 Install the fastener with high interference:

Refer to [Fig. A-FBEAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(54) Subtask 536178-831-018-002 - Install the Fastener on the Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Component COMPA12				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

- (a) If the fastener at hole H1 has not been removed:
 - 1 No further action required for the hole H1 only.
- (b) If the fastener at hole H1 has been removed:
 - 1 Apply the instruction given in the following steps.
- (c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):
 - Refer to AMM 20-21-12, Page Block 001
 - In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAB](#)

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Temporarily put in position the shim Item 1.
- 3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 4 Clean the drilled area.
- 5 Install the fastener with high interference:

Refer to [Fig. A-FBFAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAB](#)

- 1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.
- 2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBFAB](#)

1 Bush A5381278720400 Item 37

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in clearance fit:

Refer to [Fig. A-FBFAB](#)

1 Shim A5381309320000 Item 1

1 Bolt EN6115K4-9 Item 38

1 Nut ASNA2529-4 Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter ≤ 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBFAB](#)

SERVICE BULLETIN

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(55) Subtask 536178-400-001-002 - Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Clean the drilled area.
- 3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAB](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7

		and		
1	Bolt		EN6115K6Y7	Item 42
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X6	Item 38
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-6	Item 12
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y7	Item 13
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack removed and the current hole diameter < 9.40 mm (0.370 in):

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCAAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAB](#)

5	Bolt		EN6115K6Y8	Item 43
5	Nut		ASNA2529-6	Item 4
5	Washer		NSA5368-616B	Item 46
		or		
5	Bolt		EN6115K6X7	Item 39

	5	Nut	ASNA2529-6	Item 4
		or		
	5	Bolt	EN6115K6-7	Item 3
	5	Nut	ASNA2529-6	Item 4
		or		
	5	Bolt	EN6115K5Y8	Item 5
	5	Nut	ASNA2529-5	Item 6
	5	Washer	NSA5368-516B	Item 7
		and		
	1	Bolt	EN6115K6Y7	Item 42
	1	Nut	ASNA2529-6	Item 4
	1	Washer	NSA5368-616B	Item 46
		or		
	1	Bolt	EN6115K6X6	Item 38
	1	Nut	ASNA2529-6	Item 4
		or		
	1	Bolt	EN6115K6-6	Item 12
	1	Nut	ASNA2529-6	Item 4
		or		
	1	Bolt	EN6115K5Y7	Item 13
	1	Nut	ASNA2529-5	Item 6
	1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(56) Subtask 536178-400-002-002 - Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	1	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig.](#)

A-FCBAB. It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCBAB](#)

1	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		

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1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCBAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCBAB](#)

1	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7

and

1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(57) Subtask 536178-400-003-002 - Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
7	NSA5368-516B	6	WASHER	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAB](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46

		or		
5	Bolt		EN6115K6X7	Item 39
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K6-7	Item 3
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K5Y8	Item 5
5	Nut		ASNA2529-5	Item 6
5	Washer		NSA5368-516B	Item 7
		and		
1	Bolt		EN6115K6Y7	Item 42
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X6	Item 38
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-6	Item 12
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y7	Item 13
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAB](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4

or

1 Bolt EN6115K6-6 Item 12

1 Nut ASNA2529-6 Item 4

or

1 Bolt EN6115K5Y7 Item 13

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(58) Subtask 536178-400-004-002 - Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	3.50
Minimum number of person	1
Subtask elapsed time	3.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA08				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	7	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	7	NUT	
7	NSA5368-516B	7	WASHER	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
41	EN6115K6X9	1	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
45	EN6115K6Y10	1	BOLT	
46	NSA5368-616B	7	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCDAB Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCDAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDAB](#)

1	Bolt	EN6115K6Y10	Item 45
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X9	Item 41
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		

1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	and		
5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		

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1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCDAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDAB](#)

1	Bolt	EN6115K6Y10	Item 45
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X9	Item 41
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

		and		
5	Bolt		EN6115K6Y9	Item 44
5	Nut		ASNA2529-6	Item 4
5	Washer		NSA5368-616B	Item 46
		or		
5	Bolt		EN6115K6X8	Item 40
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K6-8	Item 26
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K5Y9	Item 27
5	Nut		ASNA2529-5	Item 6
5	Washer		NSA5368-516B	Item 7
		and		
1	Bolt		EN6115K6Y8	Item 43
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X7	Item 39
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-7	Item 3
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y8	Item 5
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(59) Subtask 536178-400-005-002 - Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA10				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAB](#)

5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39

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1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAB](#)

5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26

5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(60) Subtask 536178-400-006-002 - Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA12				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	6	NUT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
26	EN6115K6-8	6	BOLT	
27	EN6115K5Y9	6	BOLT	
40	EN6115K6X8	6	BOLT	
44	EN6115K6Y9	6	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAB](#)

6	Bolt	EN6115K6Y9	Item 44
6	Nut	ASNA2529-6	Item 4

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6	Washer	NSA5368-616B	Item 46
	or		
6	Bolt	EN6115K6X8	Item 40
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K6-8	Item 26
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K5Y9	Item 27
6	Nut	ASNA2529-5	Item 6
6	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAB](#)

6	Bolt	EN6115K6Y9	Item 44
6	Nut	ASNA2529-6	Item 4
6	Washer	NSA5368-616B	Item 46
	or		
6	Bolt	EN6115K6X8	Item 40
6	Nut	ASNA2529-6	Item 4

or

6 Bolt EN6115K6-8 Item 26

6 Nut ASNA2529-6 Item 4

or

6 Bolt EN6115K5Y9 Item 27

6 Nut ASNA2529-5 Item 6

6 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(61) Subtask 536178-831-019-002 - Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001

References	
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDAAB Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDAAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or if hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fastener in transition fit:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDAAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDAAB](#)

SERVICE BULLETIN

1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X5	Item 17
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-5	Item 18
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or if hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(62) Subtask 536178-831-020-002 - Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDBAB Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAB](#)

1	Bolt	EN6115K6-7	Item 3
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1	Nut	ASNA2529-6	Item 4
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or

1	Bolt	EN6115K5Y8	Item 5
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1	Nut	ASNA2529-5	Item 6
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1	Washer	NSA5368-516B	Item 7
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NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAB](#)

1	Bolt	EN6115K5-8	Item 19
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1	Nut	ASNA2529-5	Item 6
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1 Washer NSA5379-5W Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAB](#)

1 Bolt EN6115K5Y6 Item 16

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

or

1 Bolt EN6115K5X5 Item 17

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-5 Item 18

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAB](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(63) Subtask 536178-831-021-002 - Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDCAB Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K5Y6	Item 16
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1	Nut	ASNA2529-5	Item 6
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1	Washer	NSA5368-516B	Item 7
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or

1	Bolt	EN6115K5X5	Item 17
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1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

or

1	Bolt	EN6115K5-5	Item 18
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1	Nut	ASNA2529-5	Item 6
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NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(64) Subtask 536178-831-022-002 - Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA08				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44

References	
Fig. A-FDDAB Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDDAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAB](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDDAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAB](#)

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

- or
- 1 Bolt EN6115K5X6 Item 14
- 1 Nut ASNA2529-5 Item 6
- or
- 1 Bolt EN6115K5-6 Item 15
- 1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- 3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:
 - a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
 - b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):
 - <1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame
 - <2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.
 - <3> Clean the drilled area.
 - <4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAB](#)

- 1 Bolt EN6115K5-7 Item 9
- 1 Nut ASNA2529-5 Item 6
- 1 Washer NSA5379-5W Item 47

(65) Subtask 536178-831-023-002 - Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA10				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDEAB Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAB](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

1 Washer NSA5379-5W Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAB](#)

1 Bolt EN6115K5Y7 Item 13

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

or

1 Bolt EN6115K5X6 Item 14

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- 3** If (edge distance) / (hole diameter + 1.6 mm) < 1.27:
- a** If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):
- <1> Contact AIRBUS before next flight and follow their instructions.
- b** If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):
- <1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame
- <2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.
- <3> Clean the drilled area.
- <4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAB](#)

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(66) Subtask 536178-831-024-002 - Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA12				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDFAB Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDFAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDFAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K5Y7	Item 13
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1	Nut	ASNA2529-5	Item 6
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1	Washer	NSA5368-516B	Item 7
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or

1	Bolt	EN6115K5X6	Item 14
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1	Nut	ASNA2529-5	Item 6
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or

1	Bolt	EN6115K5-6	Item 15
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1	Nut	ASNA2529-5	Item 6
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NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(67) Subtask 536178-800-001-001 - Apply Protective Treatment to the Work Area at Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02
Fig. A-FDAAB Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBAAB](#), [Fig. A-FCAAB](#) and [Fig. A-FDAAB](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(68) Subtask 536178-800-002-001 - Apply Protective Treatment to the Work Area at Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02
Fig. A-FDBAB Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBBAB](#), [Fig. A-FBBAB](#) and [Fig. A-FCBAB](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion		
Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey		
Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(69) Subtask 536178-800-003-001 - Apply Protective Treatment to the Work Area at Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02
Fig. A-FDCAB Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBCAB](#), [Fig. A-FBCAB](#) and [Fig. A-FCCAB](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(70) Subtask 536178-800-004-001 - Apply Protective Treatment to the Work Area at Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBDAB Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCDAB Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02
Fig. A-FDDAB Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBDAB](#), [Fig. A-FCDAB](#) and [Fig. A-FDDAB](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion Inhibiting		

and apply finish:

Top Coat 04JME4 As required
 Polyurethane - Grey
 Internal Structure

(b) Apply on the work area below the floor level:

Corrosion 12ABC1 As required
 Preventive
 Compound-Water
 Displacing

(71) Subtask 536178-800-005-001 - Apply Protective Treatment to the Work Area at Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02
Fig. A-FDEAB Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBEAB](#), [Fig. A-FCEAB](#) and [Fig. A-FDEAB](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(72) Subtask 536178-800-006-001 - Apply Protective Treatment to the Work Area at Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02
Fig. A-FDFAB Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBFAB](#), [Fig. A-FCFAB](#) and [Fig. A-FDFAB](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(73) Subtask 536178-000-019-002 - Remove the Fastener from Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBAAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.
and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBAAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
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1	Nut	Item (4)	Discard
---	-----	----------	---------

b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(74) Subtask 536178-000-020-002 - Remove the Fastener from Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBBAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBBAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

b Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(75) Subtask 536178-000-021-002 - Remove the Fastener from Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBCAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBCAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

b Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(76) Subtask 536178-000-022-002 - Remove the Fastener from Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBDAB Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBDAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fasteners:

Refer to [Fig. A-FBDAB](#)

In accordance with SRM 51-40-20

<1> At hole H11:

1	Shim	Item (32)	Retain
1	Bolt	Item (30)	Discard
1	Nut	Item (31)	Discard

<2> At hole H1:

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
----------------------------------	--------	-------------

(77) Subtask 536178-000-023-002 - Remove the Fastener from Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBEAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBEAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
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1	Nut	Item (4)	Discard
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b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous 08BAA9 As required
Cleaner - General

(78) Subtask 536178-000-024-002 - Remove the Fastener from Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBFAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBFAB](#)

In accordance with SRM 51-40-20

- 1 Bolt Item (3) Discard
- 1 Nut Item (4) Discard

b Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(79) Subtask 536178-000-025-001 - Remove the Fasteners from Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCAAB](#)

In accordance with SRM 51-40-20

- 6 Bolt Item (3) Discard
- 6 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(80) Subtask 536178-000-026-001 - Remove the Fasteners from Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCBAB](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(81) Subtask 536178-000-027-001 - Remove the Fasteners from Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCCAB](#)

In accordance with SRM 51-40-20

7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(82) Subtask 536178-000-028-002 - Remove the Fasteners from Holes H2 to H8 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	2.50
Minimum number of person	1
Subtask elapsed time	2.50
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCDAB Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCDAB](#)

In accordance with SRM 51-40-20

7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(c) If the frame foot is not cut:

1 Remove the support:

1 Support Item (20) Retain

(83) Subtask 536178-000-029-001 - Remove the Fasteners from Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCEAB](#)

In accordance with SRM 51-40-20

6 Bolt Item (3) Discard

6 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(84) Subtask 536178-000-030-001 - Remove the Fasteners from Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCFAB](#)

In accordance with SRM 51-40-20

6 Bolt Item (3) Discard

6 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(85) Subtask 536178-000-031-002 - Remove the Fasteners from Holes H8 and H9 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDAAB Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDAAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDAAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(86) Subtask 536178-000-032-002 - Remove the Fasteners from Holes H8 and H9 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDBAB Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDBAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDBAB](#).

(c) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(87) Subtask 536178-000-033-002 - Remove the Fasteners from Holes H9 and H10 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDCAB Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDCAB](#)

In accordance with SRM 51-40-20

- 2 Bolt Item (3) Discard
- 2 Nut Item (4) Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDCAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(88) Subtask 536178-000-034-002 - Remove the Fasteners from Holes H9 and H10 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDDAB Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDDAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDDAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(89) Subtask 536178-000-035-002 - Remove the Fasteners from Holes H8 and H9 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20

References	
Fig. A-FDEAB Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDEAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDEAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(90) Subtask 536178-000-036-002 - Remove the Fasteners from Holes H8 and H9 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	

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

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDFAB Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Remove the Fasteners:

Refer to [Fig. A-FDFAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDFAB](#).

(c) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(91) Subtask 536178-250-019-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFGAA Flowchart for the Hole H1 of Frame 41, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFGAA](#) and [Fig. A-FEAAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-025 001 Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-037 002 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-037 002 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-037 002 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-037 002 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (a).

(92) Subtask 536178-250-020-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFHAA Flowchart for the Hole H1 of Frame 42, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFHAA](#) and [Fig. A-FEBAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-026 001 Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-038 002 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-038 002 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-038 002 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-038 002 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (a).

(93) Subtask 536178-250-021-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFIAA Flowchart for the Hole H1 of Frame 43, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFIAA](#) and [Fig. A-FECAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-027 001 Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-039 002 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-039 002 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-039 002 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-039 002 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (a).

(94) Subtask 536178-250-022-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFJAA Flowchart for the Hole H1 of Frame 44, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFJAA](#) and [Fig. A-FEDAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-028 001 Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-040 002 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-040 002 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-040 002 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-040 002 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (a).

(95) Subtask 536178-250-023-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FFKAA Flowchart for the Hole H1 of Frame 45, RH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFKAA](#) and [Fig. A-FEGAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-029 001 Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-041 002 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-041 002 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-041 002 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-041 002 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (a).

(96) Subtask 536178-250-024-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFLAA Flowchart for the Hole H1 of Frame 46, RH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFLAA](#) and [Fig. A-FEFAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-030 001 Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-042 002 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-042 002 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):

a Do SUBTASK 536178-831-042 002 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (b).

4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):

a Do SUBTASK 536178-831-042 002 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (a).

(97) Subtask 536178-250-025-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFSAA Flowchart for the Hole H2 to H7 from Frame 41, RH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFSAA](#) and [Fig. A-FEAAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-031 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-007 002 Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side workstep (b).

2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-007 002 Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side workstep (a).

(98) Subtask 536178-250-026-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFTAA Flowchart for the Hole H2 to H7 from Frame 42, RH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFTAA](#) and [Fig. A-FEBAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-032 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-008 002 Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-008 002 Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side workstep (a).

(99) Subtask 536178-250-027-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFUAA Flowchart for the Hole H2 to H8 from Frame 43, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFUAA](#) and [Fig. A-FECAA](#)

- 1 If crack found:
 - a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-033 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side .
 - b Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)
 - c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.
 - d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.
 - e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.
 - f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-009 002 Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-009 002 Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side workstep (a).

(100)Subtask 536178-250-028-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFVAA Flowchart for the Hole H2 to H8 from Frame 44, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFVAA](#) and [Fig. A-FEDAA](#)

1 If crack found:

a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-034 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

- f If crack removed and the current hole diameter \leq 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-010 002 Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-010 002 Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side workstep (a).

(101)Subtask 536178-250-029-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFWAA Flowchart for the Hole H2 to H7 from Frame 45, RH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFWAA](#) and [Fig. A-FEGAA](#)

- 1 If crack found:
 - a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-035 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side .

- b Do an eddy-current rotating probe testing of the holes H2 to H7.
Refer to NTM 51-10-18 and NTM 51-10-01
Refer to [Fig. A-FEGAA](#)
- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):
<1> Do workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
<1> Do the SUBTASK 536178-400-011 002 Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-011 002 Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side workstep (a).

(102)Subtask 536178-250-030-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FFXAA Flowchart for the Hole H2 to H7 from Frame 46, RH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFXAA](#) and [Fig. A-FEFAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-036 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-012 002 Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side workstep (b).

2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-012 002 Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side workstep (a).

(103)Subtask 536178-250-031-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 41, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-043 002 Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side

(104)Subtask 536178-250-032-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

- (a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:
 - 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
 - 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.
- (b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 42, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

- 1 If cracks found:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no cracks found:
 - a Do the SUBTASK 536178-831-044 002 Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side

(105)Subtask 536178-250-033-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

- (a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:
 - 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
 - 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.
- (b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 43, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)

- 1 If cracks found:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no cracks found:
 - a Do the SUBTASK 536178-831-045 002 Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side

(106)Subtask 536178-250-034-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

- (a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:
 - 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
 - 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.
- (b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 44, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

- 1 If cracks found:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no cracks found:
 - a Do the SUBTASK 536178-831-046 002 Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side

(107)Subtask 536178-250-035-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 45, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-047 002 Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side

(108)Subtask 536178-250-036-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 46, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-048 002 Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side

(109)Subtask 536178-831-025-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS GREATER THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBAAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(110)Subtask 536178-831-026-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBBAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(111)Subtask 536178-831-027-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBCAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(112)Subtask 536178-831-028-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBDAB Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBDAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(113)Subtask 536178-831-029-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBEAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(114)Subtask 536178-831-030-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBFAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(115)Subtask 536178-831-031-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCAAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(116)Subtask 536178-831-032-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCBAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(117)Subtask 536178-831-033-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCCAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(118)Subtask 536178-831-034-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCDAB Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCDAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(119)Subtask 536178-831-035-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCEAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(120)Subtask 536178-831-036-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCFAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(121)Subtask 536178-831-037-002 - Install the Fastener on the Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Component COMPA02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBAAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBAAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBAAB](#)

1	Bush	A5381278720600	Item 2
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4 Ream the hole on the bush Item 2 to the applicable fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBAAB](#)

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K4-8	Item 10
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1	Nut	ASNA2529-4	Item 11
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NOTE: If spotfacing necessary, contact AIRBUS.

- (e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAB](#). It must be as near the current hole diameter + 0.80

mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.
- 3 Temporarily put in position the shim Item 1.
- 4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.
- 5 Clean the drilled area.
- 6 Install the fastener with high interference:

Refer to [Fig. A-FBAAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(122)Subtask 536178-831-038-002 - Install the Fastener on the Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Component COMPA04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

- (a) If the fastener at hole H1 has not been removed:
 - 1 No further action required for the hole H1 only.
- (b) If the fastener at hole H1 has been removed:
 - 1 Apply the instruction given in the following steps.
- (c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):
 - Refer to AMM 20-21-12, Page Block 001
 - In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30
 - Refer to [Fig. A-FBBAB](#)

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.
- 3 Temporarily put in position the shim Item 1.
- 4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 5 Clean the drilled area.
- 6 Install the fastener with high interference:

Refer to [Fig. A-FBBAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAB](#)

- 1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.
- 2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBBAB](#)

1 Bush A5381278720600 Item 2

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBBAB](#)

1 Shim A5381309320000 Item 1

1 Bolt EN6115K4-8 Item 10

1 Nut ASNA2529-4 Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBBAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(123)Subtask 536178-831-039-002 - Install the Fastener on the Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Component COMPA06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
36	A5381278720200	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAB](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBCAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBCAB](#)

1 Bush A5381278720200 Item 36

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in clearance fit:

Refer to [Fig. A-FBCAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K4-9	Item 38
1	Nut	ASNA2529-4	Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBCAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6

1 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(124)Subtask 536178-831-040-002 - Install the Fastener on the Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Component COMPA08				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
21	EN6115K4-11	1	BOLT	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	
30	ASNA2027V4-8	1	BOLT	
31	NSA5075-8	1	NUT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

Component COMPA15				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
29	A2521327620100	1	SUPPORT	
32	A2521326620200	1	SHIM	

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

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Paste Adhesive - Epoxy Potting Structure	13FBB2	As required	

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBDAB Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAB](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBDAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Temporarily put in position the support Item (29).

3 Mark the position of the holes H1 and H2 on the support Item (29).

4 Drill the holes on the support Item (29) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAB](#)

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the support:

Refer to [Fig. A-FBDAB](#)

1	Support	Item (29)	Retained at removal
---	---------	-----------	---------------------

with:

1	Shim	Item (32)	Retained at removal
---	------	-----------	---------------------

1	Bolt	ASNA2027V4-8	Item 30
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1	Nut	NSA5075-8	Item 31
---	-----	-----------	---------

NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
--	--------	-------------

and at hole H1:

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K6-9	Item 22
---	------	------------	---------

1	Nut	ASNA2529-6	Item 4
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or

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K5Y10	Item 23
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1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
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NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAB](#)

1 If hole diameter H1 of the support Item (29) is greater than 6.35 mm (0.25 in):

a Discard the retained support Item (29).

2 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

3 Clean the drilled area.

4 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBDAB](#)

1 Bush A5381278720400 Item 37

5 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

6 Temporarily put in position the support Item (29) or 29.

If the support has been discard, use:

1 Support A2521327620100 Item 29

7 Mark the position of the holes H1 and H2 on the support Item (29) or 29.

8 Drill the holes on the support Item (29) or 29 to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAB](#)

9 Temporarily put in position the shim Item 1.

10 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

11 Clean the drilled area.

12 Install the support:

Refer to [Fig. A-FBDAB](#)

1 Support Item (29) Retained at removal

If the support Item (29) has been discard:

1 Support A2521327620100 Item 29

with:

At Hole 11:

1 Shim Item (32) Retained at removal

If the support Item (20) has been discard:

1 Shim A2521326620200 Item 32

1 Bolt ASNA2027V4-8 Item 30

1 Nut NSA5075-8 Item 31

NOTE: Install the shim Item (32) with:

Paste Adhesive - 13FBB2 As required
Epoxy Potting
Structure

and at hole H1:

1 Shim A5381309320000 Item 1

1 Bolt EN6115K4-11 Item 21

1 Nut ASNA2529-4 Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBDAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the support Item (29).

3 Mark the position of the holes H1 and H2 on the support Item (29).

4 Drill the holes on the support Item (29) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAB](#)

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the support:

Refer to [Fig. A-FBDAB](#)

1	Support	Item (29)	Retained at removal
---	---------	-----------	---------------------

with:

1	Shim	Item (32)	Retained at removal
---	------	-----------	---------------------

1	Bolt	ASNA2027V4-8	Item 30
---	------	--------------	---------

1	Nut	NSA5075-8	Item 31
---	-----	-----------	---------

NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
--	--------	-------------

and at hole H1:

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K6-9	Item 22
---	------	------------	---------

1	Nut	ASNA2529-6	Item 4
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or

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K5Y10	Item 23
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1	Nut	ASNA2529-5	Item 6
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1	Washer	NSA5368-516B	Item 7
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NOTE: If spotfacing necessary, contact AIRBUS.

(125)Subtask 536178-831-041-002 - Install the Fastener on the Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Component COMPA10				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAB](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBEAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBEAB](#)

1	Bush	A5381278720400	Item 37
---	------	----------------	---------

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBEAB](#)

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K4-9	Item 38
---	------	------------	---------

1	Nut	ASNA2529-4	Item 11
---	-----	------------	---------

NOTE: If spotfacing necessary, contact AIRBUS.

- (e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBEAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(126)Subtask 536178-831-042-002 - Install the Fastener on the Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Component COMPA12				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

- (a) If the fastener at hole H1 has not been removed:
 - 1 No further action required for the hole H1 only.
- (b) If the fastener at hole H1 has been removed:
 - 1 Apply the instruction given in the following steps.
- (c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):
 - Refer to AMM 20-21-12, Page Block 001
 - In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAB](#)

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Temporarily put in position the shim Item 1.
- 3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 4 Clean the drilled area.
- 5 Install the fastener with high interference:

Refer to [Fig. A-FBFAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAB](#)

- 1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.
- 2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBFAB](#)

1 Bush A5381278720400 Item 37

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in clearance fit:

Refer to [Fig. A-FBFAB](#)

1 Shim A5381309320000 Item 1

1 Bolt EN6115K4-9 Item 38

1 Nut ASNA2529-4 Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBFAB](#)

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1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(127)Subtask 536178-400-007-002 - Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Clean the drilled area.
- 3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAB](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7

		and		
1	Bolt		EN6115K6Y7	Item 42
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X6	Item 38
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-6	Item 12
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y7	Item 13
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack removed and the current hole diameter < 9.40 mm (0.370 in):

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCAAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAB](#)

5	Bolt		EN6115K6Y8	Item 43
5	Nut		ASNA2529-6	Item 4
5	Washer		NSA5368-616B	Item 46
		or		
5	Bolt		EN6115K6X7	Item 39

	5	Nut	ASNA2529-6	Item 4
		or		
	5	Bolt	EN6115K6-7	Item 3
	5	Nut	ASNA2529-6	Item 4
		or		
	5	Bolt	EN6115K5Y8	Item 5
	5	Nut	ASNA2529-5	Item 6
	5	Washer	NSA5368-516B	Item 7
		and		
	1	Bolt	EN6115K6Y7	Item 42
	1	Nut	ASNA2529-6	Item 4
	1	Washer	NSA5368-616B	Item 46
		or		
	1	Bolt	EN6115K6X6	Item 38
	1	Nut	ASNA2529-6	Item 4
		or		
	1	Bolt	EN6115K6-6	Item 12
	1	Nut	ASNA2529-6	Item 4
		or		
	1	Bolt	EN6115K5Y7	Item 13
	1	Nut	ASNA2529-5	Item 6
	1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(128)Subtask 536178-400-008-002 - Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	1	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig.](#)

A-FCBAB. It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCBAB](#)

1	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCBAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCBAB](#)

1	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7

and

1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(129)Subtask 536178-400-009-002 - Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
7	NSA5368-516B	6	WASHER	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAB](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46

		or		
5	Bolt		EN6115K6X7	Item 39
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K6-7	Item 3
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K5Y8	Item 5
5	Nut		ASNA2529-5	Item 6
5	Washer		NSA5368-516B	Item 7
		and		
1	Bolt		EN6115K6Y7	Item 42
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X6	Item 38
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-6	Item 12
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y7	Item 13
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAB](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4

or

1 Bolt EN6115K6-6 Item 12

1 Nut ASNA2529-6 Item 4

or

1 Bolt EN6115K5Y7 Item 13

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(130)Subtask 536178-400-010-002 - Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	3.50
Minimum number of person	1
Subtask elapsed time	3.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA08				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	7	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	7	NUT	
7	NSA5368-516B	7	WASHER	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
41	EN6115K6X9	1	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
45	EN6115K6Y10	1	BOLT	
46	NSA5368-616B	7	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCDAB Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCDAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDAB](#)

1	Bolt	EN6115K6Y10	Item 45
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X9	Item 41
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		

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1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	and		
5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		

SERVICE BULLETIN

1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCDAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDAB](#)

1	Bolt	EN6115K6Y10	Item 45
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X9	Item 41
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

		and		
5	Bolt		EN6115K6Y9	Item 44
5	Nut		ASNA2529-6	Item 4
5	Washer		NSA5368-616B	Item 46
		or		
5	Bolt		EN6115K6X8	Item 40
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K6-8	Item 26
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K5Y9	Item 27
5	Nut		ASNA2529-5	Item 6
5	Washer		NSA5368-516B	Item 7
		and		
1	Bolt		EN6115K6Y8	Item 43
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X7	Item 39
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-7	Item 3
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y8	Item 5
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(131)Subtask 536178-400-011-002 - Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA10				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAB](#)

5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39

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1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAB](#)

5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26

5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(132)Subtask 536178-400-012-002 - Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA12				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	6	NUT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
26	EN6115K6-8	6	BOLT	
27	EN6115K5Y9	6	BOLT	
40	EN6115K6X8	6	BOLT	
44	EN6115K6Y9	6	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAB](#)

6	Bolt	EN6115K6Y9	Item 44
6	Nut	ASNA2529-6	Item 4

6	Washer	NSA5368-616B	Item 46
	or		
6	Bolt	EN6115K6X8	Item 40
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K6-8	Item 26
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K5Y9	Item 27
6	Nut	ASNA2529-5	Item 6
6	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAB](#)

6	Bolt	EN6115K6Y9	Item 44
6	Nut	ASNA2529-6	Item 4
6	Washer	NSA5368-616B	Item 46
	or		
6	Bolt	EN6115K6X8	Item 40
6	Nut	ASNA2529-6	Item 4

	or		
6	Bolt	EN6115K6-8	Item 26
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K5Y9	Item 27
6	Nut	ASNA2529-5	Item 6
6	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(133)Subtask 536178-831-043-002 - Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001

References	
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDAAB Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDAAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- 3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:
- a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or if hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

- b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fastener in transition fit:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

- (b) Install the new fastener at hole H9:

Refer to [Fig. A-FDAAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

- 1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

- 2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

- a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- b Clean the drilled area.

- c Install the fastener with high interference:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X5	Item 17
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-5	Item 18
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or if hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(134)Subtask 536178-831-044-002 - Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDBAB Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAB](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

1 Washer NSA5379-5W Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAB](#)

1 Bolt EN6115K5Y6 Item 16

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

or

1 Bolt EN6115K5X5 Item 17

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-5 Item 18

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAB](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(135)Subtask 536178-831-045-002 - Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDCAB Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X5	Item 17
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-5	Item 18
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(136)Subtask 536178-831-046-002 - Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA08				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44

References	
Fig. A-FDDAB Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDDAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAB](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDDAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAB](#)

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Bolt EN6115K5X6 Item 14

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAB](#)

1 Bolt EN6115K5-7 Item 9

1 Nut ASNA2529-5 Item 6

1 Washer NSA5379-5W Item 47

(137)Subtask 536178-831-047-002 - Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA10				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDEAB Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAB](#)

1	Bolt	EN6115K6-8	Item 26
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1	Nut	ASNA2529-6	Item 4
---	-----	------------	--------

or

1	Bolt	EN6115K5Y9	Item 27
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
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NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAB](#)

1	Bolt	EN6115K5-8	Item 19
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1	Nut	ASNA2529-5	Item 6
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1 Washer NSA5379-5W Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAB](#)

1 Bolt EN6115K5Y7 Item 13

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

or

1 Bolt EN6115K5X6 Item 14

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- 3** If (edge distance) / (hole diameter + 1.6 mm) < 1.27:
- a** If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):
- <1> Contact AIRBUS before next flight and follow their instructions.
- b** If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):
- <1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame
- <2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.
- <3> Clean the drilled area.
- <4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAB](#)

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(138)Subtask 536178-831-048-002 - Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA12				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDFAB Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDFAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDFAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K5Y7	Item 13
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1	Nut	ASNA2529-5	Item 6
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1	Washer	NSA5368-516B	Item 7
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or

1	Bolt	EN6115K5X6	Item 14
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1	Nut	ASNA2529-5	Item 6
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or

1	Bolt	EN6115K5-6	Item 15
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1	Nut	ASNA2529-5	Item 6
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NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(139)Subtask 536178-800-007-001 - Apply Protective Treatment to the Work Area at Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02
Fig. A-FDAAB Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBAAB](#), [Fig. A-FCAAB](#) and [Fig. A-FDAAB](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(140)Subtask 536178-800-008-001 - Apply Protective Treatment to the Work Area at Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02
Fig. A-FDBAB Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBBAB](#), [Fig. A-FBBAB](#) and [Fig. A-FCBAB](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(141)Subtask 536178-800-009-001 - Apply Protective Treatment to the Work Area at Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02
Fig. A-FDCAB Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBCAB](#), [Fig. A-FBCAB](#) and [Fig. A-FCCAB](#)

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
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and apply finish:

Top Coat Polyurethane - Grey Internal Structure	04JME4	As required
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(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(142)Subtask 536178-800-010-001 - Apply Protective Treatment to the Work Area at Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBDAB Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCDAB Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02
Fig. A-FDDAB Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBDAB](#), [Fig. A-FCDAB](#) and [Fig. A-FDDAB](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey		
Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion	12ABC1	As required
Preventive		
Compound-Water		
Displacing		

(143)Subtask 536178-800-011-001 - Apply Protective Treatment to the Work Area at Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

References	
Fig. A-FDEAB Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBEAB](#), [Fig. A-FCEAB](#) and [Fig. A-FDEAB](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey		
Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive	12ABC1	As required
Compound-Water Displacing		

(144)Subtask 536178-800-012-001 - Apply Protective Treatment to the Work Area at Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02
Fig. A-FDFAB Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBFAB](#), [Fig. A-FCFAB](#) and [Fig. A-FDFAB](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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****CONF 003**

(1) Subtask 536178-000-001-001 - Remove the Fastener from Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBAAA Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBAAA](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(2) Subtask 536178-000-002-001 - Remove the Fastener from Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBBAA Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBBAA](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(3) Subtask 536178-000-003-001 - Remove the Fastener from Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBCAA Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBCAA](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(4) Subtask 536178-000-004-001 - Remove the Fastener from Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBDAA Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fasteners:

Refer to [Fig. A-FBDAA](#)

In accordance with SRM 51-40-20

1 At hole H11:

1	Shim	Item (32)	Retain
1	Bolt	Item (30)	Discard
1	Nut	Item (31)	Discard

2 At hole H1:

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(5) Subtask 536178-000-005-001 - Remove the Fastener from Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBEAA Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBEAA](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
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1	Nut	Item (4)	Discard
---	-----	----------	---------

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required	
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and

Non Aqueous Cleaner - General	08BAA9	As required	
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(6) Subtask 536178-000-006-001 - Remove the Fastener from Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBFAA Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBFAA](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
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1	Nut	Item (4)	Discard
---	-----	----------	---------

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required	
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and

Non Aqueous Cleaner - General	08BAA9	As required	
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(7) Subtask 536178-000-007-001 - Remove the Fasteners from Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCAAA Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCAAA](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(8) Subtask 536178-000-008-001 - Remove the Fasteners from Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCBAA Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCBAA](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(9) Subtask 536178-000-009-001 - Remove the Fasteners from Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCCAA Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCCAA](#)

In accordance with SRM 51-40-20

7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required	
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and

Non Aqueous Cleaner - General	08BAA9	As required	
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(10) Subtask 536178-000-010-001 - Remove the Fasteners from Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	2.50
Minimum number of person	1
Subtask elapsed time	2.50
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCDAA Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fasteners and the support:

Refer to [Fig. A-FCDAA](#)

In accordance with SRM 51-40-20

1	Support	Item (20)	Retain
7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
----------------------------	--------	-------------

and

Non Aqueous Cleaner - General	08BAA9	As required
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(11) Subtask 536178-000-011-001 - Remove the Fasteners from Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCEAA Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCEAA](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
----------------------------	--------	-------------

and

Non Aqueous Cleaner - General	08BAA9	As required
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(12) Subtask 536178-000-012-001 - Remove the Fasteners from Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCFAA Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCFAA](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(13) Subtask 536178-000-013-001 - Remove the Fasteners from Holes H8 and H9 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDAAA Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDAAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDAAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(14) Subtask 536178-000-014-001 - Remove the Fasteners from Holes H8 and H9 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDBAA Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDBAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDBAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
 Cleaner - General

(15) Subtask 536178-000-015-001 - Remove the Fasteners from Holes H9 and H10 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDCAA Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDCAA](#)

In accordance with SRM 51-40-20

- | | | | |
|---|------|----------|---------|
| 2 | Bolt | Item (3) | Discard |
| 2 | Nut | Item (4) | Discard |

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDCAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(16) Subtask 536178-000-016-001 - Remove the Fasteners from Holes H9 and H10 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDDAA Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDDAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDDAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(17) Subtask 536178-000-017-001 - Remove the Fasteners from Holes H8 and H9 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDEAA Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDEAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDEAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(18) Subtask 536178-000-018-001 - Remove the Fasteners from Holes H8 and H9 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDFAA Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDFAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDFAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(19) Subtask 536178-250-001-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFAAA Flowchart for the Hole H1 of Frame 41, LH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFAAA](#) and [Fig. A-FEAAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-001 001 Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-013 001 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-013 001 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-013 001 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-013 001 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (a).

(20) Subtask 536178-250-002-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFBAA Flowchart for the Hole H1 of Frame 42, LH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFBAA](#) and [Fig. A-FEBAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-002 001 Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-014 001 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-014 001 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-014 001 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-014 001 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (a).

(21) Subtask 536178-250-003-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFCAA Flowchart for the Hole H1 of Frame 43, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFCAA](#) and [Fig. A-FECAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-003 001 Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-015 001 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-015 001 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-015 001 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-015 001 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (a).

(22) Subtask 536178-250-004-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFDAA Flowchart for the Hole H1 of Frame 44, LH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFDAA](#) and [Fig. A-FEDAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-004 001 Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-016 001 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-016 001 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-016 001 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-016 001 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (a).

(23) Subtask 536178-250-005-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFEAA Flowchart for the Hole H1 of Frame 45, LH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFEAA](#) and [Fig. A-FEGAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-005 001 Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-017 001 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-017 001 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-017 001 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-017 001 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (a).

(24) Subtask 536178-250-006-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FFFAA Flowchart for the Hole H1 of Frame 46, LH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFFAA](#) and [Fig. A-FEFAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-006 001 Depending on the Inspection Result, Ream Hole H1 of Frame 46, LH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-018 001 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-018 001 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-018 001 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-018 001 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (a).

(25) Subtask 536178-250-007-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFMAA Flowchart for the Hole H2 to H7 from Frame 41, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFMAA](#) and [Fig. A-FEAAA](#)

- 1 If crack found:
 - a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-007 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side .
 - b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):
 - <1> Do workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-001 001 Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-001 001 Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side workstep (a).

(26) Subtask 536178-250-008-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFNAA Flowchart for the Hole H2 to H7 from Frame 42, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFNAA](#) and [Fig. A-FEBAA](#)

- 1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-008 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-002 001 Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side workstep (b).

- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-002 001 Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side workstep (a).

(27) Subtask 536178-250-009-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFOAA Flowchart for the Hole H2 to H8 from Frame 43, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFOAA](#) and [Fig. A-FECAA](#)

1 If crack found:

a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-009 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

- f If crack removed and the current hole diameter \leq 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-003 001 Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-003 001 Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side workstep (a).

(28) Subtask 536178-250-010-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFPAA Flowchart for the Hole H2 to H8 from Frame 44, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFPAA](#) and [Fig. A-FEDAA](#)

- 1 If crack found:
 - a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-010 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side .

- b Do an eddy-current rotating probe testing of the holes H2 to H8.
Refer to NTM 51-10-18 and NTM 51-10-01
Refer to [Fig. A-FEDAA](#)
- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):
<1> Do workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
<1> Do the SUBTASK 536178-400-004 001 Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-004 001 Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side workstep (a).

(29) Subtask 536178-250-011-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FFQAA Flowchart for the Hole H2 to H7 from Frame 45, LH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFQAA](#) and [Fig. A-FEGAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-011 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-005 001 Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side workstep (b).

2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-005 001 Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side workstep (a).

(30) Subtask 536178-250-012-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFRAA Flowchart for the Hole H2 to H7 from Frame 46, LH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFRAA](#) and [Fig. A-FEFAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-012 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-006 001 Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-006 001 Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side workstep (a).

(31) Subtask 536178-250-013-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

- (a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:
 - 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
 - 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.

- (b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 41, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

1 If cracks found:

- a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

- a Do the SUBTASK 536178-831-019 001 Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side

(32) Subtask 536178-250-014-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

- (a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

- a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

- a Apply the instructions given in the following worksteps.

- (b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 42, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-020 001 Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side

(33) Subtask 536178-250-015-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 43, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

- a Do the SUBTASK 536178-831-021 001 Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side

(34) Subtask 536178-250-016-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:

1 If bush installed:

- a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

- a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 44, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

1 If cracks found:

- a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

- a Do the SUBTASK 536178-831-022 001 Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side

(35) Subtask 536178-250-017-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 45, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-023 001 Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side

(36) Subtask 536178-250-018-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 46, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-024 001 Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side

(37) Subtask 536178-831-001-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBAAA Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBAAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(38) Subtask 536178-831-002-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBBAA Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBBAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(39) Subtask 536178-831-003-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBCAA Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBCAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(40) Subtask 536178-831-004-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBDAA Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBDAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(41) Subtask 536178-831-005-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBEAA Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBEAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(42) Subtask 536178-831-006-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBFAA Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBFAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(43) Subtask 536178-831-007-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCAAA Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCAAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(44) Subtask 536178-831-008-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCBAA Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCBAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(45) Subtask 536178-831-009-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCCAA Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCCAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(46) Subtask 536178-831-010-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCDA Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCDA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(47) Subtask 536178-831-011-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCEAA Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCEAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(48) Subtask 536178-831-012-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCFAA Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCFAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(49) Subtask 536178-831-013-001 - Install the Fastener on the Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Component COMPA01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBAAA Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBAAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1

SERVICE BULLETIN

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBAAA](#)

- 1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.
- 2 Clean the drilled area.
- 3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBAAA](#)

1	Bush	A5381278720600	Item 2
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- 4 Ream the hole on the bush Item 2 to the applicable fastener diameter in accordance with SRM 51-40-40 (transition fit).
- 5 Temporarily put in position the shim Item 1.
- 6 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.
- 7 Clean the drilled area.
- 8 Install the fastener in transition fit:

Refer to [Fig. A-FBAAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K4-8	Item 10
1	Nut	ASNA2529-4	Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

- (c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBAAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(50) Subtask 536178-831-014-001 - Install the Fastener on the Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Component COMPA03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44

References	
Fig. A-FBBAA Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAA](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBBAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X7	Item 8

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1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAA](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBBAA](#)

1	Bush	A5381278720600	Item 2
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4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBBAA](#)

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K4-8	Item 10
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1	Nut	ASNA2529-4	Item 11
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NOTE: If spotfacing necessary, contact AIRBUS.

(c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAA](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBBAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1

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1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4

NOTE: If spotfacing necessary, contact AIRBUS.

(51) Subtask 536178-831-015-001 - Install the Fastener on the Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Component COMPA05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
11	ASNA2529-4	1	NUT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
36	A5381278720200	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBCAA Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAA](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBCAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Shim A5381309320000 Item 1

1 Bolt EN6115K5X7 Item 8

1 Nut ASNA2529-5 Item 6

or

1 Shim A5381309320000 Item 1

1 Bolt EN6115K5-7 Item 9

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAA](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBCAA](#)

1 Bush A5381278720200 Item 36

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBCAA](#)

1 Shim A5381309320000 Item 1

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1 Bolt EN6115K4-9 Item 38

1 Nut ASNA2529-4 Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAA](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBCAA](#)

1 Shim A5381309320000 Item 1

1 Bolt EN6115K6-7 Item 3

1 Nut ASNA2529-6 Item 4

or

1 Shim A5381309320000 Item 1

1 Bolt EN6115K5Y8 Item 5

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

or

1 Shim A5381309320000 Item 1

1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(52) Subtask 536178-831-016-001 - Install the Fastener on the Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Component COMPA07				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
21	EN6115K4-11	1	BOLT	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	
24	EN6115K5X9	1	BOLT	
25	EN6115K5-9	1	BOLT	
30	ASNA2027V4-8	1	BOLT	
31	NSA5075-8	1	NUT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

Component COMPA15				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
20	A2521327620000	1	SUPPORT	
32	A2521326620200	1	SHIM	

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

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Paste Adhesive - Epoxy Potting Structure	13FBB2	As required	

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBDAA Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAA](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBDAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Temporarily put in position the support Item (20).
- 3 Mark the position of the holes H1 and H2 on the support Item (20).
- 4 Drill the holes on the support Item (20) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAA](#)

- 5 Temporarily put in position the shim Item 1.
- 6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 7 Clean the drilled area.
- 8 Install the support:

Refer to [Fig. A-FBDAA](#)

1	Support	Item (20)	Retained at removal
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with:

1	Shim	Item (32)	Retained at removal
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1	Bolt	ASNA2027V4-8	Item 30
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1	Nut	NSA5075-8	Item 31
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NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
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and at hole H1:

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K6-9	Item 22
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1	Nut	ASNA2529-6	Item 4
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or

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K5Y10	Item 23
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1	Nut	ASNA2529-5	Item 6
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1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X9	Item 24
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-9	Item 25
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAA](#)

1 If hole diameter H1 of the support Item (20) is greater than 6.35 mm (0.25 in):

a Discard the retained support Item (20).

2 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

3 Clean the drilled area.

4 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBDAA](#)

1	Bush	A5381278720400	Item 37
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5 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

6 Temporarily put in position the support Item (20) or 20.

If the support has been discard, use:

1	Support	A2521327620000	Item 20
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- 7 Mark the position of the holes H1 and H2 on the support Item (20) or 20.
- 8 Drill the holes on the support Item (20) or 20 to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAA](#)

- 9 Temporarily put in position the shim Item 1.
- 10 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

- 11 Clean the drilled area.

- 12 Install the support:

Refer to [Fig. A-FBDAA](#)

1	Support	Item (20)	Retained at removal
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If the support Item (20) has been discard:

1	Support	A2521327620000	Item 20
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with:

At Hole 11:

1	Shim	Item (32)	Retained at removal
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If the support Item (20) has been discard:

1	Shim	A2521326620200	Item 32
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1	Bolt	ASNA2027V4-8	Item 30
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1	Nut	NSA5075-8	Item 31
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NOTE: Install the shim Item (32) with:

Paste Adhesive - 13FBB2 As required
Epoxy Potting
Structure

and at hole H1:

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K4-11	Item 21
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1	Nut	ASNA2529-4	Item 11
---	-----	------------	---------

NOTE: If spotfacing necessary, contact AIRBUS.

(c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAA](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBDAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the support Item (20).

3 Mark the position of the holes H1 and H2 on the support Item (20).

4 Drill the holes on the support Item (20) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAA](#)

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the support:

Refer to [Fig. A-FBDAA](#)

1	Support	Item (20)	Retained at removal
---	---------	-----------	---------------------

with:

1	Shim	Item (32)	Retained at removal
---	------	-----------	---------------------

1	Bolt	ASNA2027V4-8	Item 30
---	------	--------------	---------

1	Nut	NSA5075-8	Item 31
---	-----	-----------	---------

NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
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and at hole H1:

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X9	Item 24
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-9	Item 25
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(53) Subtask 536178-831-017-001 - Install the Fastener on the Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Component COMPA09				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBEAA Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAA](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBEAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAA](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBEAA](#)

1	Bush	A5381278720400	Item 37
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4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBEAA](#)

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K4-9	Item 38
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1	Nut	ASNA2529-4	Item 11
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NOTE: If spotfacing necessary, contact AIRBUS.

- (c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAA](#)

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Temporarily put in position the shim Item 1.

- 3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

- 4 Clean the drilled area.

- 5 Install the fastener with high interference:

Refer to [Fig. A-FBEAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(54) Subtask 536178-831-018-001 - Install the Fastener on the Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Component COMPA11				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44

References	
Fig. A-FBFAA Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAA](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBFAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6

or

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAA](#)

- 1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.
- 2 Clean the drilled area.
- 3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBFAA](#)

1	Bush	A5381278720400	Item 37
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- 4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).
- 5 Temporarily put in position the shim Item 1.
- 6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 7 Clean the drilled area.
- 8 Install the fasteners in clearance fit:

Refer to [Fig. A-FBFAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K4-9	Item 38
1	Nut	ASNA2529-4	Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAA](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBFAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1

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1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(55) Subtask 536178-400-001-001 - Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
8	EN6115K5X7	5	BOLT	
9	EN6115K5-7	5	BOLT	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001

References	
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCAAA Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCAAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAA](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X7	Item 8

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5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack removed and the current hole diameter < 9.40 mm (0.370 in):

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig.](#)

[A-FCAAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAA](#)

5 Bolt EN6115K6Y8 Item 43

5 Nut ASNA2529-6 Item 4

5 Washer NSA5368-616B Item 46

or

5 Bolt EN6115K6X7 Item 39

5 Nut ASNA2529-6 Item 4

or

5 Bolt EN6115K6-7 Item 3

5 Nut ASNA2529-6 Item 4

or

5 Bolt EN6115K5Y8 Item 5

5 Nut ASNA2529-5 Item 6

5 Washer NSA5368-516B Item 7

or

5 Bolt EN6115K5X7 Item 8

5 Nut ASNA2529-5 Item 6

or

5 Bolt EN6115K5-7 Item 9

5 Nut ASNA2529-5 Item 6

and

1 Bolt EN6115K6Y7 Item 42

1 Nut ASNA2529-6 Item 4

1 Washer NSA5368-616B Item 46

or

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1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(56) Subtask 536178-400-002-001 - Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
8	EN6115K5X7	5	BOLT	
9	EN6115K5-7	5	BOLT	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCBAA Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCBAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCBAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCBAA](#)

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5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X7	Item 8
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12

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1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCBAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCBAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCBAA](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39

5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X7	Item 8
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Bolt EN6115K5X6 Item 14

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(57) Subtask 536178-400-003-001 - Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
8	EN6115K5X7	5	BOLT	
9	EN6115K5-7	5	BOLT	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCCAA Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCCAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAA](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		

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5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X7	Item 8
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCCAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAA](#)

5 Bolt EN6115K6Y8 Item 43

5 Nut ASNA2529-6 Item 4

5 Washer NSA5368-616B Item 46
or

5 Bolt EN6115K6X7 Item 39

5 Nut ASNA2529-6 Item 4
or

5 Bolt EN6115K6-7 Item 3

5 Nut ASNA2529-6 Item 4
or

5 Bolt EN6115K5Y8 Item 5

5 Nut ASNA2529-5 Item 6

5 Washer NSA5368-516B Item 7
or

5 Bolt EN6115K5X7 Item 8

5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(58) Subtask 536178-400-004-001 - Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	3.50
Minimum number of person	1
Subtask elapsed time	3.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA07				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	7	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	7	NUT	
7	NSA5368-516B	7	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
19	EN6115K5-8	5	BOLT	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	
24	EN6115K5X9	1	BOLT	
25	EN6115K5-9	1	BOLT	
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
28	EN6115K5X8	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
41	EN6115K6X9	1	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
45	EN6115K6Y10	1	BOLT	
46	NSA5368-616B	7	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001

References	
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCDA Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCDA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDA](#)

1	Bolt	EN6115K6Y10	Item 45
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X9	Item 41
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6

1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X9	Item 24
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-9	Item 25
1	Nut	ASNA2529-5	Item 6
	and		
5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X8	Item 28
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-8	Item 19
5	Nut	ASNA2529-5	Item 6
	and		

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1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCDAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDA](#)

1	Bolt	EN6115K6Y10	Item 45
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X9	Item 41
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X9	Item 24
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-9	Item 25
1	Nut	ASNA2529-5	Item 6
	and		
5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40

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5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X8	Item 28
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-8	Item 19
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6

or

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(59) Subtask 536178-400-005-001 - Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA09				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
19	EN6115K5-8	5	BOLT	
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
28	EN6115K5X8	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCEAA Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCEAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAA](#)

5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		

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5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X8	Item 28
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-8	Item 19
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCEAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAA](#)

5 Bolt EN6115K6Y9 Item 44

5 Nut ASNA2529-6 Item 4

5 Washer NSA5368-616B Item 46
or

5 Bolt EN6115K6X8 Item 40

5 Nut ASNA2529-6 Item 4
or

5 Bolt EN6115K6-8 Item 26

5 Nut ASNA2529-6 Item 4
or

5 Bolt EN6115K5Y9 Item 27

5 Nut ASNA2529-5 Item 6

5 Washer NSA5368-516B Item 7
or

5 Bolt EN6115K5X8 Item 28

5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-8	Item 19
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(60) Subtask 536178-400-006-001 - Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA11				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	6	NUT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
19	EN6115K5-8	6	BOLT	
26	EN6115K6-8	6	BOLT	
27	EN6115K5Y9	6	BOLT	
28	EN6115K5X8	6	BOLT	
40	EN6115K6X8	6	BOLT	
44	EN6115K6Y9	6	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCFAA Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAA](#)

6	Bolt	EN6115K6Y9	Item 44
6	Nut	ASNA2529-6	Item 4
6	Washer	NSA5368-616B	Item 46
	or		
6	Bolt	EN6115K6X8	Item 40
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K6-8	Item 26
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K5Y9	Item 27
6	Nut	ASNA2529-5	Item 6
6	Washer	NSA5368-516B	Item 7
	or		
6	Bolt	EN6115K5X8	Item 28
6	Nut	ASNA2529-5	Item 6
	or		
6	Bolt	EN6115K5-8	Item 19
6	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAA](#)

6	Bolt	EN6115K6Y9	Item 44
6	Nut	ASNA2529-6	Item 4
6	Washer	NSA5368-616B	Item 46
	or		
6	Bolt	EN6115K6X8	Item 40
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K6-8	Item 26
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K5Y9	Item 27
6	Nut	ASNA2529-5	Item 6
6	Washer	NSA5368-516B	Item 7
	or		
6	Bolt	EN6115K5X8	Item 28
6	Nut	ASNA2529-5	Item 6
	or		
6	Bolt	EN6115K5-8	Item 19

6 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(61) Subtask 536178-831-019-001 - Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDAAA Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

References	
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDAAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDAAA](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or if hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install in transition fit:

Refer to [Fig. A-FDAAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDAAA](#)

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1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X5	Item 17
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-5	Item 18
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or if hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fastener in transition fit:

Refer to [Fig. A-FDAAA](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(62) Subtask 536178-831-020-001 - Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDBAA Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDBAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAA](#)

1	Bolt	EN6115K6-7	Item 3
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1	Nut	ASNA2529-6	Item 4
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or

1	Bolt	EN6115K5Y8	Item 5
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1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
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or

1	Bolt	EN6115K5X7	Item 8
---	------	------------	--------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

or

1	Bolt	EN6115K5-7	Item 9
---	------	------------	--------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDBAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAA](#)

1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Bolt EN6115K5X5 Item 17

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-5 Item 18

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAA](#)

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

1 Washer NSA5379-5W Item 47

(63) Subtask 536178-831-021-001 - Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDCAA Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDCAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAA](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If $(\text{edge distance}) / (\text{hole diameter} + 0.8 \text{ mm}) \geq 1.30$ and the hole diameter $\leq 7.92 \text{ mm}$ (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDCAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If $(\text{edge distance}) / (\text{hole diameter} + 1.6 \text{ mm}) \geq 1.27$:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAA](#)

1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Bolt EN6115K5X5 Item 17

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-5 Item 18

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAA](#)

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

1 Washer NSA5379-5W Item 47

(64) Subtask 536178-831-022-001 - Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA07				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	3	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	2	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDDAA Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDDAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAA](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDDAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAA](#)

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Bolt EN6115K5X6 Item 14

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAA](#)

1 Bolt EN6115K5-7 Item 9

1 Nut ASNA2529-5 Item 6

1 Washer NSA5379-5W Item 47

(65) Subtask 536178-831-023-001 - Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA09				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	2	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDEAA Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDEAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAA](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDEAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAA](#)

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Bolt EN6115K5X6 Item 14

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAA](#)

1 Bolt EN6115K5-7 Item 9

1 Nut ASNA2529-5 Item 6

1 Washer NSA5379-5W Item 47

(66) Subtask 536178-831-024-001 - Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA11				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	4	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	2	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDFAA Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDFAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAA](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDFAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAA](#)

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6

or

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAA](#)

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(67) Subtask 536178-800-001 - Apply Protective Treatment to the Work Area at Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBAAA Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCAAA Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02
Fig. A-FDAAA Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBAAA](#), [Fig. A-FCAAA](#) and [Fig. A-FDAAA](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(68) Subtask 536178-800-002-001 - Apply Protective Treatment to the Work Area at Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBBAA Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCBAA Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02
Fig. A-FDBAA Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBBAA](#), [Fig. A-FBBAA](#) and [Fig. A-FCBAA](#)

SERVICE BULLETIN

Primer 04EAC2 As required
 Polyurethane Paint
 - Corrosion
 Inhibiting

and apply finish:

Top Coat 04JME4 As required
 Polyurethane - Grey
 Internal Structure

(b) Apply on the work area below the floor level:

Corrosion 12ABC1 As required
 Preventive
 Compound-Water
 Displacing

(69) Subtask 536178-800-003-001 - Apply Protective Treatment to the Work Area at Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBCAA	Sheet 01
Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 02 Sheet 03

References	
Fig. A-FCCAA Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02
Fig. A-FDCAA Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBCAA](#), [Fig. A-FBCAA](#) and [Fig. A-FCCAA](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion		
Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey		
Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion	12ABC1	As required
Preventive		
Compound-Water		
Displacing		

(70) Subtask 536178-800-004-001 - Apply Protective Treatment to the Work Area at Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBDAA Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCDAA Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02 Sheet 03
Fig. A-FDDAA Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBDAA](#), [Fig. A-FCDAA](#) and [Fig. A-FDDAA](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(71) Subtask 536178-800-005-001 - Apply Protective Treatment to the Work Area at Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBEAA Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCEAA Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02
Fig. A-FDEAA Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBEAA](#), [Fig. A-FCEAA](#) and [Fig. A-FDEAA](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion Inhibiting		

and apply finish:

Top Coat 04JME4 As required
 Polyurethane - Grey
 Internal Structure

(b) Apply on the work area below the floor level:

Corrosion 12ABC1 As required
 Preventive
 Compound-Water
 Displacing

(72) Subtask 536178-800-006-001 - Apply Protective Treatment to the Work Area at Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBFAA Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCFAA Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02
Fig. A-FDFAA Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBFAA](#), [Fig. A-FCFAA](#) and [Fig. A-FDFAA](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(73) Subtask 536178-000-019-001 - Remove the Fastener from Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBAAA Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBAAA](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(74) Subtask 536178-000-020-001 - Remove the Fastener from Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBBAA Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBBAA](#)

In accordance with SRM 51-40-20

1 Bolt Item (3) Discard

1 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(75) Subtask 536178-000-021-001 - Remove the Fastener from Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBCAA Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBCAA](#)

In accordance with SRM 51-40-20

1 Bolt Item (3) Discard

1 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(76) Subtask 536178-000-022-001 - Remove the Fastener from Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBDAA Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fasteners:

Refer to [Fig. A-FBDAA](#)

In accordance with SRM 51-40-20

1 At hole H11:

1 Shim Item (32) Retain

1 Bolt Item (30) Discard

- 1 Nut Item (31) Discard
- 2 At hole H1:
- 1 Bolt Item (3) Discard
- 1 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(77) Subtask 536178-000-023-001 - Remove the Fastener from Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBEAA Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBEAA](#)

In accordance with SRM 51-40-20

- 1 Bolt Item (3) Discard
- 1 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(78) Subtask 536178-000-024-001 - Remove the Fastener from Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBFAA Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fastener:

Refer to [Fig. A-FBFAA](#)

In accordance with SRM 51-40-20

- 1 Bolt Item (3) Discard
- 1 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(79) Subtask 536178-000-025-001 - Remove the Fasteners from Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCAAA Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCAAA](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(80) Subtask 536178-000-026-001 - Remove the Fasteners from Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCBAA Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCBAA](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(81) Subtask 536178-000-027-001 - Remove the Fasteners from Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCCAA Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCCAA](#)

In accordance with SRM 51-40-20

7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(82) Subtask 536178-000-028-001 - Remove the Fasteners from Holes H2 to H8 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	2.50
Minimum number of person	1
Subtask elapsed time	2.50
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCDAA Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fasteners and the support:

Refer to [Fig. A-FCDAA](#)

In accordance with SRM 51-40-20

1	Support	Item (20)	Retain
7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(83) Subtask 536178-000-029-001 - Remove the Fasteners from Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCEAA Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCEAA](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(84) Subtask 536178-000-030-001 - Remove the Fasteners from Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCFAA Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCFAA](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(85) Subtask 536178-000-031-001 - Remove the Fasteners from Holes H8 and H9 of Frame 41, RH Side

Work Zones and Access Panels			
Zone	Access/Work location		
242	Work location	Frame 41	

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDAAA Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDAAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDAAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(86) Subtask 536178-000-032-001 - Remove the Fasteners from Holes H8 and H9 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDBAA Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDBAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDBAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(87) Subtask 536178-000-033-001 - Remove the Fasteners from Holes H9 and H10 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDCAA Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDCAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDCAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(88) Subtask 536178-000-034-001 - Remove the Fasteners from Holes H9 and H10 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDDAA Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDDAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDDAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(89) Subtask 536178-000-035-001 - Remove the Fasteners from Holes H8 and H9 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDEAA Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDEAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDEAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(90) Subtask 536178-000-036-001 - Remove the Fasteners from Holes H8 and H9 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDFAA Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDFAA](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

(b) Cut-out the frame foot as per dimensions given in [Fig. A-FDFAA](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(91) Subtask 536178-250-019-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFGAA Flowchart for the Hole H1 of Frame 41, RH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFGAA](#) and [Fig. A-FEAAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-025 001 Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-037 001 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-037 001 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-037 001 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-037 001 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (a).

(92) Subtask 536178-250-020-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFHAA Flowchart for the Hole H1 of Frame 42, RH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFHAA](#) and [Fig. A-FEBAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-026 001 Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-038 001 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-038 001 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-038 001 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-038 001 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (a).

(93) Subtask 536178-250-021-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFIA Flowchart for the Hole H1 of Frame 43, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFIA](#) and [Fig. A-FECA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-027 001 Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-039 001 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-039 001 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-039 001 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-039 001 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (a).

(94) Subtask 536178-250-022-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFJAA Flowchart for the Hole H1 of Frame 44, RH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFJAA](#) and [Fig. A-FEDAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-028 001 Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-040 001 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-040 001 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-040 001 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-040 001 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (a).

(95) Subtask 536178-250-023-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFKAA Flowchart for the Hole H1 of Frame 45, RH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFKAA](#) and [Fig. A-FEGAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-029 001 Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-041 001 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-041 001 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-041 001 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-041 001 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (a).

(96) Subtask 536178-250-024-001 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FFLAA Flowchart for the Hole H1 of Frame 46, RH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFLAA](#) and [Fig. A-FEFAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-030 001 Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-042 001 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-042 001 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-042 001 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-042 001 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (a).

(97) Subtask 536178-250-025-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFSAA Flowchart for the Hole H2 to H7 from Frame 41, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFSAA](#) and [Fig. A-FEAAA](#)

- 1 If crack found:
 - a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-031 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side .
 - b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-007 001 Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side workstep (b).

2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-007 001 Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side workstep (a).

(98) Subtask 536178-250-026-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFTAA Flowchart for the Hole H2 to H7 from Frame 42, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFTAA](#) and [Fig. A-FEBAA](#)

- 1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-032 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-008 001 Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side workstep (b).

- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-008 001 Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side workstep (a).

(99) Subtask 536178-250-027-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFUAA Flowchart for the Hole H2 to H8 from Frame 43, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFUAA](#) and [Fig. A-FECAA](#)

1 If crack found:

a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-033 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

- f If crack removed and the current hole diameter \leq 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-009 001 Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-009 001 Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side workstep (a).

(100)Subtask 536178-250-028-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFVAA Flowchart for the Hole H2 to H8 from Frame 44, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFVAA](#) and [Fig. A-FEDAA](#)

- 1 If crack found:
 - a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-034 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side .

- b Do an eddy-current rotating probe testing of the holes H2 to H8.
Refer to NTM 51-10-18 and NTM 51-10-01
Refer to [Fig. A-FEDAA](#)
- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):
<1> Do workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
<1> Do the SUBTASK 536178-400-010 001 Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-010 001 Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side workstep (a).

(101)Subtask 536178-250-029-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FFWAA Flowchart for the Hole H2 to H7 from Frame 45, RH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFWAA](#) and [Fig. A-FEGAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-035 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-011 001 Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side workstep (b).

2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-011 001 Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side workstep (a).

(102)Subtask 536178-250-030-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFXAA Flowchart for the Hole H2 to H7 from Frame 46, RH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFXAA](#) and [Fig. A-FEFAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-036 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-012 001 Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-012 001 Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side workstep (a).

(103)Subtask 536178-250-031-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

- (a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:
 - 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
 - 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.

- (b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 41, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-043 001 Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side

(104)Subtask 536178-250-032-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

- (a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

- (b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 42, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-044 001 Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side

(105)Subtask 536178-250-033-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 43, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

- a Do the SUBTASK 536178-831-045 001 Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side

(106)Subtask 536178-250-034-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:

1 If bush installed:

- a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

- a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 44, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

1 If cracks found:

- a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

- a Do the SUBTASK 536178-831-046 001 Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side

(107)Subtask 536178-250-035-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

- (a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:
 - 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
 - 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.
- (b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 45, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

- 1 If cracks found:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no cracks found:
 - a Do the SUBTASK 536178-831-047 001 Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side

(108)Subtask 536178-250-036-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 46, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-048 001 Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side

(109)Subtask 536178-831-025-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBAAA Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS GREATER THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBAAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(110)Subtask 536178-831-026-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBBAA Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBBAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(111)Subtask 536178-831-027-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBCAA Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBCAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(112)Subtask 536178-831-028-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBDAA Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBDAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(113)Subtask 536178-831-029-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBEAA Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBEAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(114)Subtask 536178-831-030-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBFAA Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBFAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(115)Subtask 536178-831-031-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCAAA Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCAAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(116)Subtask 536178-831-032-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCBAA Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCBAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(117)Subtask 536178-831-033-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCCAA Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCCAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(118)Subtask 536178-831-034-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCDAA Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCDAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(119)Subtask 536178-831-035-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCEAA Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCEAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(120)Subtask 536178-831-036-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCFAA Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCFAA](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(121)Subtask 536178-831-037-001 - Install the Fastener on the Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Component COMPA01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBAAA Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBAAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1

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1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBAAA](#)

- 1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.
- 2 Clean the drilled area.
- 3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBAAA](#)

1	Bush	A5381278720600	Item 2
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- 4 Ream the hole on the bush Item 2 to the applicable fastener diameter in accordance with SRM 51-40-40 (transition fit).
- 5 Temporarily put in position the shim Item 1.
- 6 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.
- 7 Clean the drilled area.
- 8 Install the fastener in transition fit:

Refer to [Fig. A-FBAAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K4-8	Item 10
1	Nut	ASNA2529-4	Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

- (c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Temporarily put in position the shim Item 1.

- 4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

- 5 Clean the drilled area.

- 6 Install the fastener with high interference:

Refer to [Fig. A-FBAAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(122)Subtask 536178-831-038-001 - Install the Fastener on the Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Component COMPA03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44

References	
Fig. A-FBBAA Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAA](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBBAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X7	Item 8

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1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAA](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBBAA](#)

1	Bush	A5381278720600	Item 2
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4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBBAA](#)

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K4-8	Item 10
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1	Nut	ASNA2529-4	Item 11
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NOTE: If spotfacing necessary, contact AIRBUS.

(c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAA](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBBAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4

NOTE: If spotfacing necessary, contact AIRBUS.

(123)Subtask 536178-831-039-001 - Install the Fastener on the Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Component COMPA05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
11	ASNA2529-4	1	NUT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
36	A5381278720200	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBCAA Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAA](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBCAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Shim A5381309320000 Item 1

1 Bolt EN6115K5X7 Item 8

1 Nut ASNA2529-5 Item 6

or

1 Shim A5381309320000 Item 1

1 Bolt EN6115K5-7 Item 9

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAA](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBCAA](#)

1 Bush A5381278720200 Item 36

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBCAA](#)

1 Shim A5381309320000 Item 1

SERVICE BULLETIN

1 Bolt EN6115K4-9 Item 38

1 Nut ASNA2529-4 Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAA](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBCAA](#)

1 Shim A5381309320000 Item 1

1 Bolt EN6115K6-7 Item 3

1 Nut ASNA2529-6 Item 4

or

1 Shim A5381309320000 Item 1

1 Bolt EN6115K5Y8 Item 5

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

or

1 Shim A5381309320000 Item 1

SERVICE BULLETIN

1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(124)Subtask 536178-831-040-001 - Install the Fastener on the Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Component COMPA07				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
21	EN6115K4-11	1	BOLT	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	
24	EN6115K5X9	1	BOLT	
25	EN6115K5-9	1	BOLT	
30	ASNA2027V4-8	1	BOLT	
31	NSA5075-8	1	NUT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

Component COMPA15				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
29	A2521327620100	1	SUPPORT	
32	A2521326620200	1	SHIM	

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

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Paste Adhesive - Epoxy Potting Structure	13FBB2	As required	

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBDAA Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAA](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBDAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Temporarily put in position the support Item (29).
- 3 Mark the position of the holes H1 and H2 on the support Item (29).
- 4 Drill the holes on the support Item (29) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAA](#)

- 5 Temporarily put in position the shim Item 1.
- 6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 7 Clean the drilled area.
- 8 Install the support:

Refer to [Fig. A-FBDAA](#)

1	Support	Item (29)	Retained at removal
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with:

1	Shim	Item (32)	Retained at removal
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1	Bolt	ASNA2027V4-8	Item 30
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1	Nut	NSA5075-8	Item 31
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NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
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and at hole H1:

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K6-9	Item 22
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1	Nut	ASNA2529-6	Item 4
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or

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K5Y10	Item 23
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1	Nut	ASNA2529-5	Item 6
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SERVICE BULLETIN

1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X9	Item 24
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-9	Item 25
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAA](#)

1 If hole diameter H1 of the support Item (29) is greater than 6.35 mm (0.25 in):

a Discard the retained support Item (29).

2 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

3 Clean the drilled area.

4 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBDAA](#)

1	Bush	A5381278720400	Item 37
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5 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

6 Temporarily put in position the support Item (29) or 29.

If the support has been discard, use:

1	Support	A2521327620100	Item 29
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7 Mark the position of the holes H1 and H2 on the support Item (29) or 29.

8 Drill the holes on the support Item (29) or 29 to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAA](#)

9 Temporarily put in position the shim Item 1.

10 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

11 Clean the drilled area.

12 Install the support:

Refer to [Fig. A-FBDAA](#)

1	Support	Item (29)	Retained at removal
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If the support Item (29) has been discard:

1	Support	A2521327620100	Item 29
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with:

At Hole 11:

1	Shim	Item (32)	Retained at removal
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If the support Item (29) has been discard:

1	Shim	A2521326620200	Item 32
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1	Bolt	ASNA2027V4-8	Item 30
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1	Nut	NSA5075-8	Item 31
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NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
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and at hole H1:

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K4-11	Item 21
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1	Nut	ASNA2529-4	Item 11
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NOTE: If spotfacing necessary, contact AIRBUS.

(c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAA](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBDAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the support Item (29).

3 Mark the position of the holes H1 and H2 on the support Item (29).

4 Drill the holes on the support Item (29) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAA](#)

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the support:

Refer to [Fig. A-FBDAA](#)

1	Support	Item (29)	Retained at removal
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with:

1	Shim	Item (32)	Retained at removal
---	------	-----------	---------------------

1	Bolt	ASNA2027V4-8	Item 30
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1	Nut	NSA5075-8	Item 31
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NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
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and at hole H1:

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X9	Item 24
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-9	Item 25
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(125)Subtask 536178-831-041-001 - Install the Fastener on the Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Component COMPA09				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBEAA Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAA](#)

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Temporarily put in position the shim Item 1.
- 3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 4 Clean the drilled area.
- 5 Install the fastener with high interference:

Refer to [Fig. A-FBEAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAA](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBEAA](#)

1	Bush	A5381278720400	Item 37
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4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBEAA](#)

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K4-9	Item 38
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1	Nut	ASNA2529-4	Item 11
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NOTE: If spotfacing necessary, contact AIRBUS.

- (c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAA](#)

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Temporarily put in position the shim Item 1.

- 3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

- 4 Clean the drilled area.

- 5 Install the fastener with high interference:

Refer to [Fig. A-FBEAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(126)Subtask 536178-831-042-001 - Install the Fastener on the Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Component COMPA11				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44

References	
Fig. A-FBFAA Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAA](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBFAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6

or

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAA](#)

- 1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.
- 2 Clean the drilled area.
- 3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBFAA](#)

1	Bush	A5381278720400	Item 37
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- 4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).
- 5 Temporarily put in position the shim Item 1.
- 6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 7 Clean the drilled area.
- 8 Install the fasteners in clearance fit:

Refer to [Fig. A-FBFAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K4-9	Item 38
1	Nut	ASNA2529-4	Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(c) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAA](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBFAA](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Shim	A5381309320000	Item 1

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1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(127)Subtask 536178-400-007-001 - Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
8	EN6115K5X7	5	BOLT	
9	EN6115K5-7	5	BOLT	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001

References	
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCAAA Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCAAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Clean the drilled area.
- 3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAA](#)

a At Hole H2 to H5, and H7:

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		

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5	Bolt	EN6115K5X7	Item 8
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6
	<u>b</u> At hole H6:		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack removed and the current hole diameter < 9.40 mm (0.370 in):

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCAAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAA](#)

a At Hole H2 to H5, and H7:

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X7	Item 8
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6

b At hole H6:

1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(128)Subtask 536178-400-008-001 - Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
8	EN6115K5X7	5	BOLT	
9	EN6115K5-7	5	BOLT	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCBAA Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCBAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCBAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCBAA](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X7	Item 8
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38

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1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCBAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCBAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCBAA](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4

5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X7	Item 8
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		

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1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(129)Subtask 536178-400-009-001 - Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
8	EN6115K5X7	5	BOLT	
9	EN6115K5-7	5	BOLT	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
38	EN6115K6X6	1	BOLT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCCAA Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCCAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAA](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4

		or		
5	Bolt		EN6115K6-7	Item 3
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K5Y8	Item 5
5	Nut		ASNA2529-5	Item 6
5	Washer		NSA5368-516B	Item 7
		or		
5	Bolt		EN6115K5X7	Item 8
5	Nut		ASNA2529-5	Item 6
		or		
5	Bolt		EN6115K5-7	Item 9
5	Nut		ASNA2529-5	Item 6
		and		
1	Bolt		EN6115K6Y7	Item 42
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X6	Item 38
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-6	Item 12
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y7	Item 13
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7
		or		

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1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCCAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAA](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5

5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X7	Item 8
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-7	Item 9
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(130)Subtask 536178-400-010-001 - Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	3.50
Minimum number of person	1
Subtask elapsed time	3.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA07				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	7	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	7	NUT	
7	NSA5368-516B	7	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
19	EN6115K5-8	5	BOLT	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	
24	EN6115K5X9	1	BOLT	
25	EN6115K5-9	1	BOLT	
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
28	EN6115K5X8	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
41	EN6115K6X9	1	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
45	EN6115K6Y10	1	BOLT	
46	NSA5368-616B	7	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001

References	
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCDA Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCDA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDA](#)

1	Bolt	EN6115K6Y10	Item 45
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X9	Item 41
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6

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1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X9	Item 24
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-9	Item 25
1	Nut	ASNA2529-5	Item 6
	and		
5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X8	Item 28
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-8	Item 19
5	Nut	ASNA2529-5	Item 6
	and		

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1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCDAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDA](#)

1	Bolt	EN6115K6Y10	Item 45
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X9	Item 41
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X9	Item 24
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-9	Item 25
1	Nut	ASNA2529-5	Item 6
	and		
5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40

5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X8	Item 28
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-8	Item 19
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Bolt EN6115K5X7 Item 8

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-7 Item 9

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(131)Subtask 536178-400-011-001 - Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA09				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
19	EN6115K5-8	5	BOLT	
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
28	EN6115K5X8	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCEAA Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCEAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAA](#)

5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		

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5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	or		
5	Bolt	EN6115K5X8	Item 28
5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-8	Item 19
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCEAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAA](#)

5 Bolt EN6115K6Y9 Item 44

5 Nut ASNA2529-6 Item 4

5 Washer NSA5368-616B Item 46
or

5 Bolt EN6115K6X8 Item 40

5 Nut ASNA2529-6 Item 4
or

5 Bolt EN6115K6-8 Item 26

5 Nut ASNA2529-6 Item 4
or

5 Bolt EN6115K5Y9 Item 27

5 Nut ASNA2529-5 Item 6

5 Washer NSA5368-516B Item 7
or

5 Bolt EN6115K5X8 Item 28

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5	Nut	ASNA2529-5	Item 6
	or		
5	Bolt	EN6115K5-8	Item 19
5	Nut	ASNA2529-5	Item 6
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(132)Subtask 536178-400-012-001 - Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA11				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	6	NUT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
19	EN6115K5-8	6	BOLT	
26	EN6115K6-8	6	BOLT	
27	EN6115K5Y9	6	BOLT	
28	EN6115K5X8	6	BOLT	
40	EN6115K6X8	6	BOLT	
44	EN6115K6Y9	6	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCFAA Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAA](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAA](#)

6	Bolt	EN6115K6Y9	Item 44
6	Nut	ASNA2529-6	Item 4
6	Washer	NSA5368-616B	Item 46
	or		
6	Bolt	EN6115K6X8	Item 40
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K6-8	Item 26
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K5Y9	Item 27
6	Nut	ASNA2529-5	Item 6
6	Washer	NSA5368-516B	Item 7
	or		
6	Bolt	EN6115K5X8	Item 28
6	Nut	ASNA2529-5	Item 6
	or		
6	Bolt	EN6115K5-8	Item 19
6	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAA](#)

6	Bolt	EN6115K6Y9	Item 44
6	Nut	ASNA2529-6	Item 4
6	Washer	NSA5368-616B	Item 46
	or		
6	Bolt	EN6115K6X8	Item 40
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K6-8	Item 26
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K5Y9	Item 27
6	Nut	ASNA2529-5	Item 6
6	Washer	NSA5368-516B	Item 7
	or		
6	Bolt	EN6115K5X8	Item 28
6	Nut	ASNA2529-5	Item 6
	or		
6	Bolt	EN6115K5-8	Item 19

6 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

(133)Subtask 536178-831-043-001 - Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDAAA Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

References	
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDAAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDAAA](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or if hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install in transition fit:

Refer to [Fig. A-FDAAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDAAA](#)

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1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X5	Item 17
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-5	Item 18
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or if hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fastener in transition fit:

Refer to [Fig. A-FDAAA](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(134)Subtask 536178-831-044-001 - Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDBAA Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDBAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAA](#)

1	Bolt	EN6115K6-7	Item 3
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1	Nut	ASNA2529-6	Item 4
---	-----	------------	--------

or

1	Bolt	EN6115K5Y8	Item 5
---	------	------------	--------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
---	--------	--------------	--------

or

1	Bolt	EN6115K5X7	Item 8
---	------	------------	--------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

or

1	Bolt	EN6115K5-7	Item 9
---	------	------------	--------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDBAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAA](#)

1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Bolt EN6115K5X5 Item 17

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-5 Item 18

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAA](#)

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

1 Washer NSA5379-5W Item 47

(135)Subtask 536178-831-045-001 - Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
8	EN6115K5X7	1	BOLT	
9	EN6115K5-7	1	BOLT	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDCAA Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02
Fig. A-FECA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDCAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAA](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X7	Item 8
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDCAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAA](#)

1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1	Bolt	EN6115K5X5	Item 17
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1	Nut	ASNA2529-5	Item 6
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or

1	Bolt	EN6115K5-5	Item 18
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1	Nut	ASNA2529-5	Item 6
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NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAA](#)

1	Bolt	EN6115K5-6	Item 15
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1	Nut	ASNA2529-5	Item 6
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1	Washer	NSA5379-5W	Item 47
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(136)Subtask 536178-831-046-001 - Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA07				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	3	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	2	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDDAA Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDDAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAA](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDDAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAA](#)

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Bolt EN6115K5X6 Item 14

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAA](#)

1 Bolt EN6115K5-7 Item 9

1 Nut ASNA2529-5 Item 6

1 Washer NSA5379-5W Item 47

(137)Subtask 536178-831-047-001 - Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA09				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	2	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDEAA Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDEAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAA](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDEAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAA](#)

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6

or

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAA](#)

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(138)Subtask 536178-831-048-001 - Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA11				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	2	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
28	EN6115K5X8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDFAA Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDFAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAA](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X8	Item 28
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAA](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDFAA](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAA](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAA](#)

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Bolt EN6115K5X6 Item 14

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAA](#)

1 Bolt EN6115K5-7 Item 9

1 Nut ASNA2529-5 Item 6

1 Washer NSA5379-5W Item 47

(139)Subtask 536178-800-007-001 - Apply Protective Treatment to the Work Area at Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBAAA Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCAAA Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02
Fig. A-FDAAA Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBAAA](#), [Fig. A-FCAAA](#) and [Fig. A-FDAAA](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(140)Subtask 536178-800-008-001 - Apply Protective Treatment to the Work Area at Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBBAA Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCBAA Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02
Fig. A-FDBAA Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBBAA](#), [Fig. A-FBBAA](#) and [Fig. A-FCBAA](#)

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
---	--------	-------------

and apply finish:

Top Coat Polyurethane - Grey Internal Structure	04JME4	As required
---	--------	-------------

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
---	--------	-------------

(141)Subtask 536178-800-009-001 - Apply Protective Treatment to the Work Area at Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10

References	
Fig. A-FBCAA Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCCAA Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02
Fig. A-FDCAA Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBCAA](#), [Fig. A-FBCAA](#) and [Fig. A-FCCAA](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion		
Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey		
Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion	12ABC1	As required
Preventive		
Compound-Water		
Displacing		

(142)Subtask 536178-800-010-001 - Apply Protective Treatment to the Work Area at Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBDAA Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCDAA Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02 Sheet 03
Fig. A-FDDAA Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBDAA](#), [Fig. A-FCDAA](#) and [Fig. A-FDDAA](#)

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
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and apply finish:

Top Coat Polyurethane - Grey Internal Structure	04JME4	As required
---	--------	-------------

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(143)Subtask 536178-800-011-001 - Apply Protective Treatment to the Work Area at Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBEAA Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCEAA Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02
Fig. A-FDEAA Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBEAA](#), [Fig. A-FCEAA](#) and [Fig. A-FDEAA](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey		
Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion	12ABC1	As required
Preventive		
Compound-Water		
Displacing		

(144)Subtask 536178-800-012-001 - Apply Protective Treatment to the Work Area at Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBFAA Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCFAA Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

References	
Fig. A-FDFAA Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBFAA](#), [Fig. A-FCFAA](#) and [Fig. A-FDFAA](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion		
Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey		
Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion	12ABC1	As required
Preventive		
Compound-Water		
Displacing		

****CONF 004**

(1) Subtask 536178-000-001-002 - Remove the Fastener from Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	

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

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBAAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBAAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
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1	Nut	Item (4)	Discard
---	-----	----------	---------

b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(2) Subtask 536178-000-002-002 - Remove the Fastener from Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBBAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBBAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
---	------	----------	---------

1	Nut	Item (4)	Discard
---	-----	----------	---------

b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous 08BAA9 As required
Cleaner - General

(3) Subtask 536178-000-003-002 - Remove the Fastener from Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBCAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBCAB](#)

In accordance with SRM 51-40-20

- 1 Bolt Item (3) Discard
- 1 Nut Item (4) Discard

b Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(4) Subtask 536178-000-004-002 - Remove the Fastener from Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBDAB Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

- (a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBDAB](#)

- 1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fasteners:

Refer to [Fig. A-FBDAB](#)

In accordance with SRM 51-40-20

<1> At hole H11:

1	Shim	Item (32)	Retain
1	Bolt	Item (30)	Discard
1	Nut	Item (31)	Discard

<2> At hole H1:

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

b Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(5) Subtask 536178-000-005-002 - Remove the Fastener from Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBEAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.
and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBEAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
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1	Nut	Item (4)	Discard
---	-----	----------	---------

b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(6) Subtask 536178-000-006-002 - Remove the Fastener from Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBFAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBFAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
---	------	----------	---------

1	Nut	Item (4)	Discard
---	-----	----------	---------

b Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(7) Subtask 536178-000-007-001 - Remove the Fasteners from Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCAAB](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(8) Subtask 536178-000-008-001 - Remove the Fasteners from Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCBAB](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(9) Subtask 536178-000-009-001 - Remove the Fasteners from Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCCAB](#)

In accordance with SRM 51-40-20

7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(10) Subtask 536178-000-010-003 - Remove the Fasteners from Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	2.50
Minimum number of person	1
Subtask elapsed time	2.50
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCDAB Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCDAB](#)

In accordance with SRM 51-40-20

7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(c) If the frame foot is not cut:

1 Remove the support:

1 Support Item (20) Retain

(11) Subtask 536178-000-011-001 - Remove the Fasteners from Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCEAB](#)

In accordance with SRM 51-40-20

6 Bolt Item (3) Discard

6 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(12) Subtask 536178-000-012-001 - Remove the Fasteners from Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCFAB](#)

In accordance with SRM 51-40-20

6 Bolt Item (3) Discard

6 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(13) Subtask 536178-000-013-002 - Remove the Fasteners from Holes H8 and H9 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDAAB Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDAAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDAAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(14) Subtask 536178-000-014-002 - Remove the Fasteners from Holes H8 and H9 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDBAB Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDBAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDBAB](#).

(c) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(15) Subtask 536178-000-015-002 - Remove the Fasteners from Holes H9 and H10 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDCAB Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDCAB](#)

In accordance with SRM 51-40-20

- 2 Bolt Item (3) Discard
- 2 Nut Item (4) Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDCAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(16) Subtask 536178-000-016-002 - Remove the Fasteners from Holes H9 and H10 of Frame 44, LH Side

Work Zones and Access Panels			
Zone	Access/Work location		
241	Work location	Frame 44	

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDDAB Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDDAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDDAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(17) Subtask 536178-000-017-002 - Remove the Fasteners from Holes H8 and H9 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20

References	
Fig. A-FDEAB Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDEAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDEAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(18) Subtask 536178-000-018-002 - Remove the Fasteners from Holes H8 and H9 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	

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

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDFAB Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Remove the Fasteners:

Refer to [Fig. A-FDFAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDFAB](#).

(c) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(19) Subtask 536178-250-001-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFAAA Flowchart for the Hole H1 of Frame 41, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFAAA](#) and [Fig. A-FEAAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-001 001 Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-013 002 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-013 002 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-013 002 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-013 002 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (a).

(20) Subtask 536178-250-002-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFBAA Flowchart for the Hole H1 of Frame 42, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFBAA](#) and [Fig. A-FEBAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-002 001 Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-014 002 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-014 002 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-014 002 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-014 002 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (a).

(21) Subtask 536178-250-003-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFCAA Flowchart for the Hole H1 of Frame 43, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFCAA](#) and [Fig. A-FECAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-003 001 Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-015 002 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-015 002 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-015 002 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-015 002 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (a).

(22) Subtask 536178-250-004-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFDAA Flowchart for the Hole H1 of Frame 44, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFDAA](#) and [Fig. A-FEDAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-004 001 Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-016 002 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-016 002 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-016 002 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-016 002 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (a).

(23) Subtask 536178-250-005-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FFEAA Flowchart for the Hole H1 of Frame 45, LH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFEAA](#) and [Fig. A-FEGAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-005 001 Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-017 002 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-017 002 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-017 002 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-017 002 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (a).

(24) Subtask 536178-250-006-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFFAA Flowchart for the Hole H1 of Frame 46, LH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFFAA](#) and [Fig. A-FEFAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-004 001 Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-018 002 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-018 002 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-018 002 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (b).
- 4 If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-018 002 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (a).

(25) Subtask 536178-250-007-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFMAA Flowchart for the Hole H2 to H7 from Frame 41, LH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFMAA](#) and [Fig. A-FEAAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-007 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-001 002 Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side workstep (b).

2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-001 002 Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side workstep (a).

(26) Subtask 536178-250-008-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFNAA Flowchart for the Hole H2 to H7 from Frame 42, LH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFNAA](#) and [Fig. A-FEBAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-008 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-002 002 Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-002 002 Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side workstep (a).

(27) Subtask 536178-250-009-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFO Flowchart for the Hole H2 to H8 from Frame 43, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFO](#) and [Fig. A-FECA](#)

- 1 If crack found:
 - a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-009 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side .
 - b Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)
 - c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.
 - d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.
 - e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.
 - f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-003 002 Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-003 002 Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side workstep (a).

(28) Subtask 536178-250-010-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFPAA Flowchart for the Hole H2 to H8 from Frame 44, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFPAA](#) and [Fig. A-FEDAA](#)

1 If crack found:

a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-010 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

- f If crack removed and the current hole diameter \leq 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-004 002 Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-004 002 Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side workstep (a).

(29) Subtask 536178-250-011-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFQAA Flowchart for the Hole H2 to H7 from Frame 45, LH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFQAA](#) and [Fig. A-FEGAA](#)

- 1 If crack found:
 - a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-011 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side .

- b Do an eddy-current rotating probe testing of the holes H2 to H7.
Refer to NTM 51-10-18 and NTM 51-10-01
Refer to [Fig. A-FEGAA](#)
- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):
<1> Do workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
<1> Do the SUBTASK 536178-400-005 002 Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-005 002 Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side workstep (a).

(30) Subtask 536178-250-012-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FFRAA Flowchart for the Hole H2 to H7 from Frame 46, LH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFRAA](#) and [Fig. A-FEFAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-012 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-006 002 Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side workstep (b).

2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-006 002 Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side workstep (a).

(31) Subtask 536178-250-013-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

- 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 41, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

- 1 If cracks found:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no cracks found:
 - a Do the SUBTASK 536178-831-019 002 Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side

(32) Subtask 536178-250-014-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 42, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-020 002 Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side

(33) Subtask 536178-250-015-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 43, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-021 002 Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side

(34) Subtask 536178-250-016-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 44, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-022 002 Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side

(35) Subtask 536178-250-017-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 45, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-023 002 Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side

(36) Subtask 536178-250-018-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 46, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-024 002 Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side

(37) Subtask 536178-831-001-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBAAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(38) Subtask 536178-831-002-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBBAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(39) Subtask 536178-831-003-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBCAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(40) Subtask 536178-831-004-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBDAB Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBDAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(41) Subtask 536178-831-005-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBEAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(42) Subtask 536178-831-006-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBFAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(43) Subtask 536178-831-007-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCAAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(44) Subtask 536178-831-008-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCBAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(45) Subtask 536178-831-009-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCCAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(46) Subtask 536178-831-010-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCDAB Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCDAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(47) Subtask 536178-831-011-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCEAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(48) Subtask 536178-831-012-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCFAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(49) Subtask 536178-831-013-002 - Install the Fastener on the Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Component COMPA02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBAAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBAAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBAAB](#)

1	Bush	A5381278720600	Item 2
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4 Ream the hole on the bush Item 2 to the applicable fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBAAB](#)

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K4-8	Item 10
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1	Nut	ASNA2529-4	Item 11
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NOTE: If spotfacing necessary, contact AIRBUS.

- (e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAB](#). It must be as near the current hole diameter + 0.80

mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.
- 3 Temporarily put in position the shim Item 1.
- 4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.
- 5 Clean the drilled area.
- 6 Install the fastener with high interference:

Refer to [Fig. A-FBAAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(50) Subtask 536178-831-014-002 - Install the Fastener on the Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Component COMPA04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

- (a) If the fastener at hole H1 has not been removed:
 - 1 No further action required for the hole H1 only.
- (b) If the fastener at hole H1 has been removed:
 - 1 Apply the instruction given in the following steps.
- (c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):
 - Refer to AMM 20-21-12, Page Block 001
 - In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30
 - Refer to [Fig. A-FBBAB](#)

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.
- 3 Temporarily put in position the shim Item 1.
- 4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 5 Clean the drilled area.
- 6 Install the fastener with high interference:

Refer to [Fig. A-FBBAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAB](#)

- 1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.
- 2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBBAB](#)

1 Bush A5381278720600 Item 2

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBBAB](#)

1 Shim A5381309320000 Item 1

1 Bolt EN6115K4-8 Item 10

1 Nut ASNA2529-4 Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBBAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(51) Subtask 536178-831-015-002 - Install the Fastener on the Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Component COMPA06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
36	A5381278720200	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAB](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBCAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBCAB](#)

1	Bush	A5381278720200	Item 36
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4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in clearance fit:

Refer to [Fig. A-FBCAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K4-9	Item 38
1	Nut	ASNA2529-4	Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBCAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6

1 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(52) Subtask 536178-831-016-002 - Install the Fastener on the Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Component COMPA08				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
21	EN6115K4-11	1	BOLT	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	
30	ASNA2027V4-8	1	BOLT	
31	NSA5075-8	1	NUT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

Component COMPA15				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
20	A2521327620000	1	SUPPORT	
32	A2521326620200	1	SHIM	

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

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Paste Adhesive - Epoxy Potting Structure	13FBB2	As required	

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBDAB Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

- (a) If the fastener at hole H1 has not been removed:
 - 1 No further action required for the hole H1 only.
- (b) If the fastener at hole H1 has been removed:
 - 1 Apply the instruction given in the following steps.
- (c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):
 - Refer to AMM 20-21-12, Page Block 001
 - Refer to AMM 20-21-12, Page Block 001
 - In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30
 - Refer to [Fig. A-FBDAB](#)
 - 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.
 - NOTE:** Find the final hole diameter in the fasteners table given in [Fig. A-FBDAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.
 - 2 Temporarily put in position the support Item (20).
 - 3 Mark the position of the holes H1 and H2 on the support Item (20).

4 Drill the holes on the support Item (20) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAB](#)

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the support:

Refer to [Fig. A-FBDAB](#)

1	Support	Item (20)	Retained at removal
---	---------	-----------	---------------------

with:

1	Shim	Item (32)	Retained at removal
---	------	-----------	---------------------

1	Bolt	ASNA2027V4-8	Item 30
---	------	--------------	---------

1	Nut	NSA5075-8	Item 31
---	-----	-----------	---------

NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
--	--------	-------------

and at hole H1:

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K6-9	Item 22
---	------	------------	---------

1	Nut	ASNA2529-6	Item 4
---	-----	------------	--------

or

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K5Y10	Item 23
---	------	-------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
---	--------	--------------	--------

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAB](#)

1 If hole diameter H1 of the support Item (20) is greater than 6.35 mm (0.25 in):

a Discard the retained support Item (20).

2 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

3 Clean the drilled area.

4 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBDAB](#)

1 Bush A5381278720400 Item 37

5 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

6 Temporarily put in position the support Item (20).

If the support has been discard, use:

1 Support A2521327620000 Item 20

7 Mark the position of the holes H1 and H2 on the support Item (20) or 20.

8 Drill the holes on the support Item (20) or 20 to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAB](#)

9 Temporarily put in position the shim Item 1.

10 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

11 Clean the drilled area.

12 Install the support:

Refer to [Fig. A-FBDAB](#)

1 Support Item (20) Retained at removal

If the support Item (20) has been discard:

1 Support A2521327620000 Item 20

with:

At Hole 11:

1 Shim Item (32) Retained at removal

If the support Item (20) has been discard:

1 Shim A2521326620200 Item 32

1 Bolt ASNA2027V4-8 Item 30

1 Nut NSA5075-8 Item 31

NOTE: Install the shim Item (32) with:

Paste Adhesive - 13FBB2 As required
Epoxy Potting
Structure

and at hole H1:

1 Shim A5381309320000 Item 1

1 Bolt EN6115K4-11 Item 21

1 Nut ASNA2529-4 Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBDAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the support Item (20).

3 Mark the position of the holes H1 and H2 on the support Item (20).

4 Drill the holes on the support Item (20) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAB](#)

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the support:

Refer to [Fig. A-FBDAB](#)

1	Support	Item (20)	Retained at removal
---	---------	-----------	---------------------

with:

1	Shim	Item (32)	Retained at removal
---	------	-----------	---------------------

1	Bolt	ASNA2027V4-8	Item 30
---	------	--------------	---------

1	Nut	NSA5075-8	Item 31
---	-----	-----------	---------

NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
--	--------	-------------

and at hole H1:

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K6-9	Item 22
---	------	------------	---------

1	Nut	ASNA2529-6	Item 4
---	-----	------------	--------

or

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K5Y10	Item 23
---	------	-------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
---	--------	--------------	--------

NOTE: If spotfacing necessary, contact AIRBUS.

(53) Subtask 536178-831-017-002 - Install the Fastener on the Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Component COMPA10				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAB](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBEAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBEAB](#)

1	Bush	A5381278720400	Item 37
---	------	----------------	---------

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBEAB](#)

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K4-9	Item 38
---	------	------------	---------

1	Nut	ASNA2529-4	Item 11
---	-----	------------	---------

NOTE: If spotfacing necessary, contact AIRBUS.

- (e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBEAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(54) Subtask 536178-831-018-002 - Install the Fastener on the Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Component COMPA12				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

- (a) If the fastener at hole H1 has not been removed:
 - 1 No further action required for the hole H1 only.
- (b) If the fastener at hole H1 has been removed:
 - 1 Apply the instruction given in the following steps.
- (c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):
 - Refer to AMM 20-21-12, Page Block 001
 - In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAB](#)

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Temporarily put in position the shim Item 1.
- 3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 4 Clean the drilled area.
- 5 Install the fastener with high interference:

Refer to [Fig. A-FBFAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAB](#)

- 1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.
- 2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBFAB](#)

1 Bush A5381278720400 Item 37

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in clearance fit:

Refer to [Fig. A-FBFAB](#)

1 Shim A5381309320000 Item 1

1 Bolt EN6115K4-9 Item 38

1 Nut ASNA2529-4 Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter ≤ 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBFAB](#)

SERVICE BULLETIN

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(55) Subtask 536178-400-001-002 - Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Clean the drilled area.
- 3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAB](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7

		and		
1	Bolt		EN6115K6Y7	Item 42
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X6	Item 38
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-6	Item 12
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y7	Item 13
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack removed and the current hole diameter < 9.40 mm (0.370 in):

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCAAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAB](#)

5	Bolt		EN6115K6Y8	Item 43
5	Nut		ASNA2529-6	Item 4
5	Washer		NSA5368-616B	Item 46
		or		
5	Bolt		EN6115K6X7	Item 39

5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(56) Subtask 536178-400-002-002 - Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	1	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig.](#)

A-FCBAB. It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCBAB](#)

1	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCBAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCBAB](#)

1	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7

and

1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(57) Subtask 536178-400-003-002 - Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
7	NSA5368-516B	6	WASHER	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAB](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46

		or		
5	Bolt		EN6115K6X7	Item 39
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K6-7	Item 3
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K5Y8	Item 5
5	Nut		ASNA2529-5	Item 6
5	Washer		NSA5368-516B	Item 7
		and		
1	Bolt		EN6115K6Y7	Item 42
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X6	Item 38
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-6	Item 12
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y7	Item 13
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAB](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4

or

1 Bolt EN6115K6-6 Item 12

1 Nut ASNA2529-6 Item 4

or

1 Bolt EN6115K5Y7 Item 13

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(58) Subtask 536178-400-004-002 - Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	3.50
Minimum number of person	1
Subtask elapsed time	3.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA08				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	7	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	7	NUT	
7	NSA5368-516B	7	WASHER	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
41	EN6115K6X9	1	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
45	EN6115K6Y10	1	BOLT	
46	NSA5368-616B	7	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCDAB Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCDAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDAB](#)

1	Bolt	EN6115K6Y10	Item 45
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X9	Item 41
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		

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1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	and		
5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		

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1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCDAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDAB](#)

1	Bolt	EN6115K6Y10	Item 45
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X9	Item 41
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

		and		
5	Bolt		EN6115K6Y9	Item 44
5	Nut		ASNA2529-6	Item 4
5	Washer		NSA5368-616B	Item 46
		or		
5	Bolt		EN6115K6X8	Item 40
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K6-8	Item 26
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K5Y9	Item 27
5	Nut		ASNA2529-5	Item 6
5	Washer		NSA5368-516B	Item 7
		and		
1	Bolt		EN6115K6Y8	Item 43
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X7	Item 39
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-7	Item 3
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y8	Item 5
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(59) Subtask 536178-400-005-002 - Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA10				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAB](#)

5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39

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1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAB](#)

5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26

5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(60) Subtask 536178-400-006-002 - Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA12				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	6	NUT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
26	EN6115K6-8	6	BOLT	
27	EN6115K5Y9	6	BOLT	
40	EN6115K6X8	6	BOLT	
44	EN6115K6Y9	6	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAB](#)

6	Bolt	EN6115K6Y9	Item 44
6	Nut	ASNA2529-6	Item 4

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6	Washer	NSA5368-616B	Item 46
	or		
6	Bolt	EN6115K6X8	Item 40
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K6-8	Item 26
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K5Y9	Item 27
6	Nut	ASNA2529-5	Item 6
6	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAB](#)

6	Bolt	EN6115K6Y9	Item 44
6	Nut	ASNA2529-6	Item 4
6	Washer	NSA5368-616B	Item 46
	or		
6	Bolt	EN6115K6X8	Item 40
6	Nut	ASNA2529-6	Item 4

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or

6 Bolt EN6115K6-8 Item 26

6 Nut ASNA2529-6 Item 4

or

6 Bolt EN6115K5Y9 Item 27

6 Nut ASNA2529-5 Item 6

6 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(61) Subtask 536178-831-019-002 - Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001

References	
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDAAB Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDAAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- 3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:
- a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or if hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

- b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fastener in transition fit:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

- (b) Install the new fastener at hole H9:

Refer to [Fig. A-FDAAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

- 1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

- 2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

- a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- b Clean the drilled area.

- c Install the fastener with high interference:

Refer to [Fig. A-FDAAB](#)

SERVICE BULLETIN

1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X5	Item 17
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-5	Item 18
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or if hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(62) Subtask 536178-831-020-002 - Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDBAB Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAB](#)

1	Bolt	EN6115K6-7	Item 3
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1	Nut	ASNA2529-6	Item 4
---	-----	------------	--------

or

1	Bolt	EN6115K5Y8	Item 5
---	------	------------	--------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
---	--------	--------------	--------

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAB](#)

1	Bolt	EN6115K5-8	Item 19
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1 Washer NSA5379-5W Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAB](#)

1 Bolt EN6115K5Y6 Item 16

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

or

1 Bolt EN6115K5X5 Item 17

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-5 Item 18

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAB](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(63) Subtask 536178-831-021-002 - Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDCAB Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K5Y6	Item 16
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1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
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or

1	Bolt	EN6115K5X5	Item 17
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

or

1	Bolt	EN6115K5-5	Item 18
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(64) Subtask 536178-831-022-002 - Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA08				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44

References	
Fig. A-FDDAB Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDDAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAB](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDDAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAB](#)

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

- or
- 1 Bolt EN6115K5X6 Item 14
- 1 Nut ASNA2529-5 Item 6
- or
- 1 Bolt EN6115K5-6 Item 15
- 1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- 3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:
 - a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
 - b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):
 - <1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame
 - <2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.
 - <3> Clean the drilled area.
 - <4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAB](#)

- 1 Bolt EN6115K5-7 Item 9
- 1 Nut ASNA2529-5 Item 6
- 1 Washer NSA5379-5W Item 47

(65) Subtask 536178-831-023-002 - Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA10				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDEAB Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAB](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

1 Washer NSA5379-5W Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAB](#)

1 Bolt EN6115K5Y7 Item 13

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

or

1 Bolt EN6115K5X6 Item 14

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- 3** If (edge distance) / (hole diameter + 1.6 mm) < 1.27:
- a** If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):
- <1> Contact AIRBUS before next flight and follow their instructions.
- b** If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):
- <1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame
- <2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.
- <3> Clean the drilled area.
- <4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAB](#)

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(66) Subtask 536178-831-024-002 - Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA12				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDFAB Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDFAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDFAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K5Y7	Item 13
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1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
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or

1	Bolt	EN6115K5X6	Item 14
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

or

1	Bolt	EN6115K5-6	Item 15
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1	Nut	ASNA2529-5	Item 6
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NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(67) Subtask 536178-800-001-001 - Apply Protective Treatment to the Work Area at Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02
Fig. A-FDAAB Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBAAB](#), [Fig. A-FCAAB](#) and [Fig. A-FDAAB](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(68) Subtask 536178-800-002-001 - Apply Protective Treatment to the Work Area at Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02
Fig. A-FDBAB Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBBAB](#), [Fig. A-FBBAB](#) and [Fig. A-FCBAB](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion		
Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey		
Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(69) Subtask 536178-800-003-001 - Apply Protective Treatment to the Work Area at Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02
Fig. A-FDCAB Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBCAB](#), [Fig. A-FBCAB](#) and [Fig. A-FCCAB](#)

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
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and apply finish:

Top Coat Polyurethane - Grey Internal Structure	04JME4	As required
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(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(70) Subtask 536178-800-004-001 - Apply Protective Treatment to the Work Area at Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBDAB Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCDAB Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02
Fig. A-FDDAB Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBDAB](#), [Fig. A-FCDAB](#) and [Fig. A-FDDAB](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion Inhibiting		

and apply finish:

Top Coat 04JME4 As required
 Polyurethane - Grey
 Internal Structure

(b) Apply on the work area below the floor level:

Corrosion 12ABC1 As required
 Preventive
 Compound-Water
 Displacing

(71) Subtask 536178-800-005-001 - Apply Protective Treatment to the Work Area at Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02
Fig. A-FDEAB Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBEAB](#), [Fig. A-FCEAB](#) and [Fig. A-FDEAB](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(72) Subtask 536178-800-006-001 - Apply Protective Treatment to the Work Area at Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02
Fig. A-FDFAB Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBFAB](#), [Fig. A-FCFAB](#) and [Fig. A-FDFAB](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion		
Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey		
Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion	12ABC1	As required
Preventive		
Compound-Water		
Displacing		

(73) Subtask 536178-000-019-002 - Remove the Fastener from Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBAAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBAAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
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1	Nut	Item (4)	Discard
---	-----	----------	---------

b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(74) Subtask 536178-000-020-002 - Remove the Fastener from Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBBAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBBAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

b Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(75) Subtask 536178-000-021-002 - Remove the Fastener from Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBCAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBCAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

b Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(76) Subtask 536178-000-022-002 - Remove the Fastener from Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBDAB Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBDAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fasteners:

Refer to [Fig. A-FBDAB](#)

In accordance with SRM 51-40-20

<1> At hole H11:

1	Shim	Item (32)	Retain
1	Bolt	Item (30)	Discard
1	Nut	Item (31)	Discard

<2> At hole H1:

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(77) Subtask 536178-000-023-002 - Remove the Fastener from Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBEAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBEAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
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1	Nut	Item (4)	Discard
---	-----	----------	---------

b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous 08BAA9 As required
Cleaner - General

(78) Subtask 536178-000-024-002 - Remove the Fastener from Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBFAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBFAB](#)

In accordance with SRM 51-40-20

- 1 Bolt Item (3) Discard
- 1 Nut Item (4) Discard

b Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(79) Subtask 536178-000-025-001 - Remove the Fasteners from Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCAAB](#)

In accordance with SRM 51-40-20

- 6 Bolt Item (3) Discard
- 6 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(80) Subtask 536178-000-026-001 - Remove the Fasteners from Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCBAB](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(81) Subtask 536178-000-027-001 - Remove the Fasteners from Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCCAB](#)

In accordance with SRM 51-40-20

7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(82) Subtask 536178-000-028-002 - Remove the Fasteners from Holes H2 to H8 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	2.50
Minimum number of person	1
Subtask elapsed time	2.50
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCDAB Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCDAB](#)

In accordance with SRM 51-40-20

7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(c) If the frame foot is not cut:

1 Remove the support:

1 Support Item (20) Retain

(83) Subtask 536178-000-029-001 - Remove the Fasteners from Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCEAB](#)

In accordance with SRM 51-40-20

6 Bolt Item (3) Discard

6 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(84) Subtask 536178-000-030-001 - Remove the Fasteners from Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCFAB](#)

In accordance with SRM 51-40-20

6 Bolt Item (3) Discard

6 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(85) Subtask 536178-000-031-002 - Remove the Fasteners from Holes H8 and H9 of Frame 41, RH Side

Work Zones and Access Panels			
Zone	Access/Work location		
242	Work location	Frame 41	

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDAAB Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDAAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDAAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(86) Subtask 536178-000-032-002 - Remove the Fasteners from Holes H8 and H9 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDBAB Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDBAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDBAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(87) Subtask 536178-000-033-002 - Remove the Fasteners from Holes H9 and H10 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDCAB Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDCAB](#)

In accordance with SRM 51-40-20

- 2 Bolt Item (3) Discard
- 2 Nut Item (4) Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDCAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(88) Subtask 536178-000-034-002 - Remove the Fasteners from Holes H9 and H10 of Frame 44, RH Side

Work Zones and Access Panels			
Zone	Access/Work location		
242	Work location	Frame 44	

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDDAB Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDDAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDDAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(89) Subtask 536178-000-035-002 - Remove the Fasteners from Holes H8 and H9 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20

References	
Fig. A-FDEAB Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDEAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDEAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(90) Subtask 536178-000-036-002 - Remove the Fasteners from Holes H8 and H9 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	

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

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDFAB Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Remove the Fasteners:

Refer to [Fig. A-FDFAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDFAB](#).

(c) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(91) Subtask 536178-250-019-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFGAA Flowchart for the Hole H1 of Frame 41, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFGAA](#) and [Fig. A-FEAAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-025 001 Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-037 002 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-037 002 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-037 002 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-037 002 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (a).

(92) Subtask 536178-250-020-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFHAA Flowchart for the Hole H1 of Frame 42, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFHAA](#) and [Fig. A-FEBAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-026 001 Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-038 002 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-038 002 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):

a Do SUBTASK 536178-831-038 002 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (b).

4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):

a Do SUBTASK 536178-831-038 002 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (a).

(93) Subtask 536178-250-021-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFIAA Flowchart for the Hole H1 of Frame 43, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFIAA](#) and [Fig. A-FECAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-027 001 Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-039 002 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-039 002 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-039 002 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-039 002 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (a).

(94) Subtask 536178-250-022-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFJAA Flowchart for the Hole H1 of Frame 44, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFJAA](#) and [Fig. A-FEDAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-028 001 Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-040 002 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-040 002 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-040 002 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-040 002 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (a).

(95) Subtask 536178-250-023-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FFKAA Flowchart for the Hole H1 of Frame 45, RH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFKAA](#) and [Fig. A-FEGAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-029 001 Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-041 002 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-041 002 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-041 002 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-041 002 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (a).

(96) Subtask 536178-250-024-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFLAA Flowchart for the Hole H1 of Frame 46, RH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFLAA](#) and [Fig. A-FEFAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-030 001 Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-042 002 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-042 002 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-042 002 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-042 002 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (a).

(97) Subtask 536178-250-025-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFSAA Flowchart for the Hole H2 to H7 from Frame 41, RH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFSAA](#) and [Fig. A-FEAAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-031 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-007 002 Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side workstep (b).

2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-007 002 Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side workstep (a).

(98) Subtask 536178-250-026-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFTAA Flowchart for the Hole H2 to H7 from Frame 42, RH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFTAA](#) and [Fig. A-FEBAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-032 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-008 002 Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-008 002 Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side workstep (a).

(99) Subtask 536178-250-027-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFUAA Flowchart for the Hole H2 to H8 from Frame 43, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFUAA](#) and [Fig. A-FECAA](#)

- 1 If crack found:
 - a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-033 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side .
 - b Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)
 - c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.
 - d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.
 - e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.
 - f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-009 002 Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-009 002 Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side workstep (a).

(100)Subtask 536178-250-028-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFVAA Flowchart for the Hole H2 to H8 from Frame 44, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFVAA](#) and [Fig. A-FEDAA](#)

1 If crack found:

a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-034 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

- f If crack removed and the current hole diameter \leq 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-010 002 Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-010 002 Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side workstep (a).

(101)Subtask 536178-250-029-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFWAA Flowchart for the Hole H2 to H7 from Frame 45, RH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFWAA](#) and [Fig. A-FEGAA](#)

- 1 If crack found:
 - a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-035 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side .

- b Do an eddy-current rotating probe testing of the holes H2 to H7.
Refer to NTM 51-10-18 and NTM 51-10-01
Refer to [Fig. A-FEGAA](#)
- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):
<1> Do workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
<1> Do the SUBTASK 536178-400-011 002 Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-011 002 Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side workstep (a).

(102)Subtask 536178-250-030-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FFXAA Flowchart for the Hole H2 to H7 from Frame 46, RH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFXAA](#) and [Fig. A-FEFAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-036 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-012 002 Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side workstep (b).

2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-012 002 Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side workstep (a).

(103)Subtask 536178-250-031-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 41, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-043 002 Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side

(104)Subtask 536178-250-032-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 42, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-044 002 Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side

(105)Subtask 536178-250-033-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 43, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-045 002 Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side

(106)Subtask 536178-250-034-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

- (a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:
 - 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
 - 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.
- (b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 44, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

- 1 If cracks found:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no cracks found:
 - a Do the SUBTASK 536178-831-046 002 Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side

(107)Subtask 536178-250-035-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 45, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-047 002 Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side

(108)Subtask 536178-250-036-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

- (a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:
 - 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
 - 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.
- (b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 46, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

- 1 If cracks found:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no cracks found:
 - a Do the SUBTASK 536178-831-048 002 Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side

(109)Subtask 536178-831-025-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS GREATER THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBAAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(110)Subtask 536178-831-026-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBBAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(111)Subtask 536178-831-027-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBCAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(112)Subtask 536178-831-028-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBDAB Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBDAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(113)Subtask 536178-831-029-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBEAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(114)Subtask 536178-831-030-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBFAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(115)Subtask 536178-831-031-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCAAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(116)Subtask 536178-831-032-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCBAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(117)Subtask 536178-831-033-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCCAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(118)Subtask 536178-831-034-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCDAB Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCDAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(119)Subtask 536178-831-035-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCEAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(120)Subtask 536178-831-036-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCFAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(121)Subtask 536178-831-037-002 - Install the Fastener on the Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Component COMPA02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBAAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBAAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBAAB](#)

1	Bush	A5381278720600	Item 2
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4 Ream the hole on the bush Item 2 to the applicable fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBAAB](#)

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K4-8	Item 10
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1	Nut	ASNA2529-4	Item 11
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NOTE: If spotfacing necessary, contact AIRBUS.

- (e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAB](#). It must be as near the current hole diameter + 0.80

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mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.
- 3 Temporarily put in position the shim Item 1.
- 4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.
- 5 Clean the drilled area.
- 6 Install the fastener with high interference:

Refer to [Fig. A-FBAAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(122)Subtask 536178-831-038-002 - Install the Fastener on the Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Component COMPA04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

- (a) If the fastener at hole H1 has not been removed:
 - 1 No further action required for the hole H1 only.
- (b) If the fastener at hole H1 has been removed:
 - 1 Apply the instruction given in the following steps.
- (c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):
 - Refer to AMM 20-21-12, Page Block 001
 - In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30
 - Refer to [Fig. A-FBBAB](#)

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.
- 3 Temporarily put in position the shim Item 1.
- 4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 5 Clean the drilled area.
- 6 Install the fastener with high interference:

Refer to [Fig. A-FBBAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAB](#)

- 1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.
- 2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBBAB](#)

1 Bush A5381278720600 Item 2

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBBAB](#)

1 Shim A5381309320000 Item 1

1 Bolt EN6115K4-8 Item 10

1 Nut ASNA2529-4 Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter ≤ 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBBAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(123)Subtask 536178-831-039-002 - Install the Fastener on the Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Component COMPA06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
36	A5381278720200	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAB](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBCAB](#)

1 Shim A5381309320000 Item 1

1 Bolt EN6115K6-7 Item 3

1 Nut ASNA2529-6 Item 4

or

1 Shim A5381309320000 Item 1

1 Bolt EN6115K5Y8 Item 5

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBCAB](#)

1 Bush A5381278720200 Item 36

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in clearance fit:

Refer to [Fig. A-FBCAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K4-9	Item 38
1	Nut	ASNA2529-4	Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBCAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6

1 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(124)Subtask 536178-831-040-002 - Install the Fastener on the Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Component COMPA08				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
21	EN6115K4-11	1	BOLT	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	
30	ASNA2027V4-8	1	BOLT	
31	NSA5075-8	1	NUT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

Component COMPA15				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
29	A2521327620100	1	SUPPORT	
32	A2521326620200	1	SHIM	

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

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Paste Adhesive - Epoxy Potting Structure	13FBB2	As required	

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBDAB Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAB](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBDAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Temporarily put in position the support Item (29).

3 Mark the position of the holes H1 and H2 on the support Item (29).

4 Drill the holes on the support Item (29) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAB](#)

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the support:

Refer to [Fig. A-FBDAB](#)

1	Support	Item (29)	Retained at removal
---	---------	-----------	---------------------

with:

1	Shim	Item (32)	Retained at removal
---	------	-----------	---------------------

1	Bolt	ASNA2027V4-8	Item 30
---	------	--------------	---------

1	Nut	NSA5075-8	Item 31
---	-----	-----------	---------

NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
--	--------	-------------

and at hole H1:

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K6-9	Item 22
---	------	------------	---------

1	Nut	ASNA2529-6	Item 4
---	-----	------------	--------

or

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K5Y10	Item 23
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1	Nut	ASNA2529-5	Item 6
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1	Washer	NSA5368-516B	Item 7
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NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAB](#)

1 If hole diameter H1 of the support Item (29) is greater than 6.35 mm (0.25 in):

a Discard the retained support Item (29).

2 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

3 Clean the drilled area.

4 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBDAB](#)

1 Bush A5381278720400 Item 37

5 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

6 Temporarily put in position the support Item (29) or 29.

If the support has been discard, use:

1 Support A2521327620100 Item 29

7 Mark the position of the holes H1 and H2 on the support Item (29) or 29.

8 Drill the holes on the support Item (29) or 29 to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAB](#)

9 Temporarily put in position the shim Item 1.

10 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

11 Clean the drilled area.

12 Install the support:

Refer to [Fig. A-FBDAB](#)

1 Support Item (29) Retained at removal

If the support Item (29) has been discard:

1 Support A2521327620100 Item 29

with:

At Hole 11:

1 Shim Item (32) Retained at removal

If the support Item (20) has been discard:

1 Shim A2521326620200 Item 32

1 Bolt ASNA2027V4-8 Item 30

1 Nut NSA5075-8 Item 31

NOTE: Install the shim Item (32) with:

Paste Adhesive - 13FBB2 As required
Epoxy Potting
Structure

and at hole H1:

1 Shim A5381309320000 Item 1

1 Bolt EN6115K4-11 Item 21

1 Nut ASNA2529-4 Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBDAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the support Item (29).

3 Mark the position of the holes H1 and H2 on the support Item (29).

4 Drill the holes on the support Item (29) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAB](#)

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the support:

Refer to [Fig. A-FBDAB](#)

1	Support	Item (29)	Retained at removal
---	---------	-----------	---------------------

with:

1	Shim	Item (32)	Retained at removal
---	------	-----------	---------------------

1	Bolt	ASNA2027V4-8	Item 30
---	------	--------------	---------

1	Nut	NSA5075-8	Item 31
---	-----	-----------	---------

NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
--	--------	-------------

and at hole H1:

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K6-9	Item 22
---	------	------------	---------

1	Nut	ASNA2529-6	Item 4
---	-----	------------	--------

or

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K5Y10	Item 23
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1	Nut	ASNA2529-5	Item 6
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1	Washer	NSA5368-516B	Item 7
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NOTE: If spotfacing necessary, contact AIRBUS.

(125)Subtask 536178-831-041-002 - Install the Fastener on the Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Component COMPA10				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAB](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBEAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBEAB](#)

1	Bush	A5381278720400	Item 37
---	------	----------------	---------

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBEAB](#)

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K4-9	Item 38
---	------	------------	---------

1	Nut	ASNA2529-4	Item 11
---	-----	------------	---------

NOTE: If spotfacing necessary, contact AIRBUS.

- (e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAB](#)

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Temporarily put in position the shim Item 1.
- 3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 4 Clean the drilled area.
- 5 Install the fastener with high interference:

Refer to [Fig. A-FBEAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(126)Subtask 536178-831-042-002 - Install the Fastener on the Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Component COMPA12				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

- (a) If the fastener at hole H1 has not been removed:
 - 1 No further action required for the hole H1 only.
- (b) If the fastener at hole H1 has been removed:
 - 1 Apply the instruction given in the following steps.
- (c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):
 - Refer to AMM 20-21-12, Page Block 001
 - In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAB](#)

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Temporarily put in position the shim Item 1.
- 3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 4 Clean the drilled area.
- 5 Install the fastener with high interference:

Refer to [Fig. A-FBFAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAB](#)

- 1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.
- 2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBFAB](#)

1 Bush A5381278720400 Item 37

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in clearance fit:

Refer to [Fig. A-FBFAB](#)

1 Shim A5381309320000 Item 1

1 Bolt EN6115K4-9 Item 38

1 Nut ASNA2529-4 Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBFAB](#)

SERVICE BULLETIN

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(127)Subtask 536178-400-007-002 - Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Clean the drilled area.
- 3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAB](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7

		and		
1	Bolt		EN6115K6Y7	Item 42
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X6	Item 38
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-6	Item 12
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y7	Item 13
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack removed and the current hole diameter < 9.40 mm (0.370 in):

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCAAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAB](#)

5	Bolt		EN6115K6Y8	Item 43
5	Nut		ASNA2529-6	Item 4
5	Washer		NSA5368-616B	Item 46
		or		
5	Bolt		EN6115K6X7	Item 39

	5	Nut	ASNA2529-6	Item 4
		or		
	5	Bolt	EN6115K6-7	Item 3
	5	Nut	ASNA2529-6	Item 4
		or		
	5	Bolt	EN6115K5Y8	Item 5
	5	Nut	ASNA2529-5	Item 6
	5	Washer	NSA5368-516B	Item 7
		and		
	1	Bolt	EN6115K6Y7	Item 42
	1	Nut	ASNA2529-6	Item 4
	1	Washer	NSA5368-616B	Item 46
		or		
	1	Bolt	EN6115K6X6	Item 38
	1	Nut	ASNA2529-6	Item 4
		or		
	1	Bolt	EN6115K6-6	Item 12
	1	Nut	ASNA2529-6	Item 4
		or		
	1	Bolt	EN6115K5Y7	Item 13
	1	Nut	ASNA2529-5	Item 6
	1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(128)Subtask 536178-400-008-002 - Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	1	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig.](#)

A-FCBAB. It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to Fig. A-FCBAB

1 Bolt EN6115K6Y8 Item 43

5 Nut ASNA2529-6 Item 4

5 Washer NSA5368-616B Item 46

or

5 Bolt EN6115K6X7 Item 39

5 Nut ASNA2529-6 Item 4

or

5 Bolt EN6115K6-7 Item 3

5 Nut ASNA2529-6 Item 4

or

5 Bolt EN6115K5Y8 Item 5

5 Nut ASNA2529-5 Item 6

5 Washer NSA5368-516B Item 7

and

1 Bolt EN6115K6Y7 Item 42

1 Nut ASNA2529-6 Item 4

1 Washer NSA5368-616B Item 46

or

1 Bolt EN6115K6X6 Item 38

1 Nut ASNA2529-6 Item 4

or

1 Bolt EN6115K6-6 Item 12

1 Nut ASNA2529-6 Item 4

or

SERVICE BULLETIN

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCBAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCBAB](#)

1	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7

and

1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(129)Subtask 536178-400-009-002 - Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
7	NSA5368-516B	6	WASHER	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAB](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46

		or		
5	Bolt		EN6115K6X7	Item 39
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K6-7	Item 3
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K5Y8	Item 5
5	Nut		ASNA2529-5	Item 6
5	Washer		NSA5368-516B	Item 7
		and		
1	Bolt		EN6115K6Y7	Item 42
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X6	Item 38
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-6	Item 12
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y7	Item 13
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAB](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4

or

1 Bolt EN6115K6-6 Item 12

1 Nut ASNA2529-6 Item 4

or

1 Bolt EN6115K5Y7 Item 13

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(130)Subtask 536178-400-010-002 - Install the Fasteners on the Holes H2 to H8 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	3.50
Minimum number of person	1
Subtask elapsed time	3.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA08				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	7	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	7	NUT	
7	NSA5368-516B	7	WASHER	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
41	EN6115K6X9	1	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
45	EN6115K6Y10	1	BOLT	
46	NSA5368-616B	7	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCDAB Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCDAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDAB](#)

1	Bolt	EN6115K6Y10	Item 45
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X9	Item 41
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		

1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	and		
5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		

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1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCDAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDAB](#)

1	Bolt	EN6115K6Y10	Item 45
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X9	Item 41
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

		and		
5	Bolt		EN6115K6Y9	Item 44
5	Nut		ASNA2529-6	Item 4
5	Washer		NSA5368-616B	Item 46
		or		
5	Bolt		EN6115K6X8	Item 40
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K6-8	Item 26
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K5Y9	Item 27
5	Nut		ASNA2529-5	Item 6
5	Washer		NSA5368-516B	Item 7
		and		
1	Bolt		EN6115K6Y8	Item 43
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X7	Item 39
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-7	Item 3
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y8	Item 5
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(131)Subtask 536178-400-011-002 - Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA10				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAB](#)

5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39

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1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAB](#)

5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26

5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(132)Subtask 536178-400-012-002 - Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA12				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	6	NUT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
26	EN6115K6-8	6	BOLT	
27	EN6115K5Y9	6	BOLT	
40	EN6115K6X8	6	BOLT	
44	EN6115K6Y9	6	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAB](#)

6	Bolt	EN6115K6Y9	Item 44
6	Nut	ASNA2529-6	Item 4

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6	Washer	NSA5368-616B	Item 46
	or		
6	Bolt	EN6115K6X8	Item 40
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K6-8	Item 26
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K5Y9	Item 27
6	Nut	ASNA2529-5	Item 6
6	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAB](#)

6	Bolt	EN6115K6Y9	Item 44
6	Nut	ASNA2529-6	Item 4
6	Washer	NSA5368-616B	Item 46
	or		
6	Bolt	EN6115K6X8	Item 40
6	Nut	ASNA2529-6	Item 4

or

6	Bolt	EN6115K6-8	Item 26
6	Nut	ASNA2529-6	Item 4

or

6	Bolt	EN6115K5Y9	Item 27
6	Nut	ASNA2529-5	Item 6
6	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(133)Subtask 536178-831-043-002 - Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001

References	
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDAAB Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDAAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- 3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:
- a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or if hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

- b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fastener in transition fit:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

- (b) Install the new fastener at hole H9:

Refer to [Fig. A-FDAAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

- 1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

- 2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

- a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- b Clean the drilled area.

- c Install the fastener with high interference:

Refer to [Fig. A-FDAAB](#)

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1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X5	Item 17
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-5	Item 18
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or if hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(134)Subtask 536178-831-044-002 - Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDBAB Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAB](#)

1	Bolt	EN6115K6-7	Item 3
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1	Nut	ASNA2529-6	Item 4
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or

1	Bolt	EN6115K5Y8	Item 5
---	------	------------	--------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
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NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAB](#)

1	Bolt	EN6115K5-8	Item 19
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1	Nut	ASNA2529-5	Item 6
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1 Washer NSA5379-5W Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAB](#)

1 Bolt EN6115K5Y6 Item 16

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

or

1 Bolt EN6115K5X5 Item 17

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-5 Item 18

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- 3** If (edge distance) / (hole diameter + 1.6 mm) < 1.27:
- a** If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):
- <1> Contact AIRBUS before next flight and follow their instructions.
- b** If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):
- <1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame
- <2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.
- <3> Clean the drilled area.
- <4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAB](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(135)Subtask 536178-831-045-002 - Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDCAB Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K5Y6	Item 16
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1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
---	--------	--------------	--------

or

1	Bolt	EN6115K5X5	Item 17
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

or

1	Bolt	EN6115K5-5	Item 18
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1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(136)Subtask 536178-831-046-002 - Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA08				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44

References	
Fig. A-FDDAB Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDDAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAB](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDDAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAB](#)

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

- or
- 1 Bolt EN6115K5X6 Item 14
- 1 Nut ASNA2529-5 Item 6
- or
- 1 Bolt EN6115K5-6 Item 15
- 1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- 3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:
 - a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
 - b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):
 - <1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame
 - <2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.
 - <3> Clean the drilled area.
 - <4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAB](#)

- 1 Bolt EN6115K5-7 Item 9
- 1 Nut ASNA2529-5 Item 6
- 1 Washer NSA5379-5W Item 47

(137)Subtask 536178-831-047-002 - Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA10				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDEAB Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAB](#)

1	Bolt	EN6115K6-8	Item 26
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1	Nut	ASNA2529-6	Item 4
---	-----	------------	--------

or

1	Bolt	EN6115K5Y9	Item 27
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
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NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAB](#)

1	Bolt	EN6115K5-8	Item 19
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1 Washer NSA5379-5W Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAB](#)

1 Bolt EN6115K5Y7 Item 13

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

or

1 Bolt EN6115K5X6 Item 14

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- 3** If (edge distance) / (hole diameter + 1.6 mm) < 1.27:
- a** If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):
- <1> Contact AIRBUS before next flight and follow their instructions.
- b** If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):
- <1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame
- <2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.
- <3> Clean the drilled area.
- <4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAB](#)

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(138)Subtask 536178-831-048-002 - Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA12				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDFAB Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDFAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDFAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K5Y7	Item 13
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1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
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or

1	Bolt	EN6115K5X6	Item 14
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

or

1	Bolt	EN6115K5-6	Item 15
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(139)Subtask 536178-800-007-001 - Apply Protective Treatment to the Work Area at Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02
Fig. A-FDAAB Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBAAB](#), [Fig. A-FCAAB](#) and [Fig. A-FDAAB](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(140)Subtask 536178-800-008-001 - Apply Protective Treatment to the Work Area at Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02
Fig. A-FDBAB Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBBAB](#), [Fig. A-FBBAB](#) and [Fig. A-FCBAB](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(141)Subtask 536178-800-009-001 - Apply Protective Treatment to the Work Area at Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02
Fig. A-FDCAB Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBCAB](#), [Fig. A-FBCAB](#) and [Fig. A-FCCAB](#)

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
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and apply finish:

Top Coat Polyurethane - Grey Internal Structure	04JME4	As required
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(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(142)Subtask 536178-800-010-001 - Apply Protective Treatment to the Work Area at Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBDAB Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCDAB Replacement of the Fastener on Holes H2 to H8 of Frame 44	Sheet 01 Sheet 02
Fig. A-FDDAB Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBDAB](#), [Fig. A-FCDAB](#) and [Fig. A-FDDAB](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey		
Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion	12ABC1	As required
Preventive		
Compound-Water		
Displacing		

(143)Subtask 536178-800-011-001 - Apply Protective Treatment to the Work Area at Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

References	
Fig. A-FDEAB Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBEAB](#), [Fig. A-FCEAB](#) and [Fig. A-FDEAB](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey		
Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive	12ABC1	As required
Compound-Water Displacing		

(144)Subtask 536178-800-012-001 - Apply Protective Treatment to the Work Area at Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02
Fig. A-FDFAB Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBFAB](#), [Fig. A-FCFAB](#) and [Fig. A-FDFAB](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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****CONF 005**

(1) Subtask 536178-000-001-002 - Remove the Fastener from Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBAAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBAAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
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1	Nut	Item (4)	Discard
---	-----	----------	---------

b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous 08BAA9 As required
Cleaner - General

(2) Subtask 536178-000-002-002 - Remove the Fastener from Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBBAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBBAB](#)

In accordance with SRM 51-40-20

1 Bolt Item (3) Discard

1 Nut Item (4) Discard

b Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(3) Subtask 536178-000-003-002 - Remove the Fastener from Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBCAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBCAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
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1	Nut	Item (4)	Discard
---	-----	----------	---------

b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(4) Subtask 536178-000-004-003 - Remove the Fastener from Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBDAC Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBDAC](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fasteners:

Refer to [Fig. A-FBDAC](#)

In accordance with SRM 51-40-20

<1> At hole H11:

1	Shim	Item (32)	Retain
1	Bolt	Item (30)	Discard
1	Nut	Item (31)	Discard

<2> At hole H1:

1	Bolt	Item (3)	Discard
1	Nut	Item (4)	Discard

<3> <3> At holes H12 and H13:

2	Rivet	Item (35)	Discard
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b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(5) Subtask 536178-000-005-002 - Remove the Fastener from Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBEAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBEAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
---	------	----------	---------

1	Nut	Item (4)	Discard
---	-----	----------	---------

b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
----------------------------	--------	-------------

and

Non Aqueous 08BAA9 As required
Cleaner - General

(6) Subtask 536178-000-006-002 - Remove the Fastener from Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBFAB](#)

- 1 If the frame foot is cut:
 - a Do not remove the fastener and, if installed, the bush.
and
No further action required for the Hole H1.

2 If the frame foot is not cut:

- a Remove the fastener:

Refer to [Fig. A-FBFAB](#)

In accordance with SRM 51-40-20

1 Bolt Item (3) Discard

1 Nut Item (4) Discard

b Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(7) Subtask 536178-000-007-001 - Remove the Fasteners from Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCAAB](#)

In accordance with SRM 51-40-20

6 Bolt Item (3) Discard

6 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(8) Subtask 536178-000-008-001 - Remove the Fasteners from Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCBAB](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(9) Subtask 536178-000-009-001 - Remove the Fasteners from Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCCAB](#)

In accordance with SRM 51-40-20

7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(10) Subtask 536178-000-010-004 - Remove the Fasteners from Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	2.50
Minimum number of person	1
Subtask elapsed time	2.50
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCDAC Replacement of the Fastener on Holes H2 to H7 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) Remove the fasteners:

Refer to [Fig. A-FCDAC](#)

In accordance with SRM 51-40-20

7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(c) If the frame foot is not cut:

1 Remove the support:

1 Support Item (20) Retain

(11) Subtask 536178-000-011-001 - Remove the Fasteners from Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCEAB](#)

In accordance with SRM 51-40-20

6 Bolt Item (3) Discard

6 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(12) Subtask 536178-000-012-001 - Remove the Fasteners from Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCFAB](#)

In accordance with SRM 51-40-20

6 Bolt Item (3) Discard

6 Nut Item (4) Discard

(b) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(13) Subtask 536178-000-013-002 - Remove the Fasteners from Holes H8 and H9 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDAAB Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDAAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDAAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(14) Subtask 536178-000-014-002 - Remove the Fasteners from Holes H8 and H9 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDBAB Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDBAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDBAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(15) Subtask 536178-000-015-002 - Remove the Fasteners from Holes H9 and H10 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDCAB Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDCAB](#)

In accordance with SRM 51-40-20

- 2 Bolt Item (3) Discard
- 2 Nut Item (4) Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDCAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(16) Subtask 536178-000-016-002 - Remove the Fasteners from Holes H9 and H10 of Frame 44, LH Side

Work Zones and Access Panels			
Zone	Access/Work location		
241	Work location	Frame 44	

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDDAC Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDDAC](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDDAC](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(17) Subtask 536178-000-017-002 - Remove the Fasteners from Holes H8 and H9 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20

References	
Fig. A-FDEAB Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDEAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDEAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(18) Subtask 536178-000-018-002 - Remove the Fasteners from Holes H8 and H9 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	

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

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDFAB Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Remove the Fasteners:

Refer to [Fig. A-FDFAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDFAB](#).

(c) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(19) Subtask 536178-250-001-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFAAA Flowchart for the Hole H1 of Frame 41, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFAAA](#) and [Fig. A-FEAAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-001 001 Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-013 002 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-013 002 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-013 002 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-013 002 Install the Fastener on the Hole H1 of Frame 41, LH Side workstep (a).

(20) Subtask 536178-250-002-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFBAA Flowchart for the Hole H1 of Frame 42, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFBAA](#) and [Fig. A-FEBAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-002 001 Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-014 002 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-014 002 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-014 002 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-014 002 Install the Fastener on the Hole H1 of Frame 42, LH Side workstep (a).

(21) Subtask 536178-250-003-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFCAA Flowchart for the Hole H1 of Frame 43, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFCAA](#) and [Fig. A-FECAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-003 001 Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-015 002 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-015 002 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-015 002 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-015 002 Install the Fastener on the Hole H1 of Frame 43, LH Side workstep (a).

(22) Subtask 536178-250-004-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFDAA Flowchart for the Hole H1 of Frame 44, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFDAA](#) and [Fig. A-FEDAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-004 001 Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-016 003 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-016 003 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-016 003 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-016 003 Install the Fastener on the Hole H1 of Frame 44, LH Side workstep (a).

(23) Subtask 536178-250-005-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FFEAA Flowchart for the Hole H1 of Frame 45, LH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFEAA](#) and [Fig. A-FEGAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-005 001 Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-017 002 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (b).

f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-017 002 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (c).

2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):

a Contact AIRBUS before next flight and follow their instructions.

- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-017 002 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-017 002 Install the Fastener on the Hole H1 of Frame 45, LH Side workstep (a).

(24) Subtask 536178-250-006-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFFAA Flowchart for the Hole H1 of Frame 46, LH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFFAA](#) and [Fig. A-FEFAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-004 001 Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):
 - <1> Do the workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-018 002 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (b).
- f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-018 002 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-018 002 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (b).
- 4 If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-018 002 Install the Fastener on the Hole H1 of Frame 46, LH Side workstep (a).

(25) Subtask 536178-250-007-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFMAA Flowchart for the Hole H2 to H7 from Frame 41, LH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFMAA](#) and [Fig. A-FEAAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-007 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-001 002 Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side workstep (b).

2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-001 002 Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side workstep (a).

(26) Subtask 536178-250-008-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFNAA Flowchart for the Hole H2 to H7 from Frame 42, LH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFNAA](#) and [Fig. A-FEBAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-008 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-002 002 Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-002 002 Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side workstep (a).

(27) Subtask 536178-250-009-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFOAA Flowchart for the Hole H2 to H8 from Frame 43, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFOAA](#) and [Fig. A-FECAA](#)

- 1 If crack found:
 - a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-009 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side .
 - b Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)
 - c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.
 - d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.
 - e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.
 - f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-003 002 Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-003 002 Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side workstep (a).

(28) Subtask 536178-250-010-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFPAA Flowchart for the Hole H2 to H8 from Frame 44, LH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFPAA](#) and [Fig. A-FEDAA](#)

1 If crack found:

a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-010 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

- f If crack removed and the current hole diameter \leq 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-004 003 Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-004 003 Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side workstep (a).

(29) Subtask 536178-250-011-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFQAA Flowchart for the Hole H2 to H7 from Frame 45, LH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFQAA](#) and [Fig. A-FEGAA](#)

- 1 If crack found:
 - a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-011 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side .

- b Do an eddy-current rotating probe testing of the holes H2 to H7.
Refer to NTM 51-10-18 and NTM 51-10-01
Refer to [Fig. A-FEGAA](#)
- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):
<1> Do workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
<1> Do the SUBTASK 536178-400-005 002 Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-005 002 Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side workstep (a).

(30) Subtask 536178-250-012-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FFRAA Flowchart for the Hole H2 to H7 from Frame 46, LH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFRAA](#) and [Fig. A-FEFAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-012 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-006 002 Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side workstep (b).

2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-006 002 Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side workstep (a).

(31) Subtask 536178-250-013-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

- 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 41, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

- 1 If cracks found:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no cracks found:
 - a Do the SUBTASK 536178-831-019 002 Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side

(32) Subtask 536178-250-014-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

- 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 42, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

- 1 If cracks found:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no cracks found:
 - a Do the SUBTASK 536178-831-020 002 Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side

(33) Subtask 536178-250-015-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 43, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-021 002 Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side

(34) Subtask 536178-250-016-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:

- 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 44, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

- 1 If cracks found:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no cracks found:
 - a Do the SUBTASK 536178-831-022 003 Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side

(35) Subtask 536178-250-017-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

- 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 45, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

- 1 If cracks found:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no cracks found:
 - a Do the SUBTASK 536178-831-023 002 Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side

(36) Subtask 536178-250-018-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

- 1 If bush installed:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no bush installed:
 - a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 46, LH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

- 1 If cracks found:
 - a Contact AIRBUS before next flight and follow their instructions.
- 2 If no cracks found:
 - a Do the SUBTASK 536178-831-024 002 Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side

(37) Subtask 536178-831-001-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBAAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(38) Subtask 536178-831-002-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBBAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(39) Subtask 536178-831-003-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBCAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(40) Subtask 536178-831-004-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBDAC Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBDAC](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(41) Subtask 536178-831-005-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBEAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton 14SBA1 As required

and

Non Aqueous Cleaner - General 08BAA9 As required

(42) Subtask 536178-831-006-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBFAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(43) Subtask 536178-831-007-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCAAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(44) Subtask 536178-831-008-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCBAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(45) Subtask 536178-831-009-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCCAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(46) Subtask 536178-831-010-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCDAC Replacement of the Fastener on Holes H2 to H7 of Frame 44	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCDAC](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(47) Subtask 536178-831-011-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCEAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(48) Subtask 536178-831-012-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCFAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(49) Subtask 536178-831-013-002 - Install the Fastener on the Hole H1 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Component COMPA02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBAAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBAAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBAAB](#)

1	Bush	A5381278720600	Item 2
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4 Ream the hole on the bush Item 2 to the applicable fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBAAB](#)

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K4-8	Item 10
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1	Nut	ASNA2529-4	Item 11
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NOTE: If spotfacing necessary, contact AIRBUS.

- (e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAB](#). It must be as near the current hole diameter + 0.80

mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.
- 3 Temporarily put in position the shim Item 1.
- 4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.
- 5 Clean the drilled area.
- 6 Install the fastener with high interference:

Refer to [Fig. A-FBAAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(50) Subtask 536178-831-014-002 - Install the Fastener on the Hole H1 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Component COMPA04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

- (a) If the fastener at hole H1 has not been removed:
 - 1 No further action required for the hole H1 only.
- (b) If the fastener at hole H1 has been removed:
 - 1 Apply the instruction given in the following steps.
- (c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):
 - Refer to AMM 20-21-12, Page Block 001
 - In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30
 - Refer to [Fig. A-FBBAB](#)

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.
- 3 Temporarily put in position the shim Item 1.
- 4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 5 Clean the drilled area.
- 6 Install the fastener with high interference:

Refer to [Fig. A-FBBAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAB](#)

- 1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.
- 2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBBAB](#)

1 Bush A5381278720600 Item 2

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBBAB](#)

1 Shim A5381309320000 Item 1

1 Bolt EN6115K4-8 Item 10

1 Nut ASNA2529-4 Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBBAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(51) Subtask 536178-831-015-002 - Install the Fastener on the Hole H1 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Component COMPA06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
36	A5381278720200	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAB](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBCAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBCAB](#)

1	Bush	A5381278720200	Item 36
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4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in clearance fit:

Refer to [Fig. A-FBCAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K4-9	Item 38
1	Nut	ASNA2529-4	Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBCAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6

1 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(52) Subtask 536178-831-016-003 - Install the Fastener on the Hole H1 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

Component COMPA15				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
20	A2521327620000	1	SUPPORT	
32	A2521326620200	1	SHIM	

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

Component COMPA16				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
21	EN6115K4-11	1	BOLT	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	
30	ASNA2027V4-8	2	BOLT	
31	NSA5075-8	2	NUT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
35	ASNA2050DCJ3215	2	RIVET	

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

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Paste Adhesive - Epoxy Potting Structure	13FBB2	As required	

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBDAC Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAC](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBDAC](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Temporarily put in position the support Item (20).

3 Mark the position of the holes H1 and H2 on the support Item (20).

4 Drill the holes on the support Item (20) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAC](#)

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the support:

Refer to [Fig. A-FBDAC](#)

1	Support	Item (20)	Retained at removal
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with:

At Hole H11:

1	Shim	Item (32)	Retained at removal
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1	Bolt	ASNA2027V4-8	Item 30
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1	Nut	NSA5075-8	Item 31
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2	Rivet	ASNA2050DCJ3215	Item 35
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NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
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and at hole H1:

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K6-9	Item 22
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1	Nut	ASNA2529-6	Item 4
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or

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K5Y10	Item 23
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1	Nut	ASNA2529-5	Item 6
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1 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAC](#)

1 If hole diameter H1 of the support Item (20) is greater than 6.35 mm (0.25 in):

a Discard the retained support Item (20).

2 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

3 Clean the drilled area.

4 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBDAC](#)

1 Bush A5381278720400 Item 37

5 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

6 Temporarily put in position the support Item (20).

If the support has been discard, use:

1 Support A2521327620000 Item 20

7 Mark the position of the holes H1 and H2 on the support Item (20) or 20.

8 Drill the holes on the support Item (20) or 20 to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAC](#)

9 Temporarily put in position the shim Item 1.

10 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

11 Clean the drilled area.

12 Install the support:

Refer to [Fig. A-FBDAC](#)

1	Support		Item (20)	Retained at removal
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If the support Item (20) has been discard:

1	Support	A2521327620000	Item 20	
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with:

At Hole 11:

1	Shim		Item (32)	Retained at removal
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If the support Item (20) has been discard:

1	Shim	A2521326620200	Item 32	
---	------	----------------	---------	--

1	Bolt	ASNA2027V4-8	Item 30	
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1	Nut	NSA5075-8	Item 31	
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2	Rivet	ASNA2050DCJ3215	Item 35	
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NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
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and at hole H1:

1	Shim	A5381309320000	Item 1	
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1	Bolt	EN6115K4-11	Item 21	
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1	Nut	ASNA2529-4	Item 11	
---	-----	------------	---------	--

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAC](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBDAC](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the support Item (20).

3 Mark the position of the holes H1 and H2 on the support Item (20).

4 Drill the holes on the support Item (20) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAC](#)

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the support:

Refer to [Fig. A-FBDAC](#)

1	Support	Item (20)	Retained at removal
---	---------	-----------	---------------------

with:

At Hole H11:

1	Shim	Item (32)	Retained at removal
---	------	-----------	---------------------

1	Bolt	ASNA2027V4-8	Item 30
---	------	--------------	---------

1	Nut	NSA5075-8	Item 31
---	-----	-----------	---------

2	Rivet	ASNA2050DCJ3215	Item 35
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NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
--	--------	-------------

and at hole H1:

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K6-9	Item 22
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1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(53) Subtask 536178-831-017-002 - Install the Fastener on the Hole H1 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

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

Material necessary to do the job

Component COMPA10				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAB](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBEAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4

or

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBEAB](#)

1	Bush	A5381278720400	Item 37
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4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBEAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K4-9	Item 38
1	Nut	ASNA2529-4	Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBEAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(54) Subtask 536178-831-018-002 - Install the Fastener on the Hole H1 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Component COMPA12				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA13				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

- 1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAB](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBFAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBFAB](#)

1	Bush	A5381278720400	Item 37
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4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in clearance fit:

Refer to [Fig. A-FBFAB](#)

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K4-9	Item 38
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1	Nut	ASNA2529-4	Item 11
---	-----	------------	---------

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBFAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(55) Subtask 536178-400-001-002 - Install the Fasteners on the Holes H2 to H7 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
12	EN6115K6-6	1	BOLT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
13	EN6115K5Y7	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Clean the drilled area.
- 3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAB](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3

5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack removed and the current hole diameter < 9.40 mm (0.370 in):

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCAAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.
- 3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAB](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(56) Subtask 536178-400-002-002 - Install the Fasteners on the Holes H2 to H7 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	1	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCBAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install fasteners with interference fit:

Refer to [Fig. A-FCBAB](#)

1	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4

or

1 Bolt EN6115K6-6 Item 12

1 Nut ASNA2529-6 Item 4

or

1 Bolt EN6115K5Y7 Item 13

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCBAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCBAB](#)

1 Bolt EN6115K6Y8 Item 43

5 Nut ASNA2529-6 Item 4

5 Washer NSA5368-616B Item 46

or

5 Bolt EN6115K6X7 Item 39

5 Nut ASNA2529-6 Item 4

or

5 Bolt EN6115K6-7 Item 3

5 Nut ASNA2529-6 Item 4

		or		
5	Bolt		EN6115K5Y8	Item 5
5	Nut		ASNA2529-5	Item 6
5	Washer		NSA5368-516B	Item 7
		and		
1	Bolt		EN6115K6Y7	Item 42
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X6	Item 38
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-6	Item 12
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y7	Item 13
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(57) Subtask 536178-400-003-002 - Install the Fasteners on the Holes H2 to H8 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAB](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6

1 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAB](#)

5 Bolt EN6115K6Y8 Item 43

5 Nut ASNA2529-6 Item 4

5 Washer NSA5368-616B Item 46
or

5 Bolt EN6115K6X7 Item 39

5 Nut ASNA2529-6 Item 4
or

5 Bolt EN6115K6-7 Item 3

5 Nut ASNA2529-6 Item 4
or

5 Bolt EN6115K5Y8 Item 5

5 Nut ASNA2529-5 Item 6

5 Washer NSA5368-516B Item 7
and

1 Bolt EN6115K6Y7 Item 42

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1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(58) Subtask 536178-400-004-003 - Install the Fasteners on the Holes H2 to H8 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	3.50
Minimum number of person	1
Subtask elapsed time	3.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA16				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	7	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	7	NUT	
7	NSA5368-516B	7	WASHER	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
41	EN6115K6X9	1	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
45	EN6115K6Y10	1	BOLT	
46	NSA5368-616B	7	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCDAC Replacement of the Fastener on Holes H2 to H7 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCDAC](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDAC](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDAC](#)

1	Bolt	EN6115K6Y10	Item 45
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46

		or		
1	Bolt		EN6115K6X9	Item 41
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-9	Item 22
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y10	Item 23
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7
		and		
5	Bolt		EN6115K6Y9	Item 44
5	Nut		ASNA2529-6	Item 4
5	Washer		NSA5368-616B	Item 46
		or		
5	Bolt		EN6115K6X8	Item 40
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K6-8	Item 26
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K5Y9	Item 27
5	Nut		ASNA2529-5	Item 6
5	Washer		NSA5368-516B	Item 7
		and		
1	Bolt		EN6115K6Y8	Item 43
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46

		or		
1	Bolt		EN6115K6X7	Item 39
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-7	Item 3
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y8	Item 5
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCDAC](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDAC](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDAC](#)

1	Bolt		EN6115K6Y10	Item 45
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X9	Item 41
1	Nut		ASNA2529-6	Item 4

		or		
1	Bolt		EN6115K6-9	Item 22
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y10	Item 23
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7
		and		
5	Bolt		EN6115K6Y9	Item 44
5	Nut		ASNA2529-6	Item 4
5	Washer		NSA5368-616B	Item 46
		or		
5	Bolt		EN6115K6X8	Item 40
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K6-8	Item 26
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K5Y9	Item 27
5	Nut		ASNA2529-5	Item 6
5	Washer		NSA5368-516B	Item 7
		and		
1	Bolt		EN6115K6Y8	Item 43
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X7	Item 39
1	Nut		ASNA2529-6	Item 4

or

1 Bolt EN6115K6-7 Item 3

1 Nut ASNA2529-6 Item 4

or

1 Bolt EN6115K5Y8 Item 5

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(59) Subtask 536178-400-005-002 - Install the Fasteners on the Holes H2 to H7 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA10				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAB](#)

5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27

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5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAB](#)

SERVICE BULLETIN

5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(60) Subtask 536178-400-006-002 - Install the Fasteners on the Holes H2 to H7 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA12				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	6	NUT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
26	EN6115K6-8	6	BOLT	
27	EN6115K5Y9	6	BOLT	
40	EN6115K6X8	6	BOLT	
44	EN6115K6Y9	6	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAB](#)

6	Bolt	EN6115K6Y9	Item 44
6	Nut	ASNA2529-6	Item 4
6	Washer	NSA5368-616B	Item 46
	or		
6	Bolt	EN6115K6X8	Item 40
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K6-8	Item 26
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K5Y9	Item 27
6	Nut	ASNA2529-5	Item 6
6	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (b) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Clean the drilled area.

3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAB](#)

6	Bolt	EN6115K6Y9	Item 44
6	Nut	ASNA2529-6	Item 4
6	Washer	NSA5368-616B	Item 46
	or		
6	Bolt	EN6115K6X8	Item 40
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K6-8	Item 26
6	Nut	ASNA2529-6	Item 4
	or		
6	Bolt	EN6115K5Y9	Item 27
6	Nut	ASNA2529-5	Item 6
6	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(61) Subtask 536178-831-019-002 - Install the Fasteners on the Holes H8 and H9 of Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDAAB Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDAAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If $(\text{edge distance}) / (\text{hole diameter} + 1.6 \text{ mm}) < 1.27$:

a If $(\text{edge distance}) / (\text{hole diameter} + 0.8 \text{ mm}) < 1.30$ or if hole diameter $> 7.92 \text{ mm}$ (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If $(\text{edge distance}) / (\text{hole diameter} + 0.8 \text{ mm}) \geq 1.30$ and the hole diameter $\leq 7.92 \text{ mm}$ (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fastener in transition fit:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDAAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X5	Item 17
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-5	Item 18
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or if hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(62) Subtask 536178-831-020-002 - Install the Fasteners on the Holes H8 and H9 of Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001

References	
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDBAB Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAB](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAB](#)

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1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X5	Item 17
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-5	Item 18
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAB](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(63) Subtask 536178-831-021-002 - Install the Fasteners on the Holes H9 and H10 of Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDCAB Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

1 Washer NSA5379-5W Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAB](#)

1 Bolt EN6115K5Y6 Item 16

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

or

1 Bolt EN6115K5X5 Item 17

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-5 Item 18

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(64) Subtask 536178-831-022-003 - Install the Fasteners on the Holes H9 and H10 of Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA16				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDDAC Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDDAC](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAC](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAC](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAC](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDDAC](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAC](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAC](#)

1	Bolt	EN6115K5Y7	Item 13
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1	Nut	ASNA2529-5	Item 6
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1	Washer	NSA5368-516B	Item 7
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or

1	Bolt	EN6115K5X6	Item 14
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1	Nut	ASNA2529-5	Item 6
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or

1	Bolt	EN6115K5-6	Item 15
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1	Nut	ASNA2529-5	Item 6
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NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAC](#)

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(65) Subtask 536178-831-023-002 - Install the Fasteners on the Holes H8 and H9 of Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 45

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA10				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44

References	
Fig. A-FDEAB Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAB](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAB](#)

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1	Bolt	EN6115K5X6	Item 14
1	Nut	ASNA2529-5	Item 6

or

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAB](#)

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(66) Subtask 536178-831-024-002 - Install the Fasteners on the Holes H8 and H9 of Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA12				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDFAB Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDFAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

1 Washer NSA5379-5W Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDFAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAB](#)

1 Bolt EN6115K5Y7 Item 13

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

or

1 Bolt EN6115K5X6 Item 14

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- 3** If (edge distance) / (hole diameter + 1.6 mm) < 1.27:
- a** If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):
- <1> Contact AIRBUS before next flight and follow their instructions.
- b** If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):
- <1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame
- <2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.
- <3> Clean the drilled area.
- <4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(67) Subtask 536178-800-001-001 - Apply Protective Treatment to the Work Area at Frame 41, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02
Fig. A-FDAAB Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBAAB](#), [Fig. A-FCAAB](#) and [Fig. A-FDAAB](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(68) Subtask 536178-800-002-001 - Apply Protective Treatment to the Work Area at Frame 42, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02
Fig. A-FDBAB Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBBAB](#), [Fig. A-FBBAB](#) and [Fig. A-FCBAB](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(69) Subtask 536178-800-003-001 - Apply Protective Treatment to the Work Area at Frame 43, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02
Fig. A-FDCAB Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBCAB](#), [Fig. A-FBCAB](#) and [Fig. A-FCCAB](#)

SERVICE BULLETIN

Primer 04EAC2 As required
Polyurethane Paint
- Corrosion
Inhibiting

and apply finish:

Top Coat 04JME4 As required
Polyurethane - Grey
Internal Structure

(b) Apply on the work area below the floor level:

Corrosion 12ABC1 As required
Preventive
Compound-Water
Displacing

(70) Subtask 536178-800-004-001 - Apply Protective Treatment to the Work Area at Frame 44, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBDAC	Sheet 01
Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 02
	Sheet 03

References	
Fig. A-FCDAC Replacement of the Fastener on Holes H2 to H7 of Frame 44	Sheet 01 Sheet 02 Sheet 03
Fig. A-FDDAC Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBDAC](#), [Fig. A-FCDAC](#) and [Fig. A-FDDAC](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion		
Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey		
Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion	12ABC1	As required
Preventive		
Compound-Water		
Displacing		

(71) Subtask 536178-800-005-001 - Apply Protective Treatment to the Work Area at Frame 45, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02
Fig. A-FDEAB Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBEAB](#), [Fig. A-FCEAB](#) and [Fig. A-FDEAB](#)

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
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and apply finish:

Top Coat Polyurethane - Grey Internal Structure	04JME4	As required
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(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
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(72) Subtask 536178-800-006-001 - Apply Protective Treatment to the Work Area at Frame 46, LH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-75-10
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02
Fig. A-FDFAB Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBFAB](#), [Fig. A-FCFAB](#) and [Fig. A-FDFAB](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion Inhibiting		

and apply finish:

Top Coat 04JME4 As required
 Polyurethane - Grey
 Internal Structure

(b) Apply on the work area below the floor level:

Corrosion 12ABC1 As required
 Preventive
 Compound-Water
 Displacing

(73) Subtask 536178-000-019-002 - Remove the Fastener from Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBAAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBAAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
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1	Nut	Item (4)	Discard
---	-----	----------	---------

b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(74) Subtask 536178-000-020-002 - Remove the Fastener from Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBBAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBBAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
---	------	----------	---------

1	Nut	Item (4)	Discard
---	-----	----------	---------

b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(75) Subtask 536178-000-021-002 - Remove the Fastener from Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBCAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBCAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
---	------	----------	---------

1	Nut	Item (4)	Discard
---	-----	----------	---------

b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required	
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and

Non Aqueous Cleaner - General	08BAA9	As required	
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(76) Subtask 536178-000-022-003 - Remove the Fastener from Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBDAC Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBDAC](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fasteners:

Refer to [Fig. A-FBDAC](#)

In accordance with SRM 51-40-20

<1> At hole H11:

1	Shim	Item (32)	Retain
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1 Bolt Item (30) Discard

1 Nut Item (31) Discard

<2> At hole H1:

1 Bolt Item (3) Discard

1 Nut Item (4) Discard

b Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(77) Subtask 536178-000-023-002 - Remove the Fastener from Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBEAB](#)

- 1 If the frame foot is cut:
 - a Do not remove the fastener and, if installed, the bush.
and
No further action required for the Hole H1.

- 2 If the frame foot is not cut:

- a Remove the fastener:

Refer to [Fig. A-FBEAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
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1	Nut	Item (4)	Discard
---	-----	----------	---------

- b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(78) Subtask 536178-000-024-002 - Remove the Fastener from Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FBFAB	Sheet 01
Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 02
	Sheet 03

(a) Make sure that the frame foot is not cut.

Refer to [Fig. A-FBFAB](#)

1 If the frame foot is cut:

a Do not remove the fastener and, if installed, the bush.

and

No further action required for the Hole H1.

2 If the frame foot is not cut:

a Remove the fastener:

Refer to [Fig. A-FBFAB](#)

In accordance with SRM 51-40-20

1	Bolt	Item (3)	Discard
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1	Nut	Item (4)	Discard
---	-----	----------	---------

b Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(79) Subtask 536178-000-025-001 - Remove the Fasteners from Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCAAB](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required	
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and

Non Aqueous Cleaner - General	08BAA9	As required	
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(80) Subtask 536178-000-026-001 - Remove the Fasteners from Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCBAB](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required	
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and

Non Aqueous Cleaner - General	08BAA9	As required	
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(81) Subtask 536178-000-027-001 - Remove the Fasteners from Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCCAB](#)

In accordance with SRM 51-40-20

7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required	
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and

Non Aqueous Cleaner - General	08BAA9	As required	
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(82) Subtask 536178-000-028-003 - Remove the Fasteners from Holes H2 to H8 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	2.50
Minimum number of person	1
Subtask elapsed time	2.50
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCDAC	Sheet 01
Replacement of the Fastener on Holes H2 to H7 of Frame 44	Sheet 02
	Sheet 03

(a) Remove the fasteners:

Refer to [Fig. A-FCDAC](#)

In accordance with SRM 51-40-20

7	Bolt	Item (3)	Discard
7	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(c) If the frame foot is not cut:

1 Remove the support:

1	Support	Item (20)	Retain
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(83) Subtask 536178-000-029-001 - Remove the Fasteners from Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCEAB](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(84) Subtask 536178-000-030-001 - Remove the Fasteners from Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FCFAB](#)

In accordance with SRM 51-40-20

6	Bolt	Item (3)	Discard
6	Nut	Item (4)	Discard

(b) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(85) Subtask 536178-000-031-002 - Remove the Fasteners from Holes H8 and H9 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDAAB Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDAAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDAAB](#).

(c) Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(86) Subtask 536178-000-032-002 - Remove the Fasteners from Holes H8 and H9 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDBAB Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDBAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDBAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(87) Subtask 536178-000-033-002 - Remove the Fasteners from Holes H9 and H10 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDCAB Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDCAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDCAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(88) Subtask 536178-000-034-002 - Remove the Fasteners from Holes H9 and H10 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDDAC Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDDAC](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDDAC](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(89) Subtask 536178-000-035-002 - Remove the Fasteners from Holes H8 and H9 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDEAB Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Remove the fasteners:

Refer to [Fig. A-FDEAB](#)

In accordance with SRM 51-40-20

2	Bolt	Item (3)	Discard
2	Nut	Item (4)	Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDEAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(90) Subtask 536178-000-036-002 - Remove the Fasteners from Holes H8 and H9 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-20
Fig. A-FDFAB Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Remove the Fasteners:

Refer to [Fig. A-FDFAB](#)

In accordance with SRM 51-40-20

- 2 Bolt Item (3) Discard
- 2 Nut Item (4) Discard

(b) If the frame foot is not cut:

CAUTION: DURING THE CUT-OUT OF THE FRAME FOOT, BE CAREFUL NOT TO DAMAGE THE STRUCTURE.

1 Cut-out the frame foot as per dimensions given [Fig. A-FDFAB](#).

(c) Clean the area with:

Textile - Lint Free 14SBA1 As required
Cotton

and

Non Aqueous 08BAA9 As required
Cleaner - General

(91) Subtask 536178-250-019-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFGAA Flowchart for the Hole H1 of Frame 41, RH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFGAA](#) and [Fig. A-FEAAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-025 001 Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)
 - c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.
 - d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.
 - e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-037 002 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (b).
 - f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-037 002 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-037 002 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-037 002 Install the Fastener on the Hole H1 of Frame 41, RH Side workstep (a).

(92) Subtask 536178-250-020-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFHAA Flowchart for the Hole H1 of Frame 42, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFHAA](#) and [Fig. A-FEBAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-026 001 Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-038 002 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (b).

- f If crack removed and the current hole diameter \leq 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-038 002 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and \leq 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-038 002 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (b).
- 4 If no crack found and the current hole diameter \leq 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-038 002 Install the Fastener on the Hole H1 of Frame 42, RH Side workstep (a).

(93) Subtask 536178-250-021-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFIA Flowchart for the Hole H1 of Frame 43, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFIA](#) and [Fig. A-FECA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-027 001 Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)
 - c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.
 - d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.
 - e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-039 002 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (b).
 - f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-039 002 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-039 002 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-039 002 Install the Fastener on the Hole H1 of Frame 43, RH Side workstep (a).

(94) Subtask 536178-250-022-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFJAA Flowchart for the Hole H1 of Frame 44, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFJAA](#) and [Fig. A-FEDAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-028 001 Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-040 003 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (b).

- f If crack removed and the current hole diameter \leq 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-040 003 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and \leq 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-040 003 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (b).
- 4 If no crack found and the current hole diameter \leq 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-040 003 Install the Fastener on the Hole H1 of Frame 44, RH Side workstep (a).

(95) Subtask 536178-250-023-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFKAA Flowchart for the Hole H1 of Frame 45, RH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFKAA](#) and [Fig. A-FEGAA](#)

- 1 If crack found:
 - a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-029 001 Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side .
 - b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)
 - c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.
 - d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.
 - e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-041 002 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (b).
 - f If crack removed and the current hole diameter ≤ 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-041 002 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and ≤ 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-041 002 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (b).
- 4 If no crack found and the current hole diameter ≤ 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-041 002 Install the Fastener on the Hole H1 of Frame 45, RH Side workstep (a).

(96) Subtask 536178-250-024-002 - Do a Special Detailed Inspection of the Fastener Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFLAA Flowchart for the Hole H1 of Frame 46, RH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the hole H1 only if the fastener in the hole H1 is removed.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFLAA](#) and [Fig. A-FEFAA](#)

1 If crack found:

a Ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-030 001 Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side .

b Do an eddy-current rotating probe testing of the hole H1.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 10.218 mm (0.4022 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 10.218 mm (0.4022 in.):

<1> Do the workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 8.627 mm (0.3396 in.):

<1> Do SUBTASK 536178-831-042 002 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (b).

- f If crack removed and the current hole diameter \leq 8.627 mm (0.3396 in.):
 - <1> Do SUBTASK 536178-831-042 002 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (c).
- 2 If no crack found and the current hole diameter > 9.418 mm (0.3708 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter > 7.827 mm (0.3081 in.) and \leq 9.418 mm (0.3708 in.):
 - a Do SUBTASK 536178-831-042 002 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (b).
- 4 If no crack found and the current hole diameter \leq 7.827 mm (0.3081 in.):
 - a Do SUBTASK 536178-831-042 002 Install the Fastener on the Hole H1 of Frame 46, RH Side workstep (a).

(97) Subtask 536178-250-025-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02
Fig. A-FFSAA Flowchart for the Hole H2 to H7 from Frame 41, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFSAA](#) and [Fig. A-FEAAA](#)

- 1 If crack found:
 - a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-031 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side .
 - b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)
 - c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.
 - d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.
 - e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.
 - f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-007 002 Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-007 002 Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side workstep (a).

(98) Subtask 536178-250-026-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02
Fig. A-FFTAA Flowchart for the Hole H2 to H7 from Frame 42, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFTAA](#) and [Fig. A-FEBAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-032 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

- f If crack removed and the current hole diameter \leq 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-008 002 Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-008 002 Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side workstep (a).

(99) Subtask 536178-250-027-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02
Fig. A-FFUAA Flowchart for the Hole H2 to H8 from Frame 43, RH side	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFUAA](#) and [Fig. A-FECAA](#)

- 1 If crack found:
 - a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-033 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side .

- b Do an eddy-current rotating probe testing of the holes H2 to H8.
Refer to NTM 51-10-18 and NTM 51-10-01
Refer to [Fig. A-FECAA](#)
- c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):
<1> Do workstep (a).1.a and subsequent again.
- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
<1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
<1> Do the SUBTASK 536178-400-009 002 Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
a Do the SUBTASK 536178-400-009 002 Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side workstep (a).

(100)Subtask 536178-250-028-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H8 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02
Fig. A-FFVAA Flowchart for the Hole H2 to H8 from Frame 44, RH side	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFVAA](#) and [Fig. A-FEDAA](#)

1 If crack found:

a Ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-034 001 Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H8.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-010 003 Install the Fastener on the Holes H2 to H7 of Frame 44, RH Side workstep (b).

2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):

a Contact AIRBUS before next flight and follow their instructions.

3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

a Do the SUBTASK 536178-400-010 003 Install the Fastener on the Holes H2 to H7 of Frame 44, RH Side workstep (a).

(101)Subtask 536178-250-029-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFWAA Flowchart for the Hole H2 to H7 from Frame 45, RH side	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFWAA](#) and [Fig. A-FEGAA](#)

1 If crack found:

a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-035 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side .

b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.

- e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):
 - <1> Contact AIRBUS before next flight and follow their instructions.
- f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):
 - <1> Do the SUBTASK 536178-400-011 002 Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-011 002 Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side workstep (a).

(102)Subtask 536178-250-030-001 - Do a Special Detailed Inspection of the Fastener Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FFXAA Flowchart for the Hole H2 to H7 from Frame 46, RH side	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

- (a) Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FFXAA](#) and [Fig. A-FEFAA](#)

- 1 If crack found:
 - a Ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SUBTASK 536178-831-036 001 Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side .
 - b Do an eddy-current rotating probe testing of the holes H2 to H7.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)
 - c If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.
 - d If crack not removed and the current hole diameter + 0.40 mm (0.016 in.) ≤ 9.40 mm (0.370 in.):

<1> Do workstep (a).1.a and subsequent again.
 - e If crack removed and the current hole diameter > 9.40 mm (0.370 in.):

<1> Contact AIRBUS before next flight and follow their instructions.
 - f If crack removed and the current hole diameter ≤ 9.40 mm (0.370 in.):

<1> Do the SUBTASK 536178-400-012 002 Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side workstep (b).
- 2 If no crack found and the current hole diameter > 8.670 mm (0.3414 in.):
 - a Contact AIRBUS before next flight and follow their instructions.
- 3 If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):
 - a Do the SUBTASK 536178-400-012 002 Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side workstep (a).

(103)Subtask 536178-250-031-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 41, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEAAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-043 002 Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side

(104)Subtask 536178-250-032-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 42, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEBAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-044 002 Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side

(105)Subtask 536178-250-033-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 43, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FECAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-045 002 Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side

(106)Subtask 536178-250-034-001 - Do a Special Detailed Inspection of the Fastener Holes H9 and H10 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H9 and H10 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H9 to H10 on the Frame 44, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEDAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-046 003 Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side

(107)Subtask 536178-250-035-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 45, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEGAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-047 002 Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side

(108)Subtask 536178-250-036-001 - Do a Special Detailed Inspection of the Fastener Holes H8 and H9 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

References	
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Make sure that no bush is installed in the holes H8 and H9 before the application of this SB:

1 If bush installed:

a Contact AIRBUS before next flight and follow their instructions.

2 If no bush installed:

a Apply the instructions given in the following worksteps.

(b) Do an eddy-current rotating probe testing on the holes H8 to H9 on the Frame 46, RH side.

Refer to NTM 51-10-18 and NTM 51-10-01

Refer to [Fig. A-FEFAA](#)

1 If cracks found:

a Contact AIRBUS before next flight and follow their instructions.

2 If no cracks found:

a Do the SUBTASK 536178-831-048 002 Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side

(109)Subtask 536178-831-025-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS GREATER THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBAAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(110)Subtask 536178-831-026-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBBAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(111)Subtask 536178-831-027-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBCAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(112)Subtask 536178-831-028-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBDAC Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBDAC](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(113)Subtask 536178-831-029-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBEAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(114)Subtask 536178-831-030-001 - Depending on the Inspection Result, Ream Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 10.218 mm (0.4022 in.). IF THE HOLE DIAMETER IS MORE THAN 10.218 mm (0.4022 in.), CONTACT AIRBUS.

- (a) Drill and ream the hole H1 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FBFAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(115)Subtask 536178-831-031-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCAAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(116)Subtask 536178-831-032-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCBAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(117)Subtask 536178-831-033-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCCAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(118)Subtask 536178-831-034-001 - Depending on the Inspection Result, Ream Holes H2 to H8 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCDAC Replacement of the Fastener on Holes H2 to H7 of Frame 44	Sheet 01 Sheet 02 Sheet 03

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H8 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCDAC](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(119)Subtask 536178-831-035-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCEAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(120)Subtask 536178-831-036-001 - Depending on the Inspection Result, Ream Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-40-40
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

CAUTION: MAKE SURE THAT THE DIAMETER OF THE FINAL HOLE IS LESS THAN OR EQUAL TO 9.40 mm (0.370 in.). IF THE HOLE DIAMETER IS MORE THAN 9.40 mm (0.370 in.), CONTACT AIRBUS.

- (a) Drill and ream the holes H2 to H7 to the current hole diameter + 0.40 mm (0.0157 in.) in accordance with SRM 51-40-40.

Refer to [Fig. A-FCFAB](#)

- (b) Clean the hole with:

Textile - Lint Free Cotton	14SBA1	As required
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and

Non Aqueous Cleaner - General	08BAA9	As required
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(121)Subtask 536178-831-037-002 - Install the Fastener on the Hole H1 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Component COMPA02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

- 1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

- 1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBAAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBAAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBAAB](#)

1 Bush A5381278720600 Item 2

4 Ream the hole on the bush Item 2 to the applicable fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBAAB](#)

1 Shim A5381309320000 Item 1

1 Bolt EN6115K4-8 Item 10

1 Nut ASNA2529-4 Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBAAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 as the same applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBAAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(122)Subtask 536178-831-038-002 - Install the Fastener on the Hole H1 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Component COMPA04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
10	EN6115K4-8	1	BOLT	
11	ASNA2529-4	1	NUT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
2	A5381278720600	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAB](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBBAB](#)

1 Shim A5381309320000 Item 1

1 Bolt EN6115K6-7 Item 3

1 Nut ASNA2529-6 Item 4

or

1 Shim A5381309320000 Item 1

1 Bolt EN6115K5Y8 Item 5

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBBAB](#)

1 Bush A5381278720600 Item 2

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBBAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K4-8	Item 10
1	Nut	ASNA2529-4	Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBBAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBBAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBBAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6

1 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(123)Subtask 536178-831-039-002 - Install the Fastener on the Hole H1 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Component COMPA06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
36	A5381278720200	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18

References	
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

- 1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

- 1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAB](#)

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Temporarily put in position the shim Item 1.

- 4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

- 5 Clean the drilled area.

- 6 Install the fastener with high interference:

Refer to [Fig. A-FBCAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4

or

SERVICE BULLETIN

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBCAB](#)

1	Bush	A5381278720200	Item 36
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4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in clearance fit:

Refer to [Fig. A-FBCAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K4-9	Item 38
1	Nut	ASNA2529-4	Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBCAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Temporarily put in position the shim Item 1.

4 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

5 Clean the drilled area.

6 Install the fastener with high interference:

Refer to [Fig. A-FBCAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(124)Subtask 536178-831-040-003 - Install the Fastener on the Hole H1 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	0.75
Minimum number of person	1
Subtask elapsed time	0.75
Skills	AIRFRAME

Material necessary to do the job

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

Component COMPA15				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
29	A2521327620100	1	SUPPORT	
32	A2521326620200	1	SHIM	

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

Component COMPA16				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
21	EN6115K4-11	1	BOLT	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	
30	ASNA2027V4-8	2	BOLT	
31	NSA5075-8	2	NUT	
35	ASNA2050DCJ3215	2	RIVET	

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

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Paste Adhesive - Epoxy Potting Structure	13FBB2	As required	

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBDAC Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAC](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBDAC](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Temporarily put in position the support Item (29).

3 Mark the position of the holes H1 and H2 on the support Item (29).

4 Drill the holes on the support Item (29) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAC](#)

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the support:

Refer to [Fig. A-FBDAC](#)

1	Support		Item (29)	Retained at removal
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with:

At Hole H11:

1	Shim		Item (32)	Retained at removal
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1	Bolt	ASNA2027V4-8	Item 30	
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1	Nut	NSA5075-8	Item 31	
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2	Rivet	ASNA2050DCJ3215	Item 35	
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NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
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and at hole H1:

1	Shim	A5381309320000	Item 1	
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1	Bolt	EN6115K6-9	Item 22	
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1	Nut	ASNA2529-6	Item 4	
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or

1	Shim	A5381309320000	Item 1	
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1	Bolt	EN6115K5Y10	Item 23	
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1	Nut	ASNA2529-5	Item 6	
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1	Washer	NSA5368-516B	Item 7	
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NOTE: If spotfacing necessary, contact AIRBUS.

(d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAC](#)

1 If hole diameter H1 of the support Item (29) is greater than 6.35 mm (0.25 in):

a Discard the retained support Item (29).

2 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

3 Clean the drilled area.

4 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBDAC](#)

1 Bush A5381278720400 Item 37

5 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

6 Temporarily put in position the support Item (29) or 29.

If the support has been discard, use:

1 Support A2521327620100 Item 29

7 Mark the position of the holes H1 and H2 on the support Item (29) or 29.

8 Drill the holes on the support Item (29) or 29 to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAC](#)

9 Temporarily put in position the shim Item 1.

10 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

11 Clean the drilled area.

12 Install the support:

Refer to [Fig. A-FBDAC](#)

1 Support Item (29) Retained at removal

If the support Item (29) has been discard:

1 Support A2521327620100 Item 29

with:

At Hole 11:

1	Shim		Item (32)	Retained at removal
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If the support Item (29) has been discard:

1	Shim	A2521326620200	Item 32	
1	Bolt	ASNA2027V4-8	Item 30	
1	Nut	NSA5075-8	Item 31	
2	Rivet	ASNA2050DCJ3215	Item 35	

NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
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and at hole H1:

1	Shim	A5381309320000	Item 1	
1	Bolt	EN6115K4-11	Item 21	
1	Nut	ASNA2529-4	Item 11	

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBDAC](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBDAC](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the support Item (29).

3 Mark the position of the holes H1 and H2 on the support Item (29).

4 Drill the holes on the support Item (29) to the fasteners diameter to be installed in accordance with SRM 51-40-44 (transition fit).

Refer to [Fig. A-FBDAC](#)

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the support:

Refer to [Fig. A-FBDAC](#)

1	Support	Item (20)	Retained at removal
---	---------	-----------	---------------------

with:

At Hole H11:

1	Shim	Item (32)	Retained at removal
---	------	-----------	---------------------

1	Bolt	ASNA2027V4-8	Item 30
---	------	--------------	---------

1	Nut	NSA5075-8	Item 31
---	-----	-----------	---------

2	Rivet	ASNA2050DCJ3215	Item 35
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NOTE: Install the shim Item (32) with:

Paste Adhesive - Epoxy Potting Structure	13FBB2	As required
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and at hole H1:

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K6-9	Item 22
---	------	------------	---------

1	Nut	ASNA2529-6	Item 4
---	-----	------------	--------

or

1	Shim	A5381309320000	Item 1
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1	Bolt	EN6115K5Y10	Item 23
---	------	-------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
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NOTE: If spotfacing necessary, contact AIRBUS.

(125)Subtask 536178-831-041-002 - Install the Fastener on the Hole H1 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Component COMPA10				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03

(a) If the fastener at hole H1 has not been removed:

1 No further action required for the hole H1 only.

(b) If the fastener at hole H1 has been removed:

1 Apply the instruction given in the following steps.

(c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAB](#)

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBEAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAB](#)

1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.

2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBEAB](#)

1	Bush	A5381278720400	Item 37
---	------	----------------	---------

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in transition fit:

Refer to [Fig. A-FBEAB](#)

1	Shim	A5381309320000	Item 1
---	------	----------------	--------

1	Bolt	EN6115K4-9	Item 38
---	------	------------	---------

1	Nut	ASNA2529-4	Item 11
---	-----	------------	---------

NOTE: If spotfacing necessary, contact AIRBUS.

- (e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBEAB](#)

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Temporarily put in position the shim Item 1.
- 3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 4 Clean the drilled area.
- 5 Install the fastener with high interference:

Refer to [Fig. A-FBEAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(126)Subtask 536178-831-042-002 - Install the Fastener on the Hole H1 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Component COMPA12				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	1	NUT	
7	NSA5368-516B	1	WASHER	
11	ASNA2529-4	1	NUT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
38	EN6115K4-9	1	BOLT	

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

Component COMPA14				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	A5381309320000	1	SHIM	
37	A5381278720400	1	BUSH	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Non Destructive Test Manual (NTM)	51-10-01 51-10-18
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03

- (a) If the fastener at hole H1 has not been removed:
 - 1 No further action required for the hole H1 only.
- (b) If the fastener at hole H1 has been removed:
 - 1 Apply the instruction given in the following steps.
- (c) If no crack found and the current hole diameter < 7.827 mm (0.3081 in.):
 - Refer to AMM 20-21-12, Page Block 001
 - In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAB](#)

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Temporarily put in position the shim Item 1.
- 3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.
- 4 Clean the drilled area.
- 5 Install the fastener with high interference:

Refer to [Fig. A-FBFAB](#)

1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- (d) If no crack found and the current hole diameter is between 7.827 mm (0.3081 in.) and 9.418 mm (0.3707 in.) or crack found and the current hole diameter is between 8.627 mm (0.3396 in.) and 10.218 mm (0.4022 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAB](#)

- 1 Ream the hole between 11 mm (0.4331 in.) and 11.018 mm (0.4337 in.) in accordance with SRM 51-40-40.
- 2 Clean the drilled area.

3 Install the bush Item 2 with high interference:

Refer to [Fig. A-FBFAB](#)

1 Bush A5381278720400 Item 37

4 Ream the hole on the bush Item 2 to the fastener diameter in accordance with SRM 51-40-40 (transition fit).

5 Temporarily put in position the shim Item 1.

6 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

7 Clean the drilled area.

8 Install the fasteners in clearance fit:

Refer to [Fig. A-FBFAB](#)

1 Shim A5381309320000 Item 1

1 Bolt EN6115K4-9 Item 38

1 Nut ASNA2529-4 Item 11

NOTE: If spotfacing necessary, contact AIRBUS.

(e) If cracks found and the current hole diameter \leq 8.627 mm (0.3396 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

Refer to [Fig. A-FBFAB](#)

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FBFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Temporarily put in position the shim Item 1.

3 Ream the hole on the shim Item 1 to match the applicable fastener diameter in accordance with SRM 51-40-40.

4 Clean the drilled area.

5 Install the fastener with high interference:

Refer to [Fig. A-FBFAB](#)

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1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Shim	A5381309320000	Item 1
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(127)Subtask 536178-400-007-002 - Install the Fasteners on the Holes H2 to H7 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAB](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7

		and		
1	Bolt		EN6115K6Y7	Item 42
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X6	Item 38
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-6	Item 12
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y7	Item 13
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack removed and the current hole diameter < 9.40 mm (0.370 in):

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCAAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install the fasteners with high interference:

Refer to [Fig. A-FCAAB](#)

5	Bolt		EN6115K6Y8	Item 43
5	Nut		ASNA2529-6	Item 4
5	Washer		NSA5368-616B	Item 46
		or		
5	Bolt		EN6115K6X7	Item 39

	5	Nut	ASNA2529-6	Item 4
		or		
	5	Bolt	EN6115K6-7	Item 3
	5	Nut	ASNA2529-6	Item 4
		or		
	5	Bolt	EN6115K5Y8	Item 5
	5	Nut	ASNA2529-5	Item 6
	5	Washer	NSA5368-516B	Item 7
		and		
	1	Bolt	EN6115K6Y7	Item 42
	1	Nut	ASNA2529-6	Item 4
	1	Washer	NSA5368-616B	Item 46
		or		
	1	Bolt	EN6115K6X6	Item 38
	1	Nut	ASNA2529-6	Item 4
		or		
	1	Bolt	EN6115K6-6	Item 12
	1	Nut	ASNA2529-6	Item 4
		or		
	1	Bolt	EN6115K5Y7	Item 13
	1	Nut	ASNA2529-5	Item 6
	1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(128)Subtask 536178-400-008-002 - Install the Fasteners on the Holes H2 to H7 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	1	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig.](#)

A-FCBAB. It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to Fig. A-FCBAB

1	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		

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1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCBAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCBAB](#)

1	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7

and

1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-6	Item 12
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(129)Subtask 536178-400-009-002 - Install the Fasteners on the Holes H2 to H8 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	5	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	5	BOLT	
6	ASNA2529-5	6	NUT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
7	NSA5368-516B	6	WASHER	
12	EN6115K6-6	1	BOLT	
13	EN6115K5Y7	1	BOLT	
38	EN6115K6X6	1	BOLT	
39	EN6115K6X7	5	BOLT	
42	EN6115K6Y7	1	BOLT	
43	EN6115K6Y8	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter ≤ 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAB](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46

		or		
5	Bolt		EN6115K6X7	Item 39
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K6-7	Item 3
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K5Y8	Item 5
5	Nut		ASNA2529-5	Item 6
5	Washer		NSA5368-516B	Item 7
		and		
1	Bolt		EN6115K6Y7	Item 42
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X6	Item 38
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-6	Item 12
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y7	Item 13
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCCAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install fasteners with interference fit:

Refer to [Fig. A-FCCAB](#)

5	Bolt	EN6115K6Y8	Item 43
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X7	Item 39
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-7	Item 3
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y8	Item 5
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y7	Item 42
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X6	Item 38
1	Nut	ASNA2529-6	Item 4

or

1 Bolt EN6115K6-6 Item 12

1 Nut ASNA2529-6 Item 4

or

1 Bolt EN6115K5Y7 Item 13

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(130)Subtask 536178-400-010-003 - Install the Fastener on the Holes H2 to H7 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	3.50
Minimum number of person	1
Subtask elapsed time	3.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA16				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	7	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	7	NUT	
7	NSA5368-516B	7	WASHER	
22	EN6115K6-9	1	BOLT	
23	EN6115K5Y10	1	BOLT	
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
41	EN6115K6X9	1	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
45	EN6115K6Y10	1	BOLT	
46	NSA5368-616B	7	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCDAC Replacement of the Fastener on Holes H2 to H7 of Frame 44	Sheet 01 Sheet 02 Sheet 03

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCDAC](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDAC](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDAC](#)

1	Bolt	EN6115K6Y10	Item 45
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X9	Item 41
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		

1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	and		
5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		

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1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCDAC](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCDAC](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCDAC](#)

1	Bolt	EN6115K6Y10	Item 45
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X9	Item 41
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-9	Item 22
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y10	Item 23
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

		and		
5	Bolt		EN6115K6Y9	Item 44
5	Nut		ASNA2529-6	Item 4
5	Washer		NSA5368-616B	Item 46
		or		
5	Bolt		EN6115K6X8	Item 40
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K6-8	Item 26
5	Nut		ASNA2529-6	Item 4
		or		
5	Bolt		EN6115K5Y9	Item 27
5	Nut		ASNA2529-5	Item 6
5	Washer		NSA5368-516B	Item 7
		and		
1	Bolt		EN6115K6Y8	Item 43
1	Nut		ASNA2529-6	Item 4
1	Washer		NSA5368-616B	Item 46
		or		
1	Bolt		EN6115K6X7	Item 39
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K6-7	Item 3
1	Nut		ASNA2529-6	Item 4
		or		
1	Bolt		EN6115K5Y8	Item 5
1	Nut		ASNA2529-5	Item 6
1	Washer		NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(131)Subtask 536178-400-011-002 - Install the Fasteners on the Holes H2 to H7 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA10				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	6	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
26	EN6115K6-8	5	BOLT	
27	EN6115K5Y9	5	BOLT	
39	EN6115K6X7	1	BOLT	
40	EN6115K6X8	5	BOLT	
43	EN6115K6Y8	1	BOLT	
44	EN6115K6Y9	5	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

(a) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to [Fig. A-FCEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

- 1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- 2 Clean the drilled area.

- 3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAB](#)

5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39

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1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to [Fig. A-FCEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCEAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install fasteners with interference fit:

Refer to [Fig. A-FCEAB](#)

5	Bolt	EN6115K6Y9	Item 44
5	Nut	ASNA2529-6	Item 4
5	Washer	NSA5368-616B	Item 46
	or		
5	Bolt	EN6115K6X8	Item 40
5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K6-8	Item 26

5	Nut	ASNA2529-6	Item 4
	or		
5	Bolt	EN6115K5Y9	Item 27
5	Nut	ASNA2529-5	Item 6
5	Washer	NSA5368-516B	Item 7
	and		
1	Bolt	EN6115K6Y8	Item 43
1	Nut	ASNA2529-6	Item 4
1	Washer	NSA5368-616B	Item 46
	or		
1	Bolt	EN6115K6X7	Item 39
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(132)Subtask 536178-400-012-002 - Install the Fasteners on the Holes H2 to H7 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Component COMPA12				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	6	NUT	
6	ASNA2529-5	6	NUT	
7	NSA5368-516B	6	WASHER	
26	EN6115K6-8	6	BOLT	
27	EN6115K5Y9	6	BOLT	
40	EN6115K6X8	6	BOLT	
44	EN6115K6Y9	6	BOLT	
46	NSA5368-616B	6	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02

(a) If crack found and the current hole diameter < 9.40 mm (0.370 in):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 0.80 mm (0.0315 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAB](#). It must be as near the current hole diameter + 0.80 mm (0.0315 in.) minimum as possible.

2 Clean the drilled area.

3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAB](#)

6	Bolt	EN6115K6Y9	Item 44
6	Nut	ASNA2529-6	Item 4

	6	Washer	NSA5368-616B	Item 46
		or		
	6	Bolt	EN6115K6X8	Item 40
	6	Nut	ASNA2529-6	Item 4
		or		
	6	Bolt	EN6115K6-8	Item 26
	6	Nut	ASNA2529-6	Item 4
		or		
	6	Bolt	EN6115K5Y9	Item 27
	6	Nut	ASNA2529-5	Item 6
	6	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(b) If no crack found and the current hole diameter \leq 8.670 mm (0.3414 in.):

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00,SRM 51-40-20, SRM 51-40-30

1 Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FCFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

2 Clean the drilled area.

3 Install the new fasteners with interference fit:

Refer to [Fig. A-FCFAB](#)

	6	Bolt	EN6115K6Y9	Item 44
	6	Nut	ASNA2529-6	Item 4
	6	Washer	NSA5368-616B	Item 46
		or		
	6	Bolt	EN6115K6X8	Item 40
	6	Nut	ASNA2529-6	Item 4

or

6 Bolt EN6115K6-8 Item 26

6 Nut ASNA2529-6 Item 4

or

6 Bolt EN6115K5Y9 Item 27

6 Nut ASNA2529-5 Item 6

6 Washer NSA5368-516B Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

(133)Subtask 536178-831-043-002 - Install the Fasteners on the Holes H8 and H9 of Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001

References	
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDAAB Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02
Fig. A-FEAAA Inspection of the Holes on Frame 41	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDAAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

- 3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:
- a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or if hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

- b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fastener in transition fit:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

- (b) Install the new fastener at hole H9:

Refer to [Fig. A-FDAAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

- 1 Measure the edge distance.

Refer to [Fig. A-FEAAA](#)

- 2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

- a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDAAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

- b Clean the drilled area.

- c Install the fastener with high interference:

Refer to [Fig. A-FDAAB](#)

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1	Bolt	EN6115K5Y6	Item 16
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7
	or		
1	Bolt	EN6115K5X5	Item 17
1	Nut	ASNA2529-5	Item 6
	or		
1	Bolt	EN6115K5-5	Item 18
1	Nut	ASNA2529-5	Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or if hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream the bush to a diameter between 7.900 mm (0.3111 in.) and 7.940 mm (0.3125 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDAAB](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(134)Subtask 536178-831-044-002 - Install the Fasteners on the Holes H8 and H9 of Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDBAB Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02
Fig. A-FEBAA Inspection of the Holes on Frame 42	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAB](#)

1	Bolt	EN6115K6-7	Item 3
---	------	------------	--------

1	Nut	ASNA2529-6	Item 4
---	-----	------------	--------

or

1	Bolt	EN6115K5Y8	Item 5
---	------	------------	--------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
---	--------	--------------	--------

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAB](#)

1	Bolt	EN6115K5-8	Item 19
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1 Washer NSA5379-5W Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDBAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEBAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDBAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDBAB](#)

1 Bolt EN6115K5Y6 Item 16

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

or

1 Bolt EN6115K5X5 Item 17

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-5 Item 18

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

- 3** If (edge distance) / (hole diameter + 1.6 mm) < 1.27:
- a** If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):
- <1> Contact AIRBUS before next flight and follow their instructions.
- b** If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):
- <1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame
- <2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.
- <3> Clean the drilled area.
- <4> Install the fasteners in transition fit:

Refer to [Fig. A-FDBAB](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(135)Subtask 536178-831-045-002 - Install the Fasteners on the Holes H9 and H10 of Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA06				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6115K6-7	1	BOLT	
4	ASNA2529-6	1	NUT	
5	EN6115K5Y8	1	BOLT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
15	EN6115K5-6	1	BOLT	
16	EN6115K5Y6	1	BOLT	
17	EN6115K5X5	1	BOLT	
18	EN6115K5-5	1	BOLT	
19	EN6115K5-8	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDCAB Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02
Fig. A-FECAA Inspection of the Holes on Frame 43	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K6-7	Item 3
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y8	Item 5
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDCAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FECAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDCAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K5Y6	Item 16
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
---	--------	--------------	--------

or

1	Bolt	EN6115K5X5	Item 17
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

or

1	Bolt	EN6115K5-5	Item 18
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDCAB](#)

1	Bolt	EN6115K5-6	Item 15
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(136)Subtask 536178-831-046-003 - Install the Fasteners on the Holes H9 and H10 of Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA16				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44

References	
Fig. A-FDDAC Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02
Fig. A-FEDAA Inspection of the Holes on Frame 44	Sheet 01 Sheet 02

(a) Install the new fastener at hole H9:

Refer to [Fig. A-FDDAC](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAC](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAC](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAC](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fasteners at holes H10:

Refer to [Fig. A-FDDAC](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEDAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDDAC](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDDAC](#)

1	Bolt	EN6115K5Y7	Item 13
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

or

1 Bolt EN6115K5X6 Item 14

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDDAC](#)

1 Bolt EN6115K5-7 Item 9

1 Nut ASNA2529-5 Item 6

1 Washer NSA5379-5W Item 47

(137)Subtask 536178-831-047-002 - Install the Fasteners on the Holes H8 and H9 of Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA10				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDEAB Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02
Fig. A-FEFAA Inspection of the Holes on Frame 46	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAB](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6

1 Washer NSA5379-5W Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDEAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEFAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDEAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDEAB](#)

1 Bolt EN6115K5Y7 Item 13

1 Nut ASNA2529-5 Item 6

1 Washer NSA5368-516B Item 7

or

1 Bolt EN6115K5X6 Item 14

1 Nut ASNA2529-5 Item 6

or

1 Bolt EN6115K5-6 Item 15

1 Nut ASNA2529-5 Item 6

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) ≥ 1.30 and the hole diameter ≤ 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDEAB](#)

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(138)Subtask 536178-831-048-002 - Install the Fasteners on the Holes H8 and H9 of Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPA12				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	ASNA2529-6	1	NUT	
6	ASNA2529-5	2	NUT	
7	NSA5368-516B	2	WASHER	
9	EN6115K5-7	1	BOLT	
13	EN6115K5Y7	1	BOLT	

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
14	EN6115K5X6	1	BOLT	
15	EN6115K5-6	1	BOLT	
19	EN6115K5-8	1	BOLT	
26	EN6115K6-8	1	BOLT	
27	EN6115K5Y9	1	BOLT	
47	NSA5379-5W	2	WASHER	

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

References	
Aircraft Maintenance Manual (AMM)	20-21-12, Page Block 001
Structural Repair Manual (SRM)	51-40-00 51-40-20 51-40-30 51-40-40 51-40-44
Fig. A-FDFAB Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02
Fig. A-FEGAA Inspection of the Holes on Frame 45	Sheet 01 Sheet 02

(a) Install the new fastener at hole H8:

Refer to [Fig. A-FDFAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K6-8	Item 26
1	Nut	ASNA2529-6	Item 4
	or		
1	Bolt	EN6115K5Y9	Item 27
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5368-516B	Item 7

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) < 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) < 1.30 or the hole diameter > 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 02 - Principle of Bush Machining and Installation in the Frame Foot

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K5-8	Item 19
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(b) Install the new fastener at hole H9:

Refer to [Fig. A-FDFAB](#)

Refer to AMM 20-21-12, Page Block 001

In accordance with SRM 51-40-00, SRM 51-40-20 and SRM 51-40-30

1 Measure the edge distance.

Refer to [Fig. A-FEGAA](#)

2 If (edge distance) / (hole diameter + 1.6 mm) \geq 1.27:

a Drill and ream the hole to the current hole diameter + 1.60 mm (0.0630 in.) minimum in accordance with SRM 51-40-40.

NOTE: Find the final hole diameter in the fasteners table given in [Fig. A-FDFAB](#). It must be as near the current hole diameter + 1.60 mm (0.0630 in.) minimum as possible.

b Clean the drilled area.

c Install the fastener with high interference:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K5Y7	Item 13
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

1	Washer	NSA5368-516B	Item 7
---	--------	--------------	--------

or

1	Bolt	EN6115K5X6	Item 14
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

or

1	Bolt	EN6115K5-6	Item 15
---	------	------------	---------

1	Nut	ASNA2529-5	Item 6
---	-----	------------	--------

NOTE: If spotfacing necessary, contact AIRBUS.

3 If (edge distance) / (hole diameter + 1.6 mm) $<$ 1.27:

a If (edge distance) / (hole diameter + 0.8 mm) $<$ 1.30 or the hole diameter $>$ 7.92 mm (0.312 in.):

<1> Contact AIRBUS before next flight and follow their instructions.

b If (edge distance) / (hole diameter + 0.8 mm) \geq 1.30 and the hole diameter \leq 7.92 mm (0.312 in.):

<1> Install a bush PN A0041118320000 in accordance with Appendix 03 - Principle of Bush Machining and Installation in the Frame

<2> Drill and ream a bush to a diameter "d" between 7.90 mm (0.311 in.) and 7.94 mm (0.312 in.) in accordance with SRM 51-40-40.

<3> Clean the drilled area.

<4> Install the fasteners in transition fit:

Refer to [Fig. A-FDFAB](#)

1	Bolt	EN6115K5-7	Item 9
1	Nut	ASNA2529-5	Item 6
1	Washer	NSA5379-5W	Item 47

(139)Subtask 536178-800-007-001 - Apply Protective Treatment to the Work Area at Frame 41, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 41

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBAAB Replacement of the Fastener on the Hole H1 of Frame 41	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCAAB Replacement of the Fastener on Holes H2 to H7 of Frame 41	Sheet 01 Sheet 02
Fig. A-FDAAB Replacement of the Fastener on Holes H8 to H9 of Frame 41	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBAAB](#), [Fig. A-FCAAB](#) and [Fig. A-FDAAB](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
---	--------	-------------

(140)Subtask 536178-800-008-001 - Apply Protective Treatment to the Work Area at Frame 42, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 42

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBBAB Replacement of the Fastener on the Hole H1 of Frame 42	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCBAB Replacement of the Fastener on Holes H2 to H7 of Frame 42	Sheet 01 Sheet 02
Fig. A-FDBAB Replacement of the Fastener on Holes H8 to H9 of Frame 42	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBBAB](#), [Fig. A-FBBAB](#) and [Fig. A-FCBAB](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
---	--------	-------------

(141)Subtask 536178-800-009-001 - Apply Protective Treatment to the Work Area at Frame 43, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 43

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBCAB Replacement of the Fastener on the Hole H1 of Frame 43	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCCAB Replacement of the Fastener on Holes H2 to H8 of Frame 43	Sheet 01 Sheet 02
Fig. A-FDCAB Replacement of the Fastener on Holes H9 to H10 of Frame 43	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBCAB](#), [Fig. A-FBCAB](#) and [Fig. A-FCCAB](#)

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
---	--------	-------------

and apply finish:

Top Coat Polyurethane - Grey Internal Structure	04JME4	As required
---	--------	-------------

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
---	--------	-------------

(142)Subtask 536178-800-010-001 - Apply Protective Treatment to the Work Area at Frame 44, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 44

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBDAC Replacement of the Fastener on the Hole H1 of Frame 44	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCDAC Replacement of the Fastener on Holes H2 to H7 of Frame 44	Sheet 01 Sheet 02 Sheet 03
Fig. A-FDDAC Replacement of the Fastener on Holes H9 to H10 of Frame 44	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBDAC](#), [Fig. A-FCDAC](#) and [Fig. A-FDDAC](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey		
Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion	12ABC1	As required
Preventive		
Compound-Water		
Displacing		

(143)Subtask 536178-800-011-001 - Apply Protective Treatment to the Work Area at Frame 45, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 45

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBEAB Replacement of the Fastener on the Hole H1 of Frame 45	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCEAB Replacement of the Fastener on Holes H2 to H7 of Frame 45	Sheet 01 Sheet 02

References	
Fig. A-FDEAB Replacement of the Fastener on Holes H8 to H9 of Frame 45	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBEAB](#), [Fig. A-FCEAB](#) and [Fig. A-FDEAB](#)

Primer	04EAC2	As required
Polyurethane Paint		
- Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey		
Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive	12ABC1	As required
Compound-Water Displacing		

(144)Subtask 536178-800-012-001 - Apply Protective Treatment to the Work Area at Frame 46, RH Side

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Work location	Frame 46

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

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-24-00 51-75-10
Fig. A-FBFAB Replacement of the Fastener on the Hole H1 of Frame 46	Sheet 01 Sheet 02 Sheet 03
Fig. A-FCFAB Replacement of the Fastener on Holes H2 to H7 of Frame 46	Sheet 01 Sheet 02
Fig. A-FDFAB Replacement of the Fastener on Holes H8 to H9 of Frame 46	Sheet 01 Sheet 02

(a) Protect the fastener heads and tails with primer:

In accordance with SRM 51-75-10.

Refer to [Fig. A-FBFAB](#), [Fig. A-FCFAB](#) and [Fig. A-FDFAB](#)

Primer	04EAC2	As required
Polyurethane Paint - Corrosion Inhibiting		

and apply finish:

Top Coat	04JME4	As required
Polyurethane - Grey Internal Structure		

(b) Apply on the work area below the floor level:

Corrosion Preventive Compound-Water Displacing	12ABC1	As required
--	--------	-------------

****CONF ALL**

D. TEST

****CONF 001**

(1) Subtask 536178-700-001-001 - Test

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	25-21-00, Page Block 401 25-23-21, Page Block 401

NOTE: This Service Bulletin requires the accomplishment of the following Tests which are given in subtasks included in the topic Close-up. The man-hours for the tests are included in the referenced Service Bulletin subtasks.

- Do the test procedure as specified after the installation of the passenger seats between Frame 41 and Frame 46, refer to AMM 25-21-00, Page Block 401.
- Do the test procedure as specified after the installation of the passenger-compartment lining-panels, refer to AMM 25-23-21, Page Block 401.

****CONF 002**

(1) Subtask 536178-700-001-001 - Test

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	25-21-00, Page Block 401 25-23-21, Page Block 401

NOTE: This Service Bulletin requires the accomplishment of the following Tests which are given in subtasks included in the topic Close-up. The man-hours for the tests are included in the referenced Service Bulletin subtasks.

- Do the test procedure as specified after the installation of the passenger seats between Frame 41 and Frame 46, refer to AMM 25-21-00, Page Block 401.
- Do the test procedure as specified after the installation of the passenger-compartment lining-panels, refer to AMM 25-23-21, Page Block 401.

**CONF 003

None

**CONF 004

None

**CONF 005

(1) Subtask 536178-700-001-001 - Test

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	25-21-00, Page Block 401 25-23-21, Page Block 401

NOTE: This Service Bulletin requires the accomplishment of the following Tests which are given in subtasks included in the topic Close-up. The man-hours for the tests are included in the referenced Service Bulletin subtasks.

- Do the test procedure as specified after the installation of the passenger seats between Frame 41 and Frame 46, refer to AMM 25-21-00, Page Block 401.
- Do the test procedure as specified after the installation of the passenger-compartment lining-panels, refer to AMM 25-23-21, Page Block 401.

**CONF ALL

E. CLOSE-UP

**CONF 001

(1) Subtask 536178-942-001-001 - Close-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	25-21-00, Page Block 401 25-22-11, Page Block 401 25-23-31, Page Block 401

- Make sure that the work areas are clean and clear of tools and other items of equipment.
- Between Frame 41 and Frame 46, install the heat and sound insulation blankets, refer to AMM 25-22-11, Page Block 401.

- (c) Between Frame 41 and Frame 46, install the passenger-compartment lining-panels, refer to AMM 25-23-31, Page Block 401.
- (d) Between Frame 41 and Frame 46, install the passenger seats, refer to AMM 25-21-00, Page Block 401.
- (e) Remove the access platform(s).
- (f) Put the aircraft back to its initial configuration.

****CONF 002**

(1) Subtask 536178-942-001-001 - Close-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	25-21-00, Page Block 401 25-22-11, Page Block 401 25-23-31, Page Block 401

- (a) Make sure that the work areas are clean and clear of tools and other items of equipment.
- (b) Between Frame 41 and Frame 46, install the heat and sound insulation blankets, refer to AMM 25-22-11, Page Block 401.
- (c) Between Frame 41 and Frame 46, install the passenger-compartment lining-panels, refer to AMM 25-23-31, Page Block 401.
- (d) Between Frame 41 and Frame 46, install the passenger seats, refer to AMM 25-21-00, Page Block 401.
- (e) Remove the access platform(s).
- (f) Put the aircraft back to its initial configuration.

****CONF 003**

(1) Subtask 536178-942-001-002 - Close-up

Manpower Resources	
Skills	NON SPECIFIC

Material necessary to do the job				
Component COMPA17				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
	DAN382G20	1 (M)	TAPE	

NOTE: The quantity given for the PN DAN382G20 is only for the connection between two pipes. The PN DAN382G20 must be orderer as necessary.

NOTE: The above list of components contains items with a Shelf Life of less than or equal to 24 months which must be ordered when you intend to accomplish the Service Bulletin

References	
Aircraft Maintenance Manual (AMM)	25-22-11, Page Block 401 25-58-22, Page Block 401 26-19-12, Page Block 401 53-10-25, Page Block 401
Fig. A-FGAAA Principle for the Removal and the Installation of the Smoke Detector Pipes in the Modification Area	Sheet 01 Sheet 02

- (a) Make sure that the work areas are clean and clear of tools and other items of equipment.
- (b) Between Frame 41 and Frame 46, install the heat and sound insulation blankets, refer to AMM 25-22-11, Page Block 401.
- (c) If removed between Frame 41 and Frame 42, install the smoke detectors FIN 5WU, 7WU, 10WU and 12WU, refer to AMM 26-19-12, Page Block 401.
- (d) Install the removed smoke detector pipes between Frame 41 and Frame 46:

Refer to Fig. [Fig. A-FGAAA](#)

- Put in the position the retained pipe(s) at its(their) applicable location(s).
- Install the pipe(s) with the retained hardware.
- Install new adhesive tape:

1 (M) Tape-Adhesive DAN382G20

NOTE: The quantity given for the adhesive tape is only for the connection between two pipes. The adhesive tape must be used as necessary depending of the number of pipes removed.

- (e) Install the floor panels 242XJ, 241XJ, 242YJ and 241YJ between Frame 45 and Frame 47, refer to AMM 53-10-25, Page Block 401.
- (f) Between Frame 41 and Frame 46, install the main deck cargo lining-panels, refer to AMM 25-58-22, Page Block 401.
- (g) Remove the access platform(s).
- (h) Put the aircraft back to its initial configuration.

****CONF 004**

(1) Subtask 536178-942-001-002 - Close-up

Manpower Resources	
Skills	NON SPECIFIC

Material necessary to do the job

Component COMPA17				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
	DAN382G20	1 (M)	TAPE	

NOTE: The quantity given for the PN DAN382G20 is only for the connection between two pipes. The PN DAN382G20 must be orderer as necessary.

NOTE: The above list of components contains items with a Shelf Life of less than or equal to 24 months which must be ordered when you intend to accomplish the Service Bulletin

References	
Aircraft Maintenance Manual (AMM)	25-22-11, Page Block 401 25-58-22, Page Block 401 26-19-12, Page Block 401 53-10-25, Page Block 401
Fig. A-FGAAA Principle for the Removal and the Installation of the Smoke Detector Pipes in the Modification Area	Sheet 01 Sheet 02

- (a) Make sure that the work areas are clean and clear of tools and other items of equipment.
- (b) Between Frame 41 and Frame 46, install the heat and sound insulation blankets, refer to AMM 25-22-11, Page Block 401.
- (c) If removed between Frame 41 and Frame 42, install the smoke detectors FIN 5WU, 7WU, 10WU and 12WU, refer to AMM 26-19-12, Page Block 401.
- (d) Install the removed smoke detector pipes between Frame 41 and Frame 46:

Refer to Fig. [Fig. A-FGAAA](#)
 - Put in the position the retained pipe(s) at its(their) applicable location(s).
 - Install the pipe(s) with the retained hardware.
 - Install new adhesive tape:

1 (M) Tape-Adhesive DAN382G20

NOTE: The quantity given for the adhesive tape is only for the connection between two pipes. The adhesive tape must be used as necessary depending of the number of pipes removed.

- (e) Install the floor panels 242XJ, 241XJ, 242YJ and 241YJ between Frame 45 and Frame 47, refer to AMM 53-10-25, Page Block 401.
- (f) Between Frame 41 and Frame 46, install the main deck cargo lining-panels, refer to AMM 25-58-22, Page Block 401.
- (g) Remove the access platform(s).
- (h) Put the aircraft back to its initial configuration.

****CONF 005**

(1) Subtask 536178-942-001-001 - Close-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	25-21-00, Page Block 401 25-22-11, Page Block 401 25-23-31, Page Block 401

- (a) Make sure that the work areas are clean and clear of tools and other items of equipment.
- (b) Between Frame 41 and Frame 46, install the heat and sound insulation blankets, refer to AMM 25-22-11, Page Block 401.
- (c) Between Frame 41 and Frame 46, install the passenger-compartment lining-panels, refer to AMM 25-23-31, Page Block 401.
- (d) Between Frame 41 and Frame 46, install the passenger seats, refer to AMM 25-21-00, Page Block 401.
- (e) Remove the access platform(s).
- (f) Put the aircraft back to its initial configuration.

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Task 536178-839-801-001 - Inspection - ADDITIONAL WORK

**CONF ALL

NOTE: No physical work on aircraft is required on this procedure.

Task Associated Data

**CONF 001

Manpower	
TOTAL MANHOURS	0.15
ELAPSED TIME (HOURS)	0.15

**CONF 002

Manpower	
TOTAL MANHOURS	0.15
ELAPSED TIME (HOURS)	0.15

**CONF 003

Manpower	
TOTAL MANHOURS	0.15
ELAPSED TIME (HOURS)	0.15

**CONF 004

Manpower	
TOTAL MANHOURS	0.15
ELAPSED TIME (HOURS)	0.15

**CONF 005

Manpower	
TOTAL MANHOURS	0.15
ELAPSED TIME (HOURS)	0.15

**CONF ALL

A. GENERAL

**CONF 001

(1) Subtask 536178-839-003-001 - 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 536178-839-003-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

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

**CONF 003

(1) Subtask 536178-839-003-001 - 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 536178-839-003-001 - 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 536178-839-003-001 - 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

None

**CONF 002

None

****CONF 003**

None

****CONF 004**

None

****CONF 005**

None

****CONF ALL**

C. PROCEDURE

****CONF 001**

(1) Subtask 536178-832-003-001 - Do a Check of the Rotating Probe Inspection on Frame 41 to Frame 46

Manpower Resources	
Manhours	0.15
Minimum number of person	1
Subtask elapsed time	0.15
Skills	NON SPECIFIC

(a) In the approved maintenance records, inspect if the rotating probe inspection of the fasteners holes on Frame 41 to Frame 46 has been done during the application on aircraft of the original issue of this service bulletin.

- 1 If rotating probe inspection has been done.
 - a No further action
- 2 If no rotating probe inspection has been done.
 - a Contact AIRBUS before next flight and follow their instruction.

****CONF 002**

(1) Subtask 536178-832-003-001 - Do a Check of the Rotating Probe Inspection on Frame 41 to Frame 46

Manpower Resources	
Manhours	0.15
Minimum number of person	1
Subtask elapsed time	0.15
Skills	NON SPECIFIC

(a) In the approved maintenance records, inspect if the rotating probe inspection of the fasteners holes on Frame 41 to Frame 46 has been done during the application on aircraft of the original issue of this service bulletin.

1 If rotating probe inspection has been done.

a No further action

2 If no rotating probe inspection has been done.

a Contact AIRBUS before next flight and follow their instruction.

**CONF 003

(1) **Subtask 536178-832-003-001 - Do a Check of the Rotating Probe Inspection on Frame 41 to Frame 46**

Manpower Resources	
Manhours	0.15
Minimum number of person	1
Subtask elapsed time	0.15
Skills	NON SPECIFIC

(a) In the approved maintenance records, inspect if the rotating probe inspection of the fasteners holes on Frame 41 to Frame 46 has been done during the application on aircraft of the original issue of this service bulletin.

1 If rotating probe inspection has been done.

a No further action

2 If no rotating probe inspection has been done.

a Contact AIRBUS before next flight and follow their instruction.

**CONF 004

(1) **Subtask 536178-832-003-001 - Do a Check of the Rotating Probe Inspection on Frame 41 to Frame 46**

Manpower Resources	
Manhours	0.15
Minimum number of person	1
Subtask elapsed time	0.15
Skills	NON SPECIFIC

(a) In the approved maintenance records, inspect if the rotating probe inspection of the fasteners holes on Frame 41 to Frame 46 has been done during the application on aircraft of the original issue of this service bulletin.

1 If rotating probe inspection has been done.

a No further action

2 If no rotating probe inspection has been done.

a Contact AIRBUS before next flight and follow their instruction.

**CONF 005

(1) **Subtask 536178-832-003-001 - Do a Check of the Rotating Probe Inspection on Frame 41 to Frame 46**

Manpower Resources	
Manhours	0.15
Minimum number of person	1
Subtask elapsed time	0.15
Skills	NON SPECIFIC

(a) In the approved maintenance records, inspect if the rotating probe inspection of the fasteners holes on Frame 41 to Frame 46 has been done during the application on aircraft of the original issue of this service bulletin.

1 If rotating probe inspection has been done.

a No further action

2 If no rotating probe inspection has been done.

a Contact AIRBUS before next flight and follow their instruction.

**CONF ALL

D. TEST

**CONF 001

None

**CONF 002

None

**CONF 003

None

█ ****CONF 004**

█ None

█ ****CONF 005**

█ None

█ ****CONF ALL**

█ **E. CLOSE-UP**

█ ****CONF 001**

█ None

█ ****CONF 002**

█ None

█ ****CONF 003**

█ None

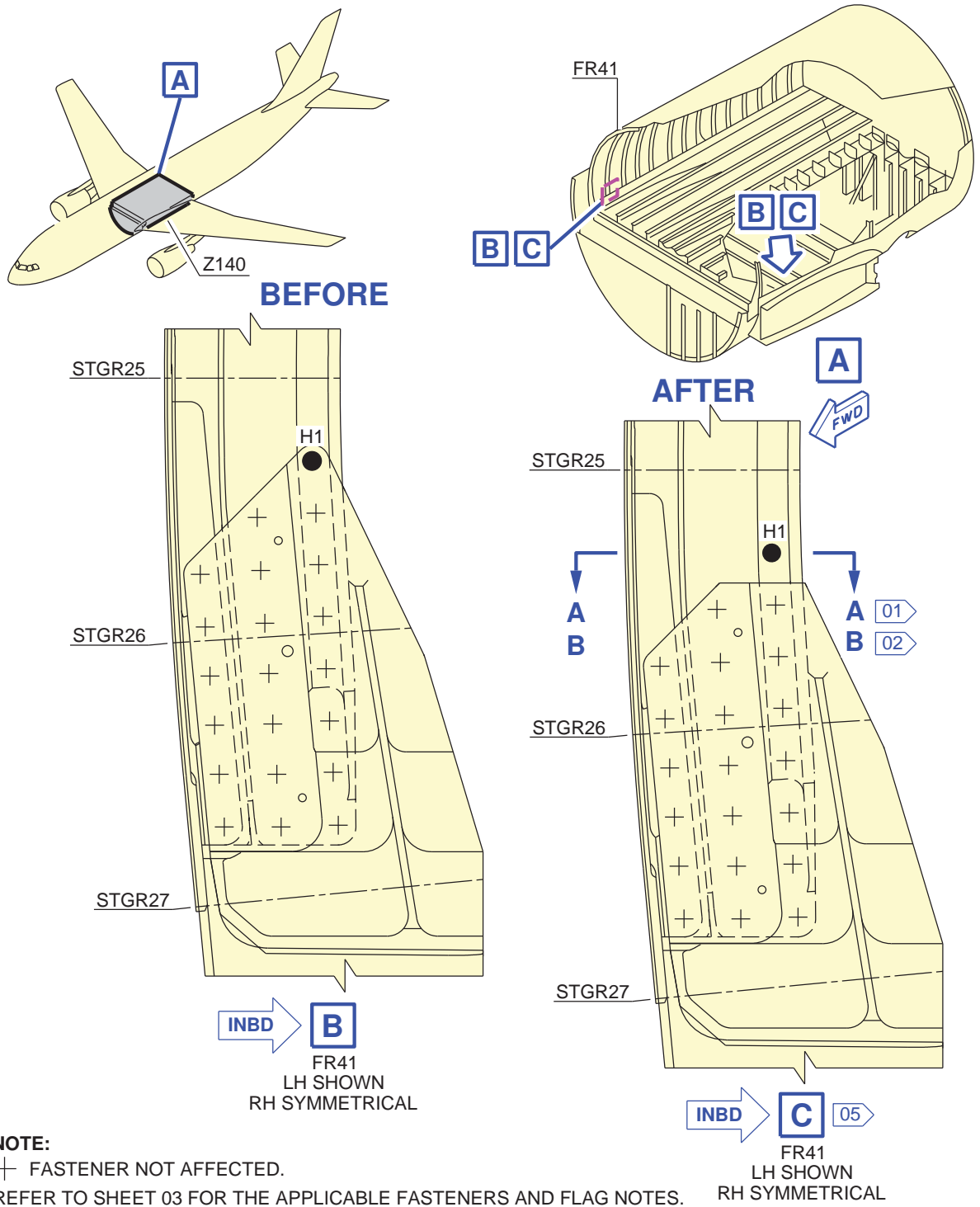
█ ****CONF 004**

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█ ****CONF 005**

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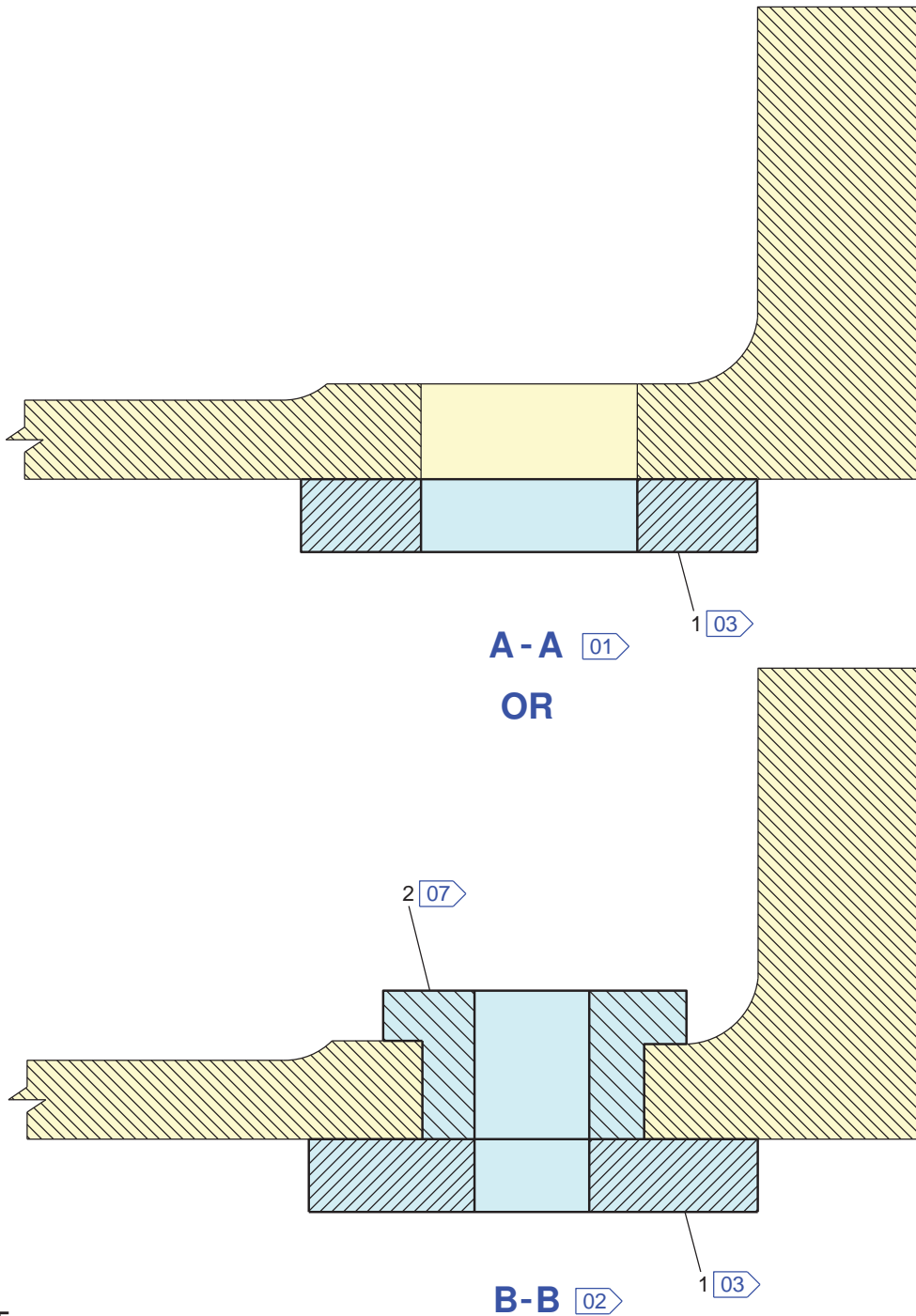
**CONF 001, 003



D_SB_536178_5_BAAA_01_03

Figure A-FBAAA - Sheet 01
Replacement of the Fastener on the Hole H1 of Frame 41

**CONF 001, 003



NOTE:
REFER TO SHEET 03 FOR THE APPLICABLE FLAG NOTES.

D_SB_536178_5_BAAA_02_05

Figure A-FBAAA - Sheet 02
Replacement of the Fastener on the Hole H1 of Frame 41

**CONF 001, 003

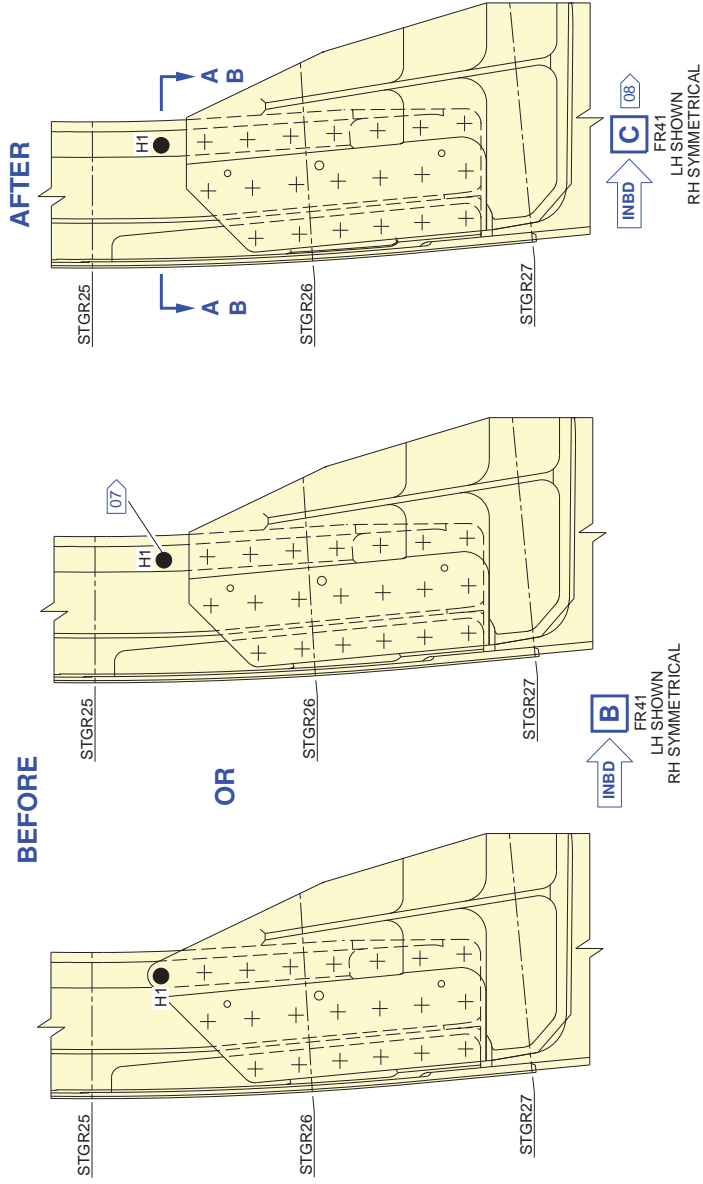
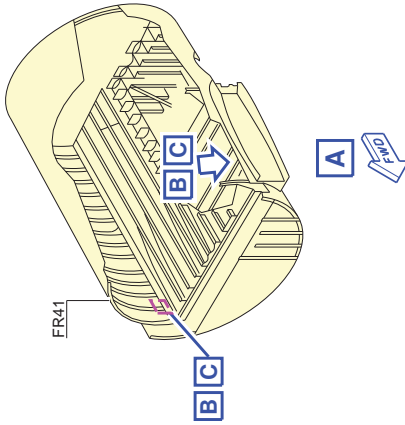
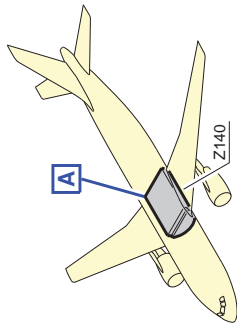
HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
●	(3)	3	EN6115K6-7	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	(01) (06)
	(4)	4	ASNA2529-6	NUT				(08)
						OR		
	(3)	5	EN6115K5Y8	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	(01) (06)
	(4)	6	ASNA2529-5	NUT				(08)
						OR		
	(3)	8	EN6115K5X7	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	(01) (06)
	(4)	6	ASNA2529-5	NUT				(08)
						OR		
	(3)	9	EN6115K5-7	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	(01) (06)
	(4)	6	ASNA2529-5	NUT				(08)
					OR			
(3)	10	EN6115K4-8	BOLT	6.310 mm (0.2485 in)	6.350 mm (0.2500 in)	FASTENERS IN TRANSITION FIT	(02) (04)	
(4)	11	ASNA2529-4	NUT				(06)	

NOTE:

- (01) > VALID ONLY IF THE HOLE DIAMETER IS LESS THAN OR EQUAL TO 9.418 mm (0.3708 in).
- (02) > VALID IF THE HOLE DIAMETER IS MORE THAN 9.418 mm (0.3708 in).
- (03) > COUNTERDRILL THE SHIM ITEM 1 TO THE FASTENER DIAMETER TO BE INSTALLED.
- (04) > OVERSIZE THE HOLE BETWEEN 11 mm (0.4331 in) AND 11.018 mm (0.4337 in) BEFORE THE INSTALLATION OF THE BUSH ITEM 2.
- (05) > PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JIME4.
- (06) > IF SPOTFACING NECESSARY CONTACT AIRBUS.
- (07) > BEFORE THE INSTALLATION OF THE BUSH ITEM 2, PROTECT THE HOLE INNER FACE WITH MATERIAL No 06ABC1.
- (08) > OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).

Figure A-FBAAA - Sheet 03
Replacement of the Fastener on the Hole H1 of Frame 41

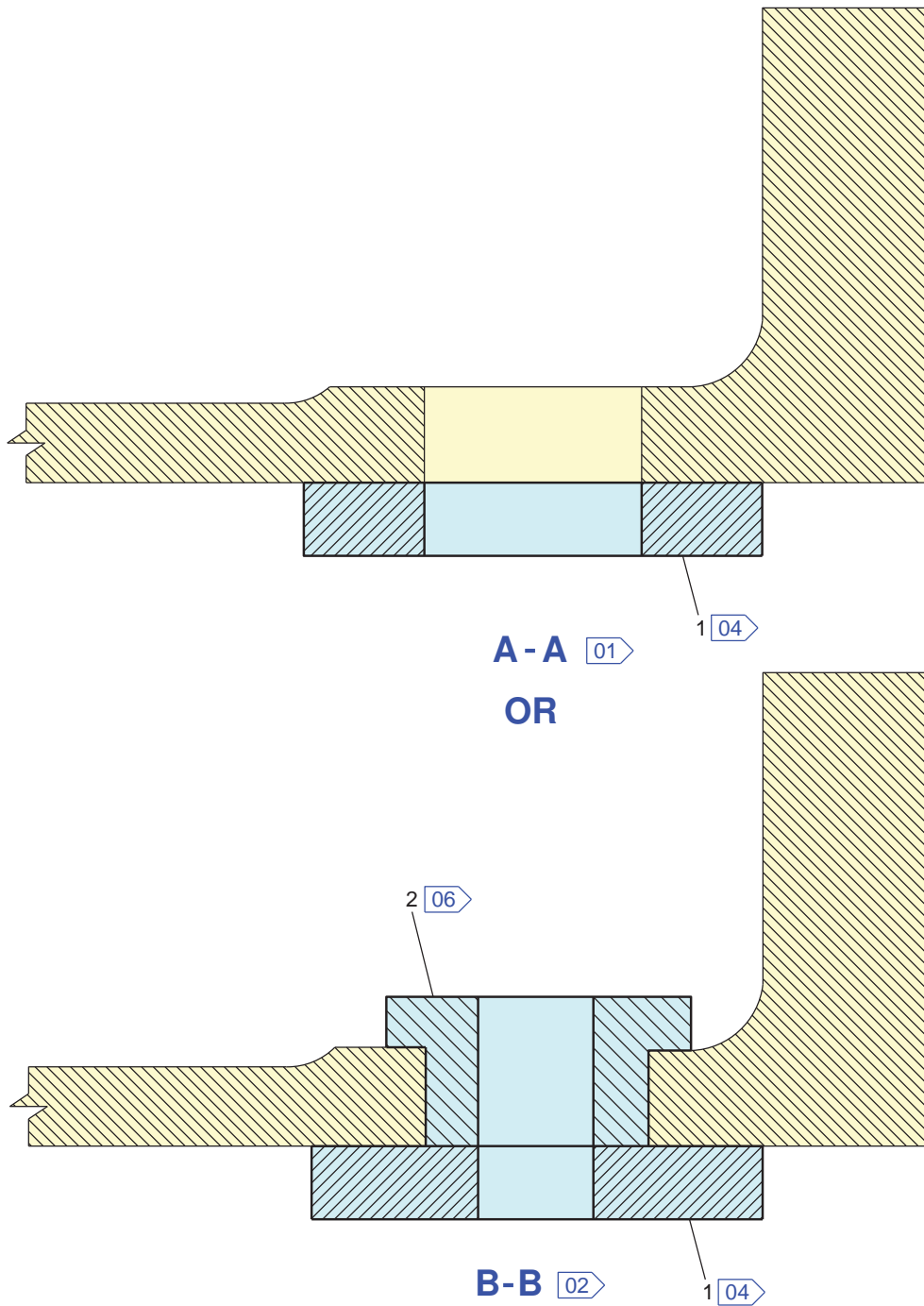
**CONF 002, 004 thru 005



NOTE:
+ FASTENER NOT AFFECTED.
REFER TO SHEET 03 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

Figure A-FBAAB - Sheet 01
Replacement of the Fastener on the Hole H1 of Frame 41

****CONF 002, 004 thru 005**



NOTE:
REFER TO SHEET 03 FOR THE APPLICABLE FLAG NOTES.

D_SB_536178_5_BAAB_02_05

Figure A-FBAAB - Sheet 02
Replacement of the Fastener on the Hole H1 of Frame 41

**CONF 002, 004 thru 005

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE	
					MIN	MAX			
●	(3)	3	EN6115K6-7	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	(01) (09)	
	(4)	4	ASNA2529-6	NUT				(11)	
	OR								
	(3)	5	EN6115K5Y8	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	(01) (03)	
	(4)	6	ASNA2529-5	NUT				(09)	
		7	NSA5368-516B	WASHER					
	OR								
(3)	21	EN6115K4-11	BOLT	6.310 mm (0.2485 in)	6.350 mm (0.2500 in)	FASTENERS IN TRANSITION FIT	(02) (05)		
(4)	11	ASNA2529-4	NUT				(09) (10)		

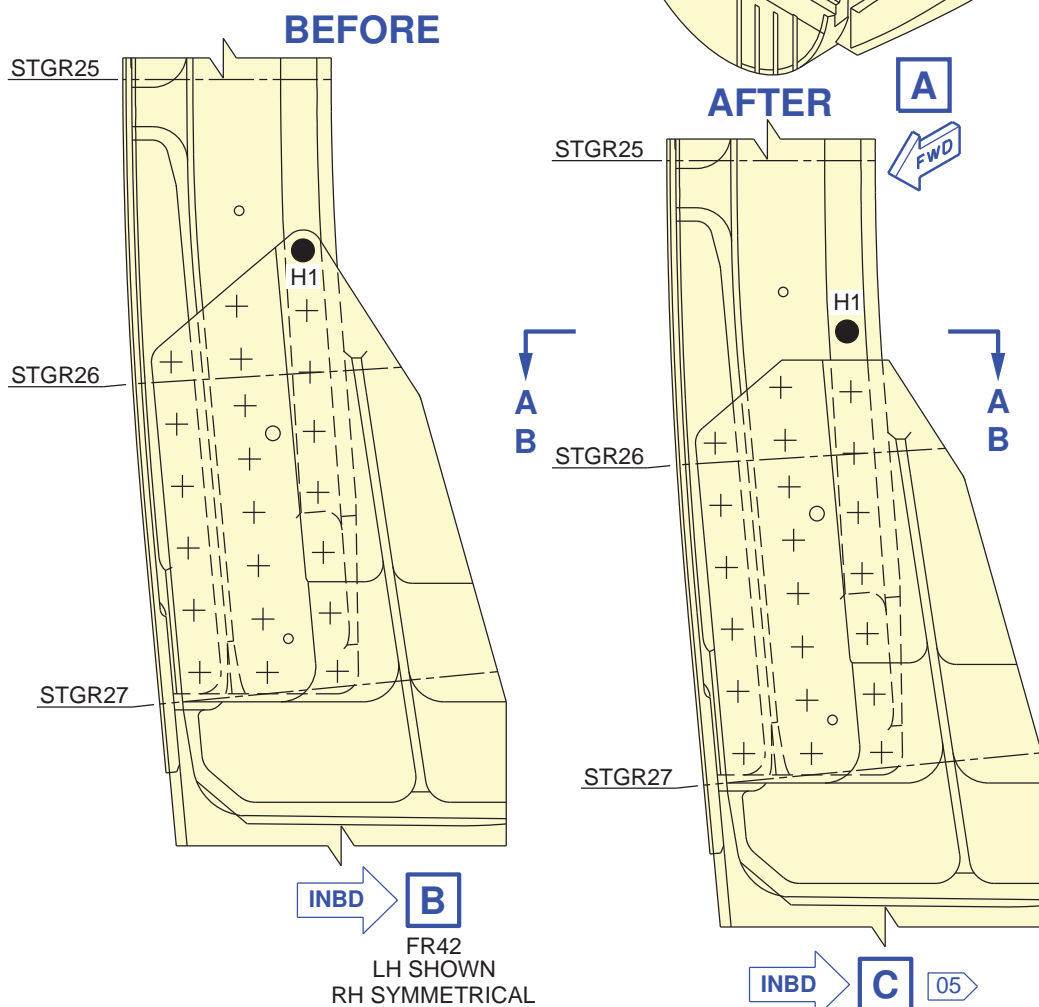
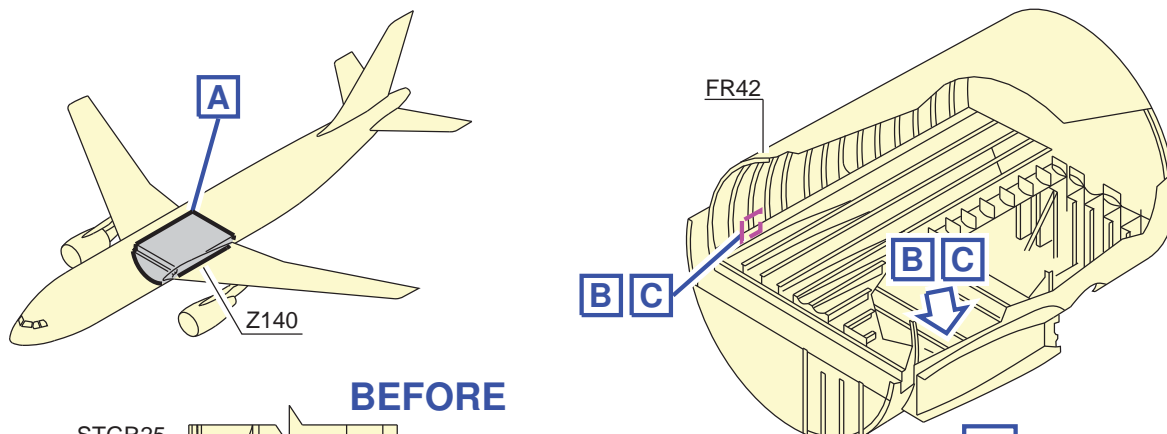
NOTE:

- (01) VALID ONLY IF THE HOLE DIAMETER IS LESS THAN OR EQUAL TO 9.418 mm (0.3708 in).
- (02) VALID IF THE HOLE DIAMETER IS MORE THAN 9.418 mm (0.3708 in).
- (03) OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 10.218 mm (0.4023 in)).
- (04) COUNTERDRILL THE SHIM ITEM 1 TO THE FASTENER DIAMETER TO BE INSTALLED.
- (05) OVERSIZE THE HOLE BETWEEN 11 mm (0.4331 in) AND 11.018 mm (0.4337 in).
- (06) BEFORE THE INSTALLATION OF THE BUSH ITEM 2, PROTECT THE HOLE INNER FACE WITH MATERIAL No 06ABC1.
- (07) IF THE FRAME FOOT IS ALREADY CUT, DO NOT REMOVE THE FASTENER.
- (08) PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JME4.
- (09) IF SPOTFACING NECESSARY CONTACT AIRBUS.
- (10) VALID ONLY IF A BUSH IS INSTALLED.
- (11) OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).

Figure A-FBAAB - Sheet 03

Replacement of the Fastener on the Hole H1 of Frame 41

**CONF 001, 003



NOTE:

+ FASTENER NOT AFFECTED.

REFER TO SHEET 03 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

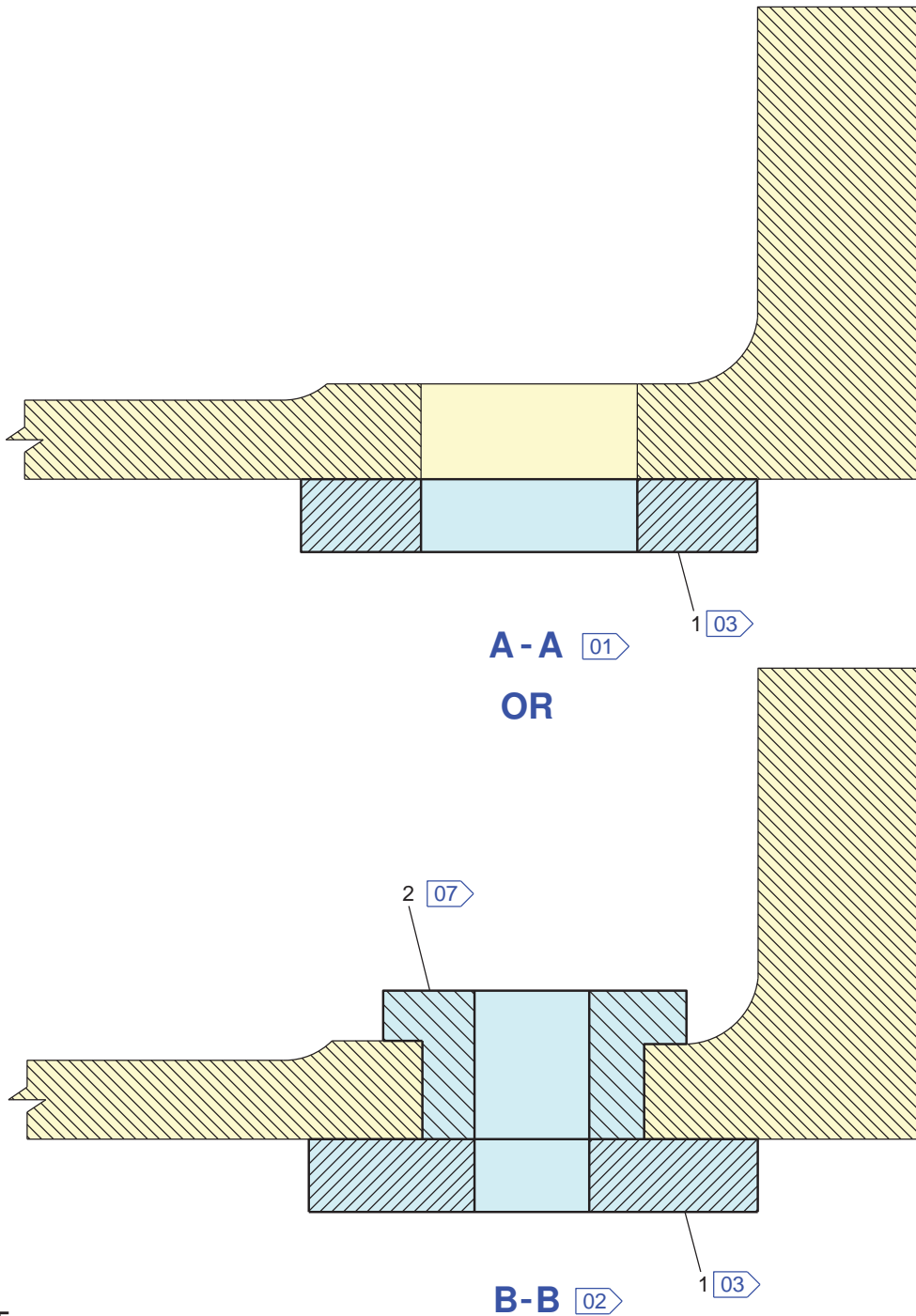
FR42
LH SHOWN
RH SYMMETRICAL

FR42
LH SHOWN
RH SYMMETRICAL

D_SB_536178_5_BBAA_01_04

Figure A-FBBAA - Sheet 01
Replacement of the Fastener on the Hole H1 of Frame 42

**CONF 001, 003



NOTE:
REFER TO SHEET 03 FOR THE APPLICABLE FLAG NOTES.

D_SB_536178_5_BBAA_02_05

Figure A-FBBAA - Sheet 02
Replacement of the Fastener on the Hole H1 of Frame 42

**CONF 001, 003

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
	(3)	3	EN6115K6-7	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	(01) (06)
	(4)	4	ASNA2529-6	NUT				(08)
	(3)	5	EN6115K5Y8	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	(01) (06)
	(4)	6	ASNA2529-5	NUT				(08)
		7	NSA5368-516B	WASHER				
	(3)	8	EN6115K5X7	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	(01) (06)
	(4)	6	ASNA2529-5	NUT				(08)
	(3)	9	EN6115K5-7	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	(01) (06)
	(4)	6	ASNA2529-5	NUT				(08)
	(3)	10	EN6115K4-8	BOLT	6.310 mm (0.2485 in)	6.350 mm (0.2500 in)	FASTENERS IN TRANSITION FIT	(02) (04)
	(4)	11	ASNA2529-4	NUT				(06)

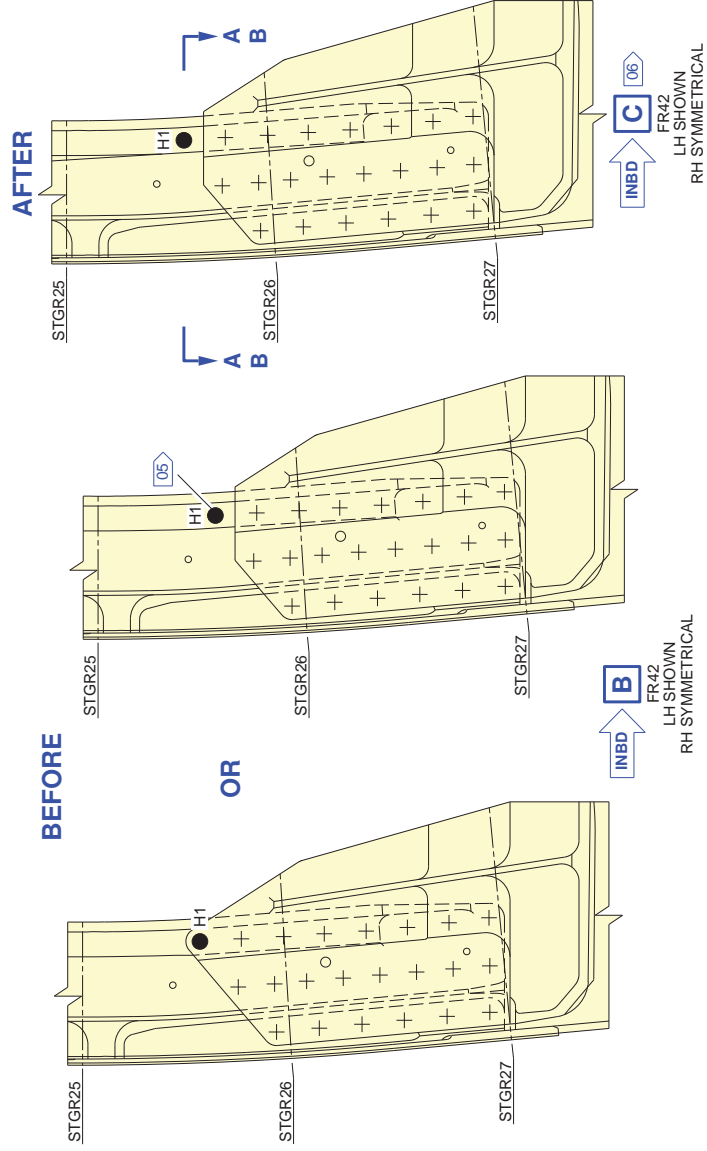
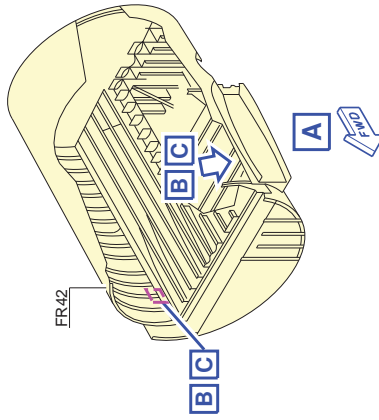
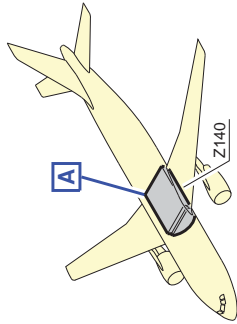
NOTE:

- (01) > VALID ONLY IF THE HOLE DIAMETER IS LESS THAN OR EQUAL TO 9.418 mm (0.3708 in).
- (02) > VALID IF THE HOLE DIAMETER IS MORE THAN 9.418 mm (0.3708 in).
- (03) > COUNTERDRILL THE SHIM ITEM 1 TO THE FASTENER DIAMETER TO BE INSTALLED.
- (04) > OVERSIZE THE HOLE BETWEEN 11 mm (0.4331 in) AND 11.018 mm (0.4337 in), BEFORE THE INSTALLATION OF THE BUSH ITEM 2.
- (05) > PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JIME4.
- (06) > IF SPOTFACING NECESSARY CONTACT AIRBUS.
- (07) > BEFORE THE INSTALLATION OF THE BUSH ITEM 2, PROTECT THE HOLE INNER FACE WITH MATERIAL No 06ABC1.
- (08) > OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).

Figure A-FBAA - Sheet 03

Replacement of the Fastener on the Hole H1 of Frame 42

**CONF 002, 004 thru 005

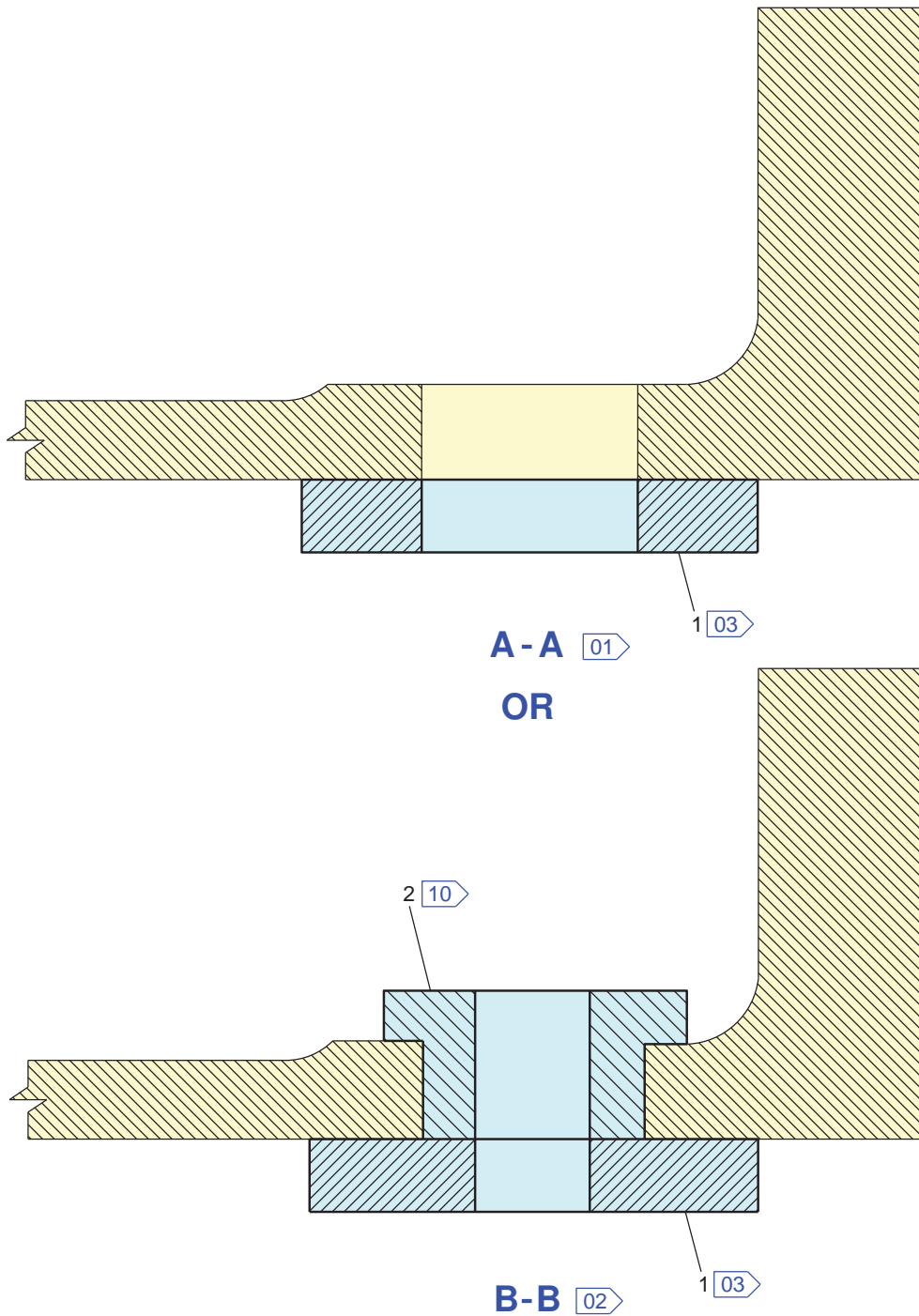


NOTE:
+ FASTENER NOT AFFECTED.
REFER TO SHEET 03 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

Figure A-FBBAB - Sheet 01
Replacement of the Fastener on the Hole H1 of Frame 42

D_SB_536178_5_BBAB_01_04

****CONF 002, 004 thru 005**



NOTE:
REFER TO SHEET 03 FOR THE APPLICABLE FLAG NOTES.

D_SB_536178_5_BBAB_02_05

Figure A-FBBAB - Sheet 02
Replacement of the Fastener on the Hole H1 of Frame 42

**CONF 002, 004 thru 005

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
●	(3)	3	EN6115K6-7	BOLT	9.387 mm (0.3686 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 07 09
	(4)	4	ASNA2529-6	NUT	OR			
	(3)	5	EN6115K5Y8	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 07 09
	(4)	6	ASNA2529-5	NUT	OR			
	(4)	7	NSA5368-516B	WASHER	OR			
	(3)	10	EN6115K4-8	BOLT	6.310 mm (0.2485 in)	6.350 mm (0.2500 in)	FASTENERS IN TRANSITION FIT	02 04 07 08
	(4)	11	ASNA2529-4	NUT	OR			

- NOTE:**
- 01 > VALID ONLY IF THE HOLE DIAMETER IS LESS THAN OR EQUAL TO 9.418 mm (0.3708 in).
 - 02 > VALID IF THE HOLE DIAMETER IS MORE THAN 9.418 mm (0.3708 in).
 - 03 > COUNTERDRILL THE SHIM ITEM 1 TO THE FASTENER DIAMETER TO BE INSTALLED.
 - 04 > OVERSIZE THE HOLE BETWEEN 11 mm (0.4331 in) AND 11.018 mm (0.4337 in).
 - 05 > IF THE FRAME FOOT IS ALREADY CUT, DO NOT REMOVE THE FASTENER.
 - 06 > PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JME4.
 - 07 > IF SPOTFACING NECESSARY CONTACT AIRBUS.
 - 08 > VALID ONLY IF A BUSH IS INSTALLED.
 - 09 > OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).
 - 10 > BEFORE THE INSTALLATION OF THE BUSH ITEM 2, PROTECT THE HOLE INNER FACE WITH MATERIAL No 06ABC1.

**CONF 001, 003

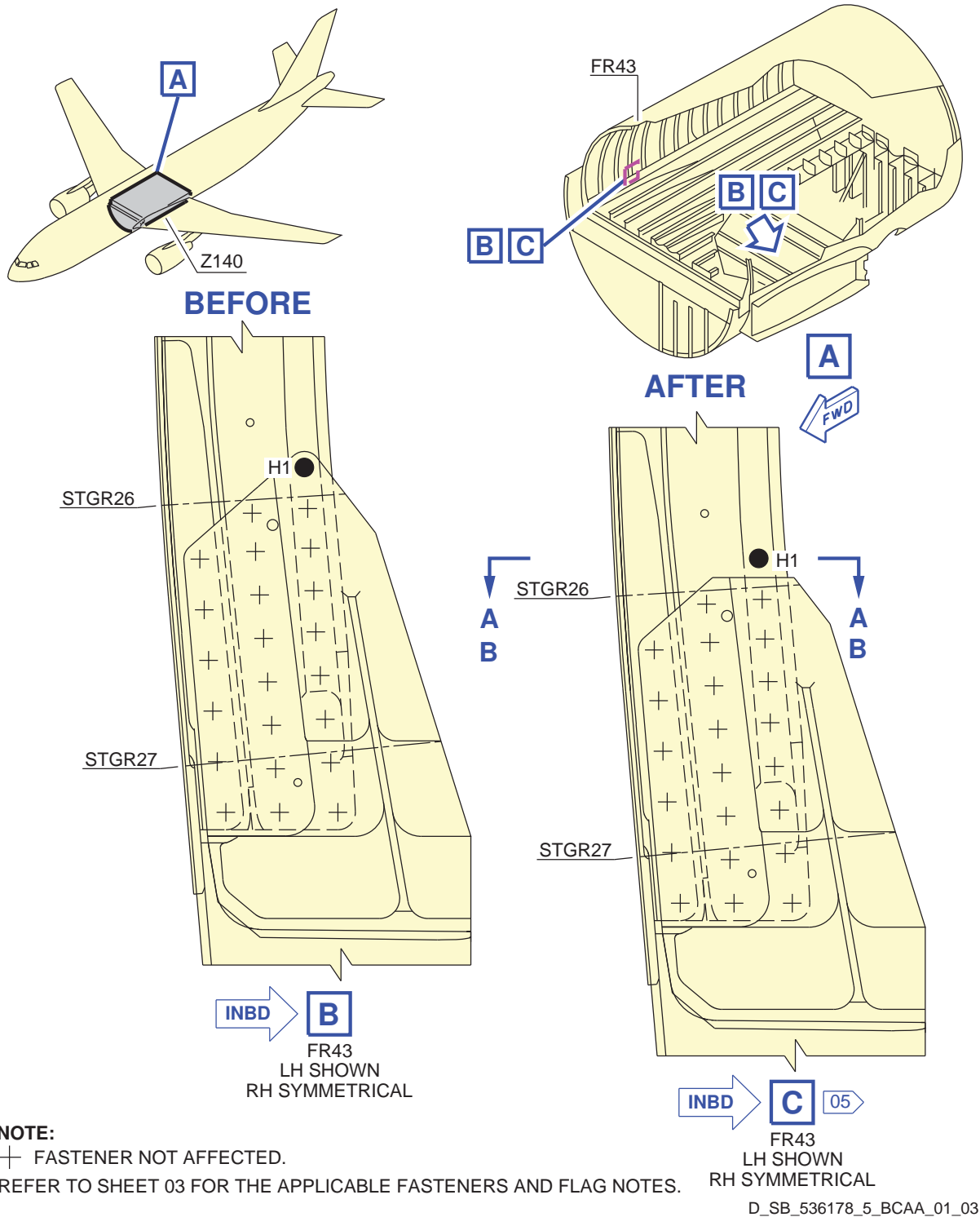
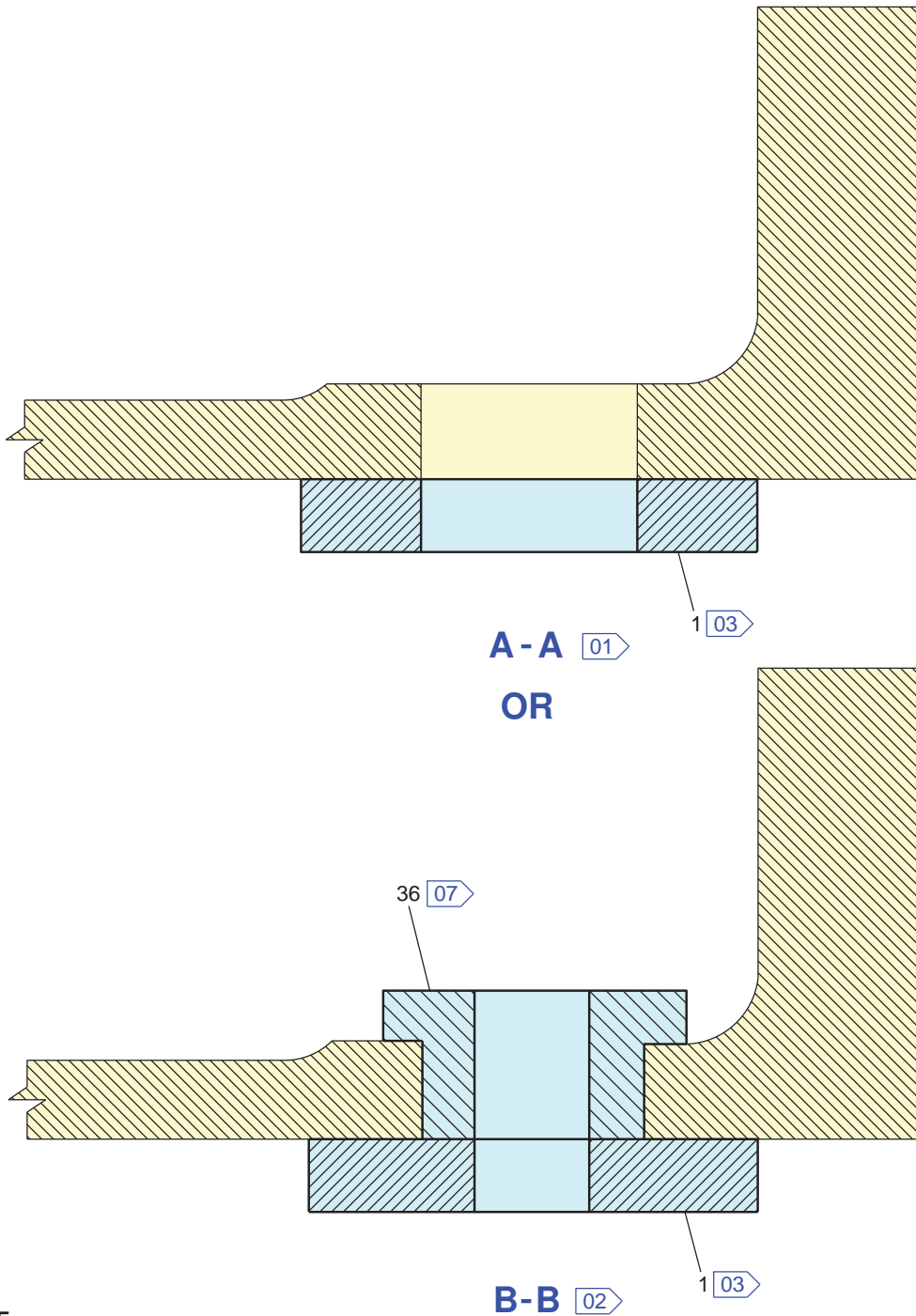


Figure A-FBCAA - Sheet 01
Replacement of the Fastener on the Hole H1 of Frame 43

**CONF 001, 003



NOTE:
REFER TO SHEET 03 FOR THE APPLICABLE FLAG NOTES.

D_SB_536178_5_BCAA_02_05

Figure A-FBCAA - Sheet 02
Replacement of the Fastener on the Hole H1 of Frame 43

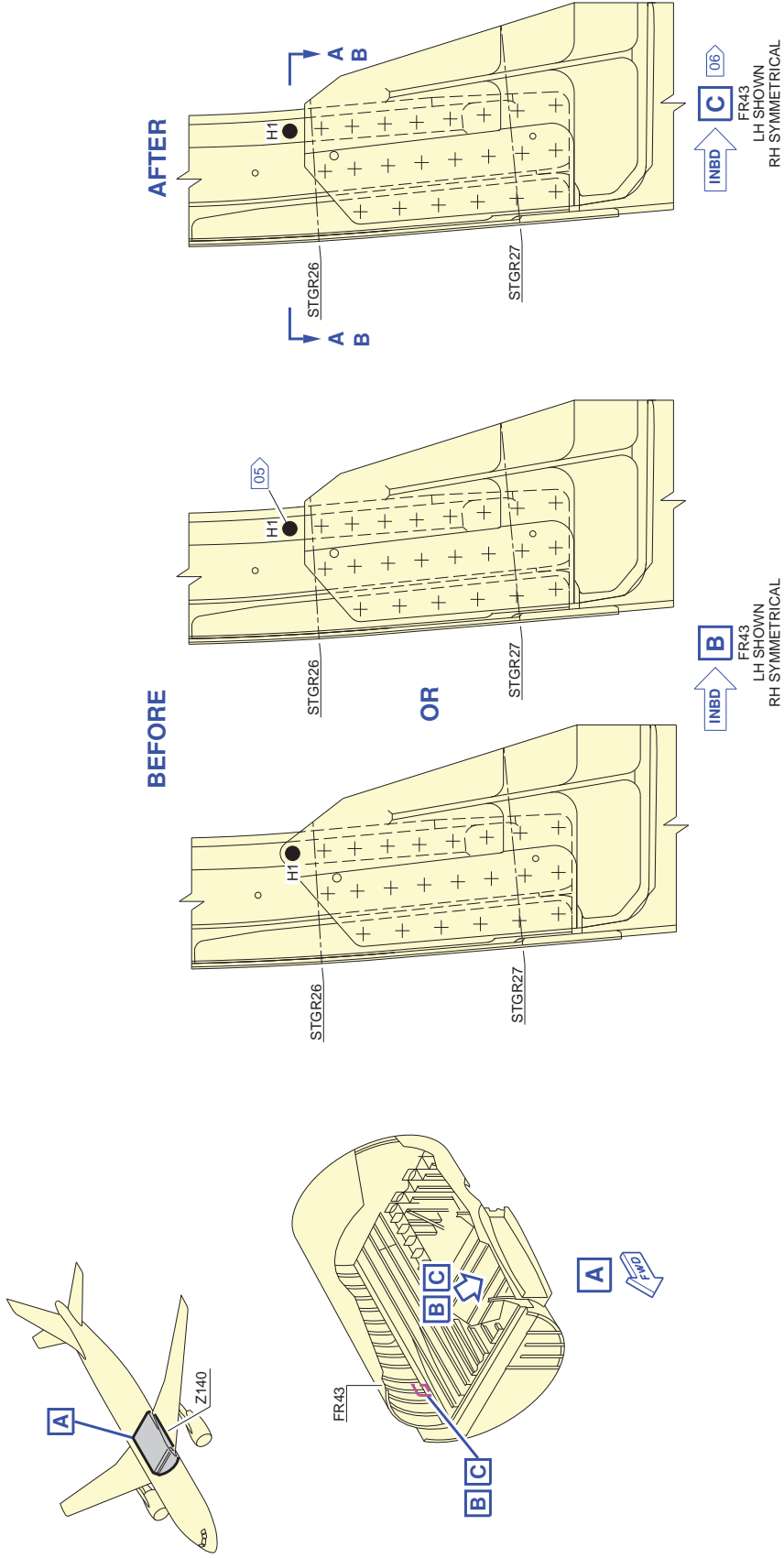
**CONF 001, 003

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
	(3)	3	EN6115K6-7	BOLT	9,387 mm (0.3696 in)	9,427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 06 08
	(4)	4	ASNA2529-6	NUT	OR			
	(3)	5	EN6115K5Y8	BOLT	8,602 mm (0.3387 in)	8,642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 06 08
	(4)	6	ASNA2529-5	NUT	OR			
		7	NSA5368-516B	WASHER	OR			
	(3)	8	EN6115K5X7	BOLT	8,206 mm (0.3231 in)	8,246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 06 08
(4)	6	ASNA2529-5	NUT	OR				
	(3)	9	EN6115K5-7	BOLT	7,809 mm (0.3075 in)	7,849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 06 08
	(4)	6	ASNA2529-5	NUT	OR			
	(3)	38	EN6115K4-9	BOLT	6,310 mm (0.2485 in)	6,350 mm (0.2500 in)	FASTENERS IN TRANSITION FIT	02 04 06
	(4)	11	ASNA2529-4	NUT	OR			

- NOTE:**
- 01> VALID ONLY IF THE HOLE DIAMETER IS LESS THAN OR EQUAL TO 9.418 mm (0.3708 in).
 - 02> VALID IF THE HOLE DIAMETER IS MORE THAN 9.418 mm (0.3708 in).
 - 03> COUNTERDRILL THE SHIM ITEM 1 TO THE FASTENER DIAMETER TO BE INSTALLED.
 - 04> OVERSIZE THE HOLE BETWEEN 11 mm (0.4331 in) AND 11.018 mm (0.4337 in) BEFORE THE INSTALLATION OF THE BUSH ITEM 36.
 - 05> PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JME4.
 - 06> IF SPOTTAGING NECESSARY CONTACT AIRBUS.
 - 07> BEFORE THE INSTALLATION OF THE BUSH ITEM 36, PROTECT THE HOLE INNER FACE WITH MATERIAL No 06ABC1.
 - 08> OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).

Figure A-FBCAA - Sheet 03
Replacement of the Fastener on the Hole H1 of Frame 43

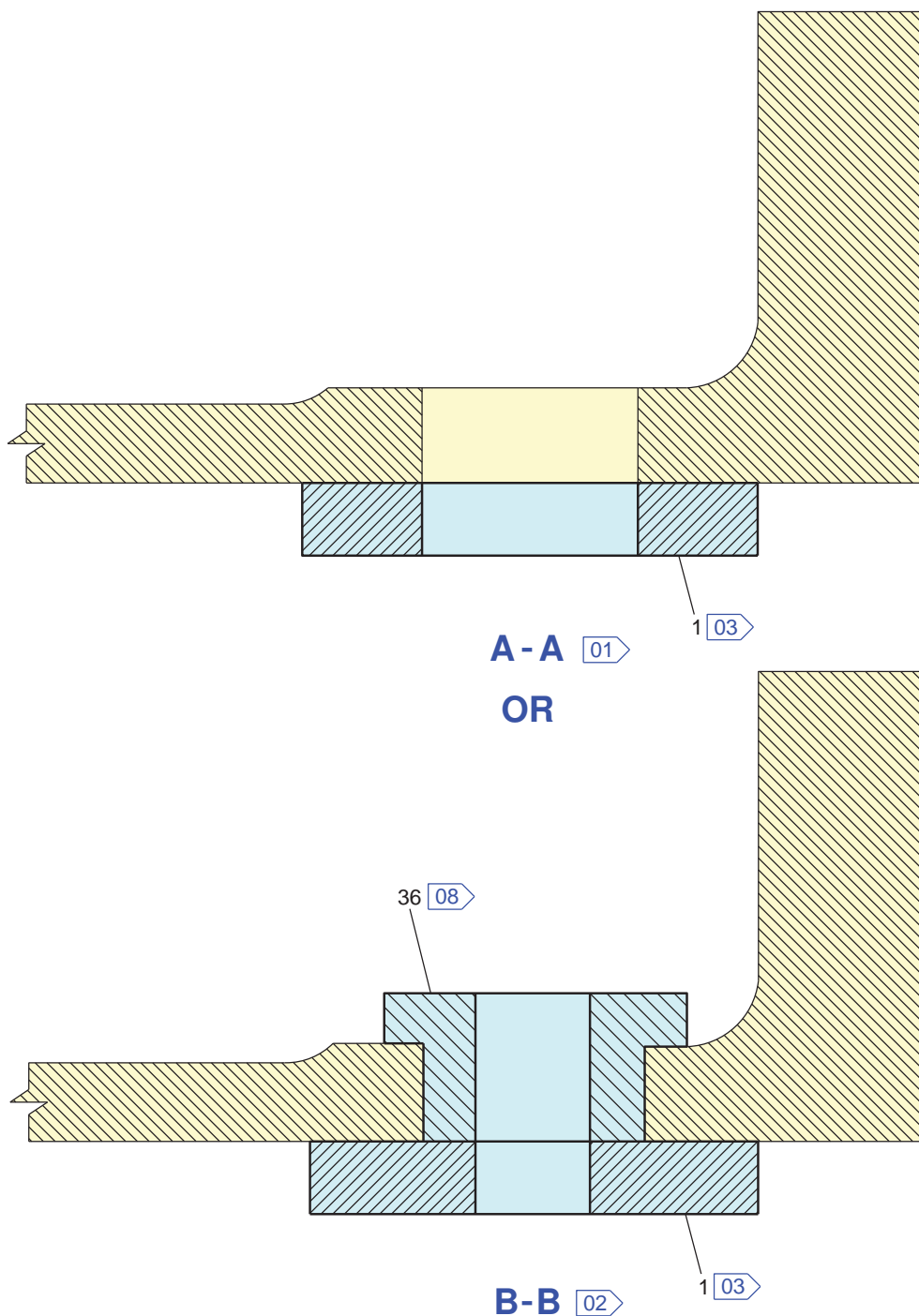
**CONF 002, 004 thru 005



NOTE:
+ FASTENER NOT AFFECTED.
REFER TO SHEET 03 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

Figure A-FBCAB - Sheet 01
Replacement of the Fastener on the Hole H1 of Frame 43

****CONF 002, 004 thru 005**



NOTE:
REFER TO SHEET 03 FOR THE APPLICABLE FLAG NOTES.

D_SB_536178_5_BCAB_02_05

Figure A-FBCAB - Sheet 02
Replacement of the Fastener on the Hole H1 of Frame 43

**CONF 002, 004 thru 005

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE	
					MIN	MAX			
●	(3)	3	EN6115K6-7	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 07 09	
	(4)	4	ASNA2529-6	NUT					
	OR								
	(3)	5	EN6115K5Y8	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 07 09	
	(4)	6	ASNA2529-5	NUT					
		7	NSA5368-516B	WASHER					
	OR								
(3)	38	EN6115K4-9	BOLT	6.310 mm (0.2485 in)	6.350 mm (0.2500 in)	FASTENERS IN TRANSITION FIT	02 04 07		
(4)	11	ASNA2529-4	NUT						

NOTE:

- 01 VALID ONLY IF THE HOLE DIAMETER IS LESS THAN OR EQUAL TO 9.418 mm (0.3708 in).
- 02 VALID IF THE HOLE DIAMETER IS MORE THAN 9.418 mm (0.3708 in).
- 03 COUNTERDRILL THE SHIM ITEM 1 TO THE FASTENER DIAMETER TO BE INSTALLED.
- 04 OVERSIZE THE HOLE BETWEEN 11 mm (0.4331 in) AND 11.018 mm (0.4337 in) BEFORE THE INSTALLATION OF THE BUSH ITEM 36.
- 05 IF THE FRAME FOOT IS ALREADY CUT, DO NOT REMOVE THE FASTENER.
- 06 PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JIME4.
- 07 IF SPOTFACING NECESSARY CONTACT AIRBUS.
- 08 BEFORE THE INSTALLATION OF THE BUSH ITEM 36, PROTECT THE HOLE INNER FACE WITH MATERIAL No 06ABC1.
- 09 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).

Figure A-FBCAB - Sheet 03
Replacement of the Fastener on the Hole H1 of Frame 43

**CONF 001, 003

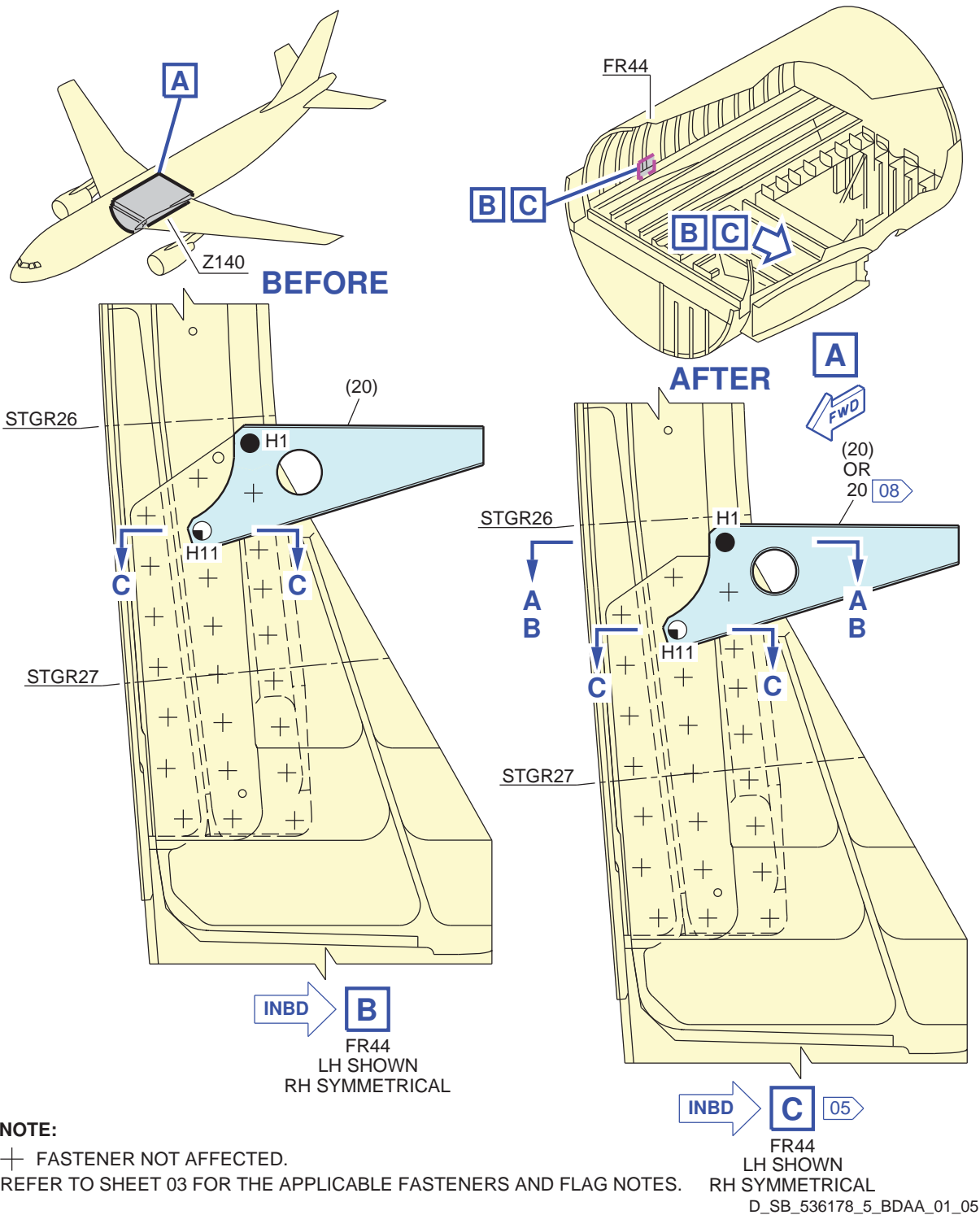
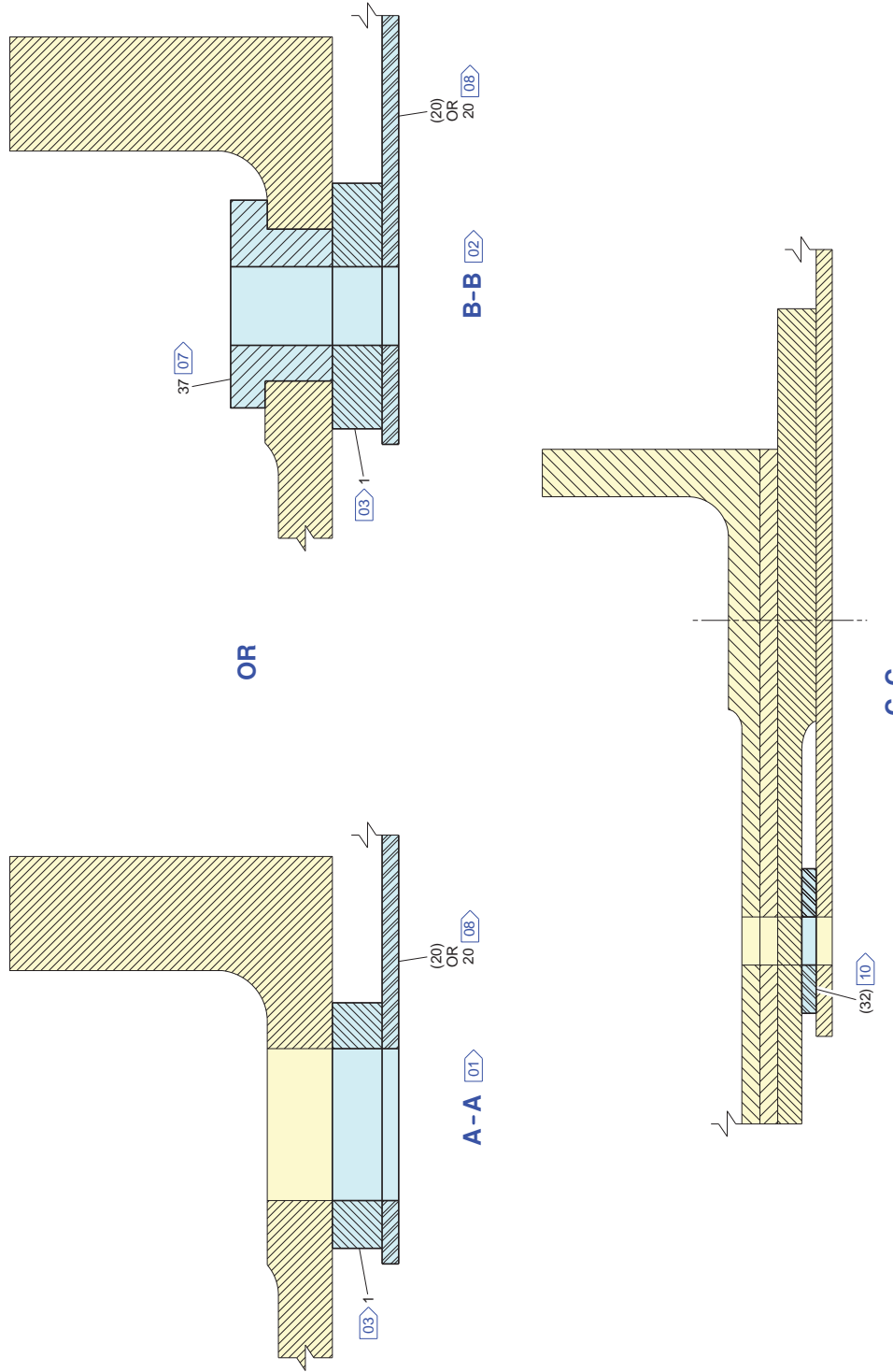


Figure A-FBDAA - Sheet 01
Replacement of the Fastener on the Hole H1 of Frame 44

**CONF 001, 003



NOTE:
REFER TO SHEET 03 FOR THE APPLICABLE FLAG NOTES.

Figure A-FBDAA - Sheet 02
Replacement of the Fastener on the Hole H1 of Frame 44

**CONF 001, 003

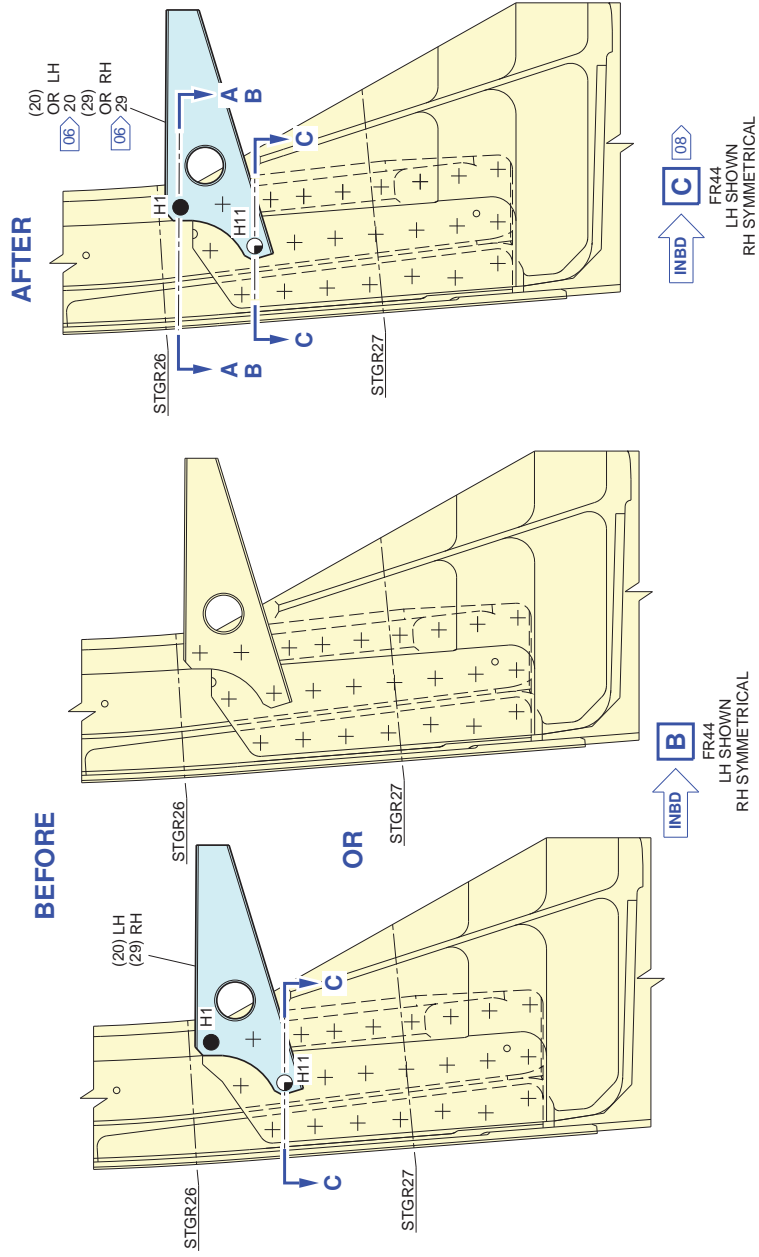
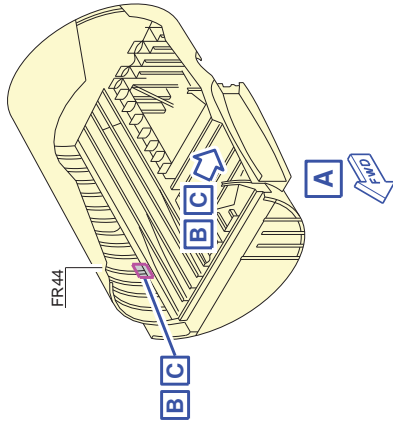
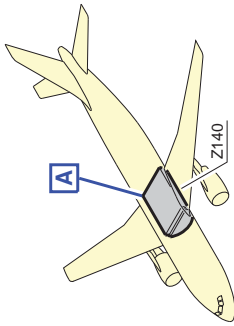
HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE	
					MIN	MAX			
●	(3)	22	EN6115K6-9	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 06 09	
	(4)	4	ASNA2529-6	NUT					
	OR								
	(3)	23	EN6115K5Y10	BOLT	8.642 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 06 09	
(4)	6	ASNA2529-5	NUT						
		7	NSA5368-516B	WASHER					
OR									
●	(3)	24	EN6115K5X9	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 06 09	
	(4)	6	ASNA2529-5	NUT					
	OR								
	(3)	25	EN6115K5-9	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 06 09	
(4)	6	ASNA2529-5	NUT						
OR									
◐	(3)	21	EN6115K4-11	BOLT	6.310 mm (0.2485 in)	6.350 mm (0.2500 in)	FASTENERS IN TRANSITION FIT	02 04 06 07	
	(4)	11	ASNA2529-4	NUT					
	(30)	30	ASNA2027V4-8	BOLT					
	(31)	31	NSA5075-8	NUT					

NOTE:

- 01 VALID ONLY IF THE HOLE DIAMETER IS LESS THAN OR EQUAL TO 9.418 mm (0.3708 in).
- 02 VALID IF THE HOLE DIAMETER IS MORE THAN 9.418 mm (0.3708 in).
- 03 COUNTERDRILL THE SHIM ITEM 1 TO THE FASTENER DIAMETER TO BE INSTALLED.
- 04 OVERSIZE THE HOLE BETWEEN 11 mm (0.4331 in) AND 11.018 mm (0.4337 in) BEFORE THE INSTALLATION OF THE BUSH ITEM 37.
- 05 PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JME4.
- 06 IF SPOTFACING NECESSARY CONTACT AIRBUS.
- 07 VALID ONLY IF THE BUSH IS INSTALLED.
- 08 IF THE HOLES OF THE BRACKET, ITEM (20), IS MORE THAN 6.35 mm (0.250 in), INSTALL A NEW BRACKET ITEM 20.
- 09 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).
- 10 INSTALL THE SHIM ITEM (32) WITH MATERIAL No 13FB82.

Figure A-FBDA - Sheet 03
Replacement of the Fastener on the Hole H1 of Frame 44

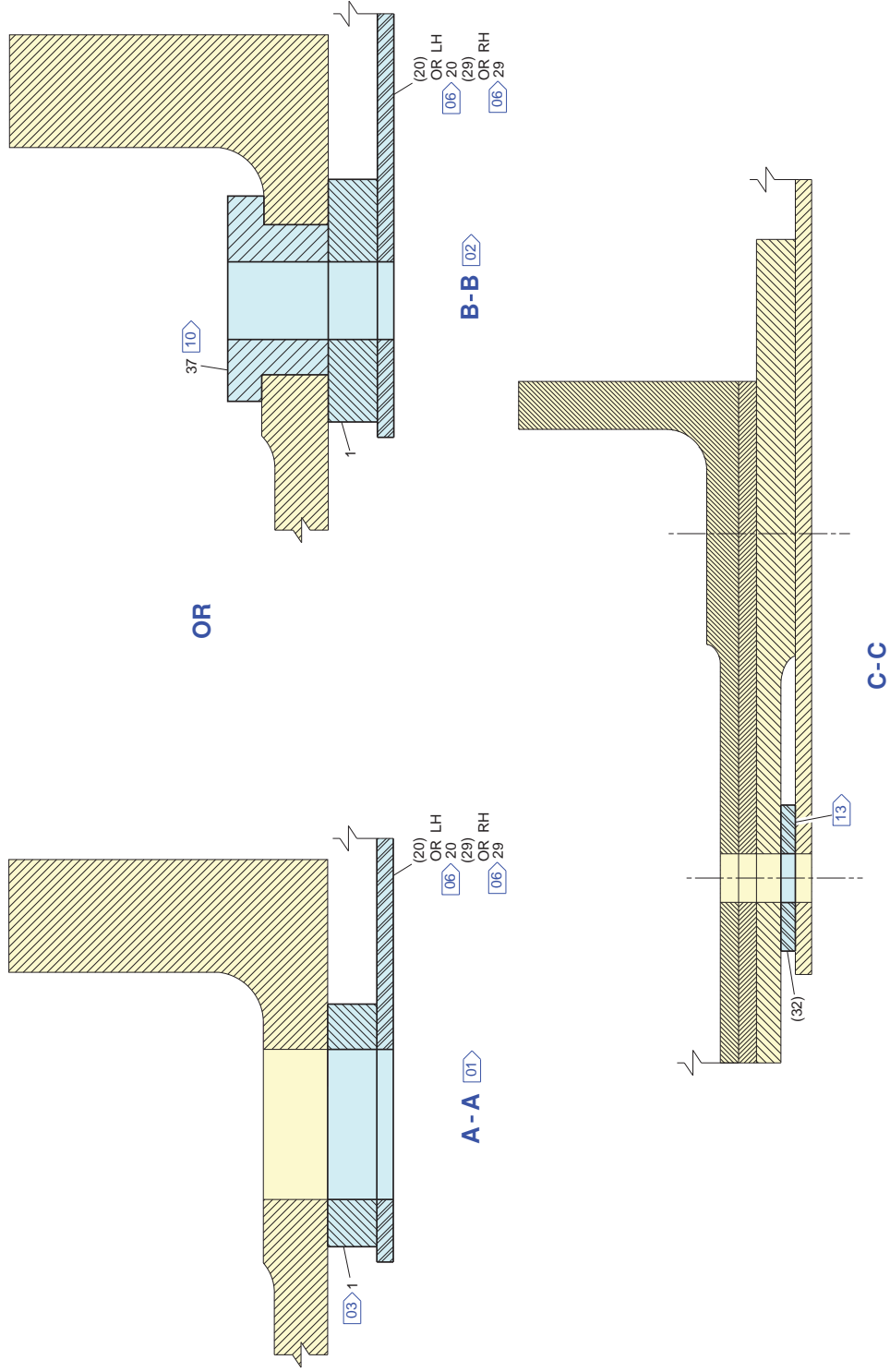
**CONF 002, 004



NOTE:
+ FASTENERS NOT AFFECTED.
REFER TO SHEET 03 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

Figure A-FBDAB - Sheet 01
Replacement of the Fastener on the Hole H1 of Frame 44

**CONF 002, 004



NOTE:
REFER TO SHEET 03 FOR THE APPLICABLE FLAG NOTES.

Figure A-FBDAB - Sheet 02
Replacement of the Fastener on the Hole H1 of Frame 44

**CONF 002, 004

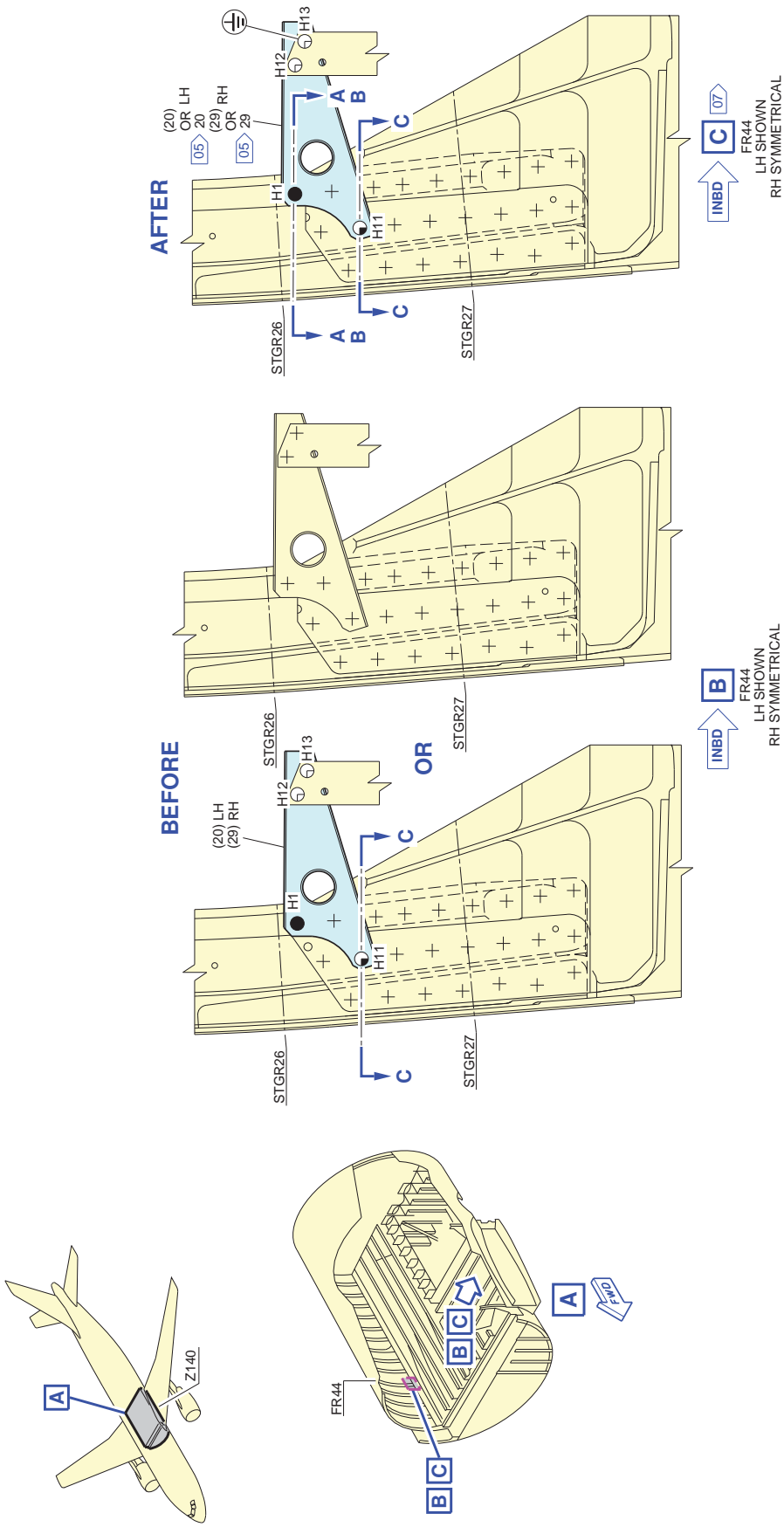
HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
●	(3)	22	EN6115K6-9	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	05 07 09 11
	(4)	4	ASNA2529-6	NUT				
	(3)	23	EN6115K5Y10	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	05 07 09 11
	(4)	6	ASNA2529-5	NUT				
◐	(3)	21	EN6115K4-11	BOLT	6.310 mm (0.2485 in)	6.350 mm (0.2500 in)	FASTENERS IN TRANSITION FIT	04 05 09 12
	(4)	11	ASNA2529-4	NUT				
	(30)	30	ASNA2027V4-8	BOLT				
	(31)	31	NSA5075-8	NUT				

NOTE:

- 01 VALID ONLY IF THE HOLE DIAMETER IS LESS THAN OR EQUAL TO 9.418 mm (0.3708 in).
- 02 VALID IF THE HOLE DIAMETER IS MORE THAN 9.418 mm (0.3708 in).
- 03 OVERSIZE THE HOLE BETWEEN 11 mm (0.4331 in) AND 11.018 mm (0.4337 in) BEFORE THE INSTALLATION OF THE BUSH ITEM 37.
- 04 COUNTERDRILL THE SHIM ITEM 1 TO THE FASTENER DIAMETER TO BE INSTALLED.
- 05 IF FRAME FOOT IS ALREADY CUT, DO NOT REMOVE. IF FRAME FOOT IS NOT CUT AND BUSH ALREADY INSTALLED, CONTACT AIRBUS.
- 06 IF THE HOLE OF THE BRACKET ITEM (20) OR ITEM (29) IS MORE THAN 6.35 mm (0.250 in), INSTALL A NEW BRACKET ITEM 20 OR ITEM 29.
- 07 FASTENERS TO BE REPLACED IF SUPPORT ITEM (20) OR ITEM (29) HAS TO BE REPLACED/REMOVED.
- 08 PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JME4.
- 09 IF SPOTFACING NECESSARY CONTACT AIRBUS.
- 10 BEFORE THE INSTALLATION OF THE BUSH ITEM 37 PROTECT THE HOLE INNER FACE WITH MATERIAL No 06ABC1.
- 11 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).
- 12 VALID ONLY IF THE BUSH IS INSTALLED.
- 13 INSTALL THE SHIM ITEM (32) WITH MATERIAL No 13FBB2.

Figure A-FBDAB - Sheet 03
Replacement of the Fastener on the Hole H1 of Frame 44

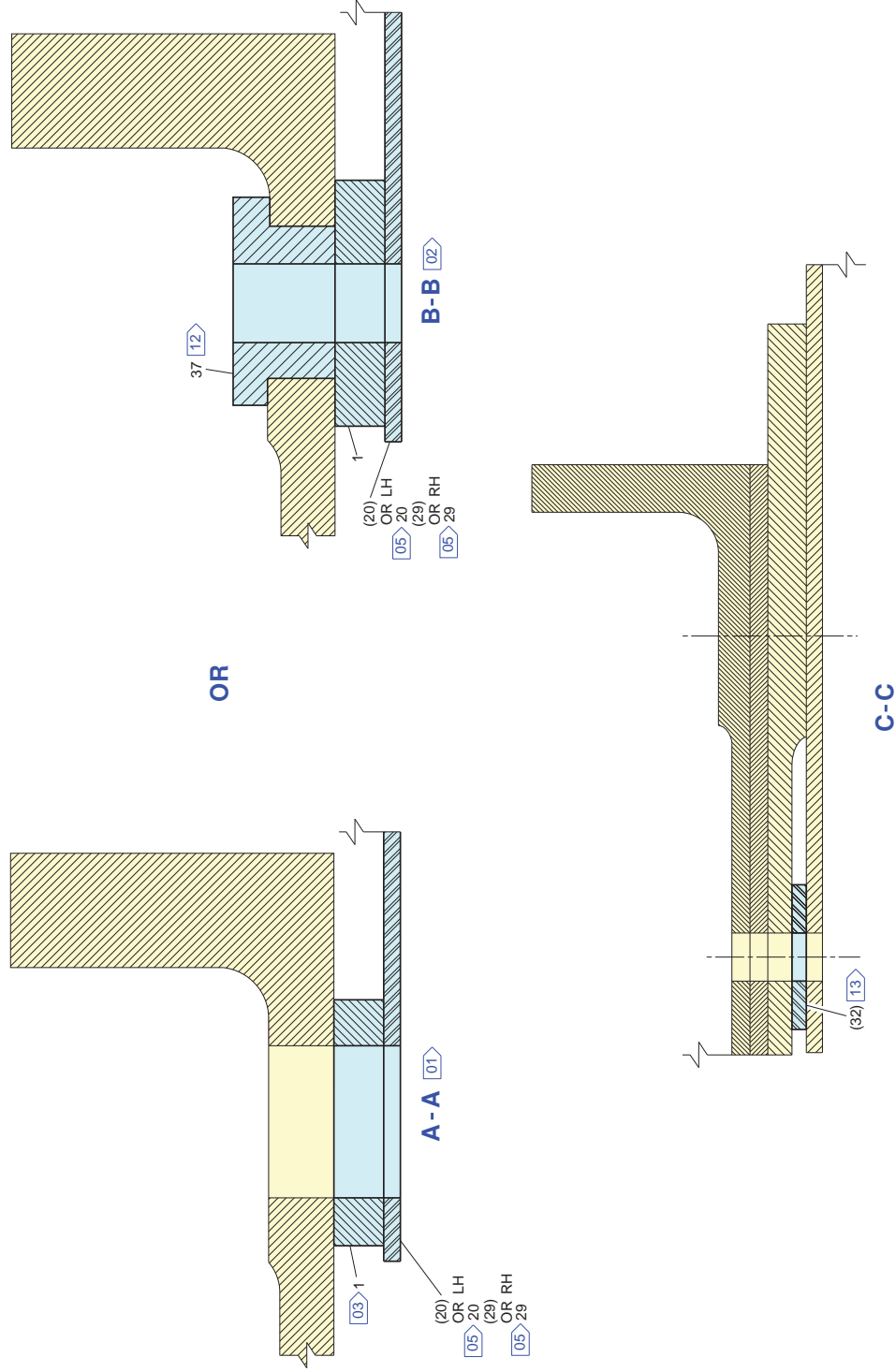
**CONF 005



D_SB_536778_5_BDAC_01_04

Figure A-FBDAC - Sheet 01
Replacement of the Fastener on the Hole H1 of Frame 44

**CONF 005



NOTE:
REFER TO SHEET 03 FOR THE APPLICABLE FLAG NOTES.

D_SB_536178_5_BDAC_02_04

Figure A-FBDAC - Sheet 02
Replacement of the Fastener on the Hole H1 of Frame 44

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5 DATE: Mar 17/15

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**CONF 005

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
●	(3)	22	EN6115K6-9	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	[01] [06] [08]
	(4)	4	ASNA2529-6	NUT				[10] [11]
	(3)	23	EN6115K5Y10	BOLT			FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	[01] [06] [08]
	(4)	6	ASNA2529-5	NUT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)		[10] [11]
◐	(3)	21	EN6115K4-11	BOLT	6.310 mm (0.2485 in)	6.350 mm (0.2500 in)	FASTENERS IN TRANSITION FIT	[02] [04] [06]
	(4)	11	ASNA2529-4	NUT				[08] [11] [09]
	(30)	30	ASNA2027V4-8	BOLT				
	(31)	31	NSA5075-8	NUT				
	(35)	35	ASNA2050DCJ3215	RIVET				[06]

NOTE:

- [01] VALID ONLY IF THE HOLE DIAMETER IS LESS THAN OR EQUAL TO 9.418 mm (0.3708 in).
- [02] VALID IF THE HOLE DIAMETER IS MORE THAN 9.418 mm (0.3708 in).
- [03] OVERSIZE THE HOLE BETWEEN 11 mm (0.4331 in) AND 11.018 mm (0.4337 in) BEFORE THE INSTALLATION OF THE BUSH ITEM 37.
- [04] COUNTERDRILL THE SHIM ITEM 1 TO THE FASTENER DIAMETER TO BE INSTALLED.
- [05] IF THE HOLE OF THE BRACKET ITEM (20) OR ITEM (29) IS MORE THAN 6.35 mm (0.250 in), INSTALL A NEW BRACKET ITEM 20 OR ITEM 29.
- [06] FASTENERS TO BE REPLACED ONLY IF SUPPORT ITEM (20) OR ITEM (29) HAS TO BE REPLACED/REMOVED.
- [07] PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JME4.
- [08] IF SPOTFACING NECESSARY CONTACT AIRBUS.
- [09] VALID ONLY IF THE BUSH IS INSTALLED.
- [10] OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).
- [11] IF FRAME FOOT IS ALREADY CUT, DO NOT REMOVE. IF FRAME FOOT IS NOT CUT AND BUSH ALREADY INSTALLED, CONTACT AIRBUS.
- [12] BEFORE THE INSTALLATION OF THE BUSH ITEM 37, PROTECT THE HOLE INNER FACE WITH MATERIAL No 06ABC1.
- [13] INSTALL THE SHIM ITEM (32) WITH MATERIAL No 13FBB2.

Figure A-FBDAC - Sheet 03
Replacement of the Fastener on the Hole H1 of Frame 44

**CONF 001, 003

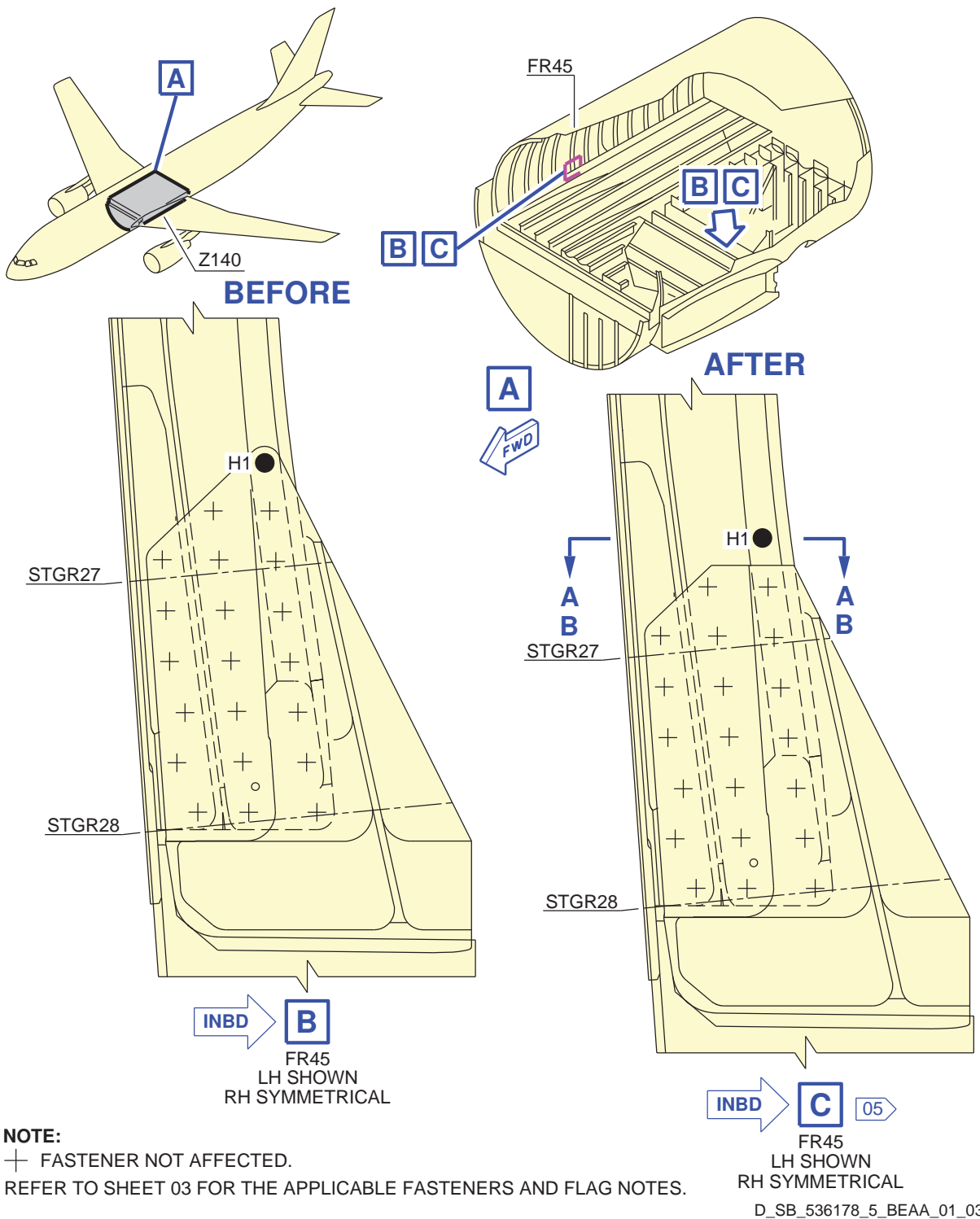
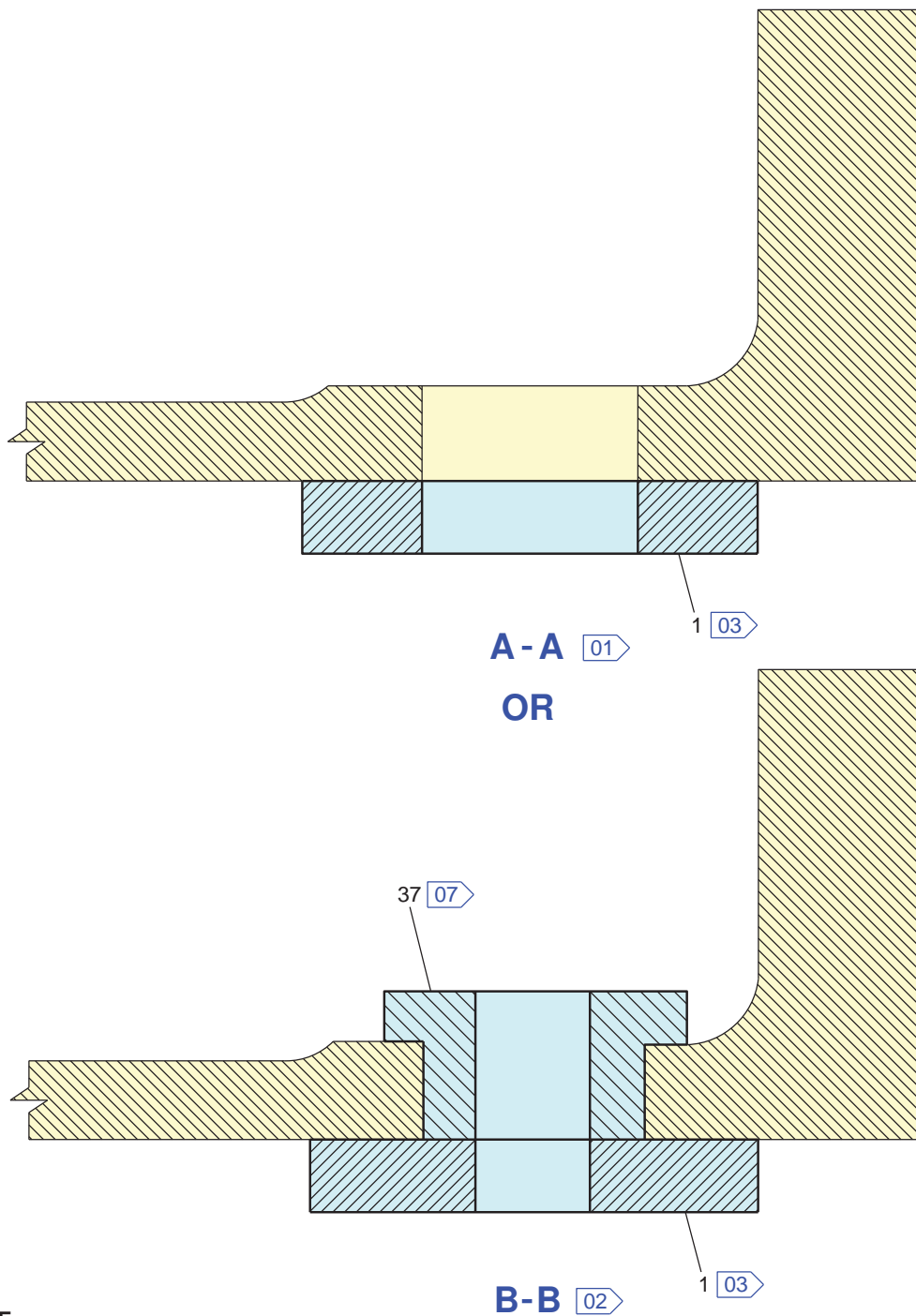


Figure A-FBEAA - Sheet 01
 Replacement of the Fastener on the Hole H1 of Frame 45

**CONF 001, 003



NOTE:
REFER TO SHEET 03 FOR THE APPLICABLE FLAG NOTES.

D_SB_536178_5_BEAA_02_05

Figure A-FBEAA - Sheet 02
Replacement of the Fastener on the Hole H1 of Frame 45

**CONF 001, 003

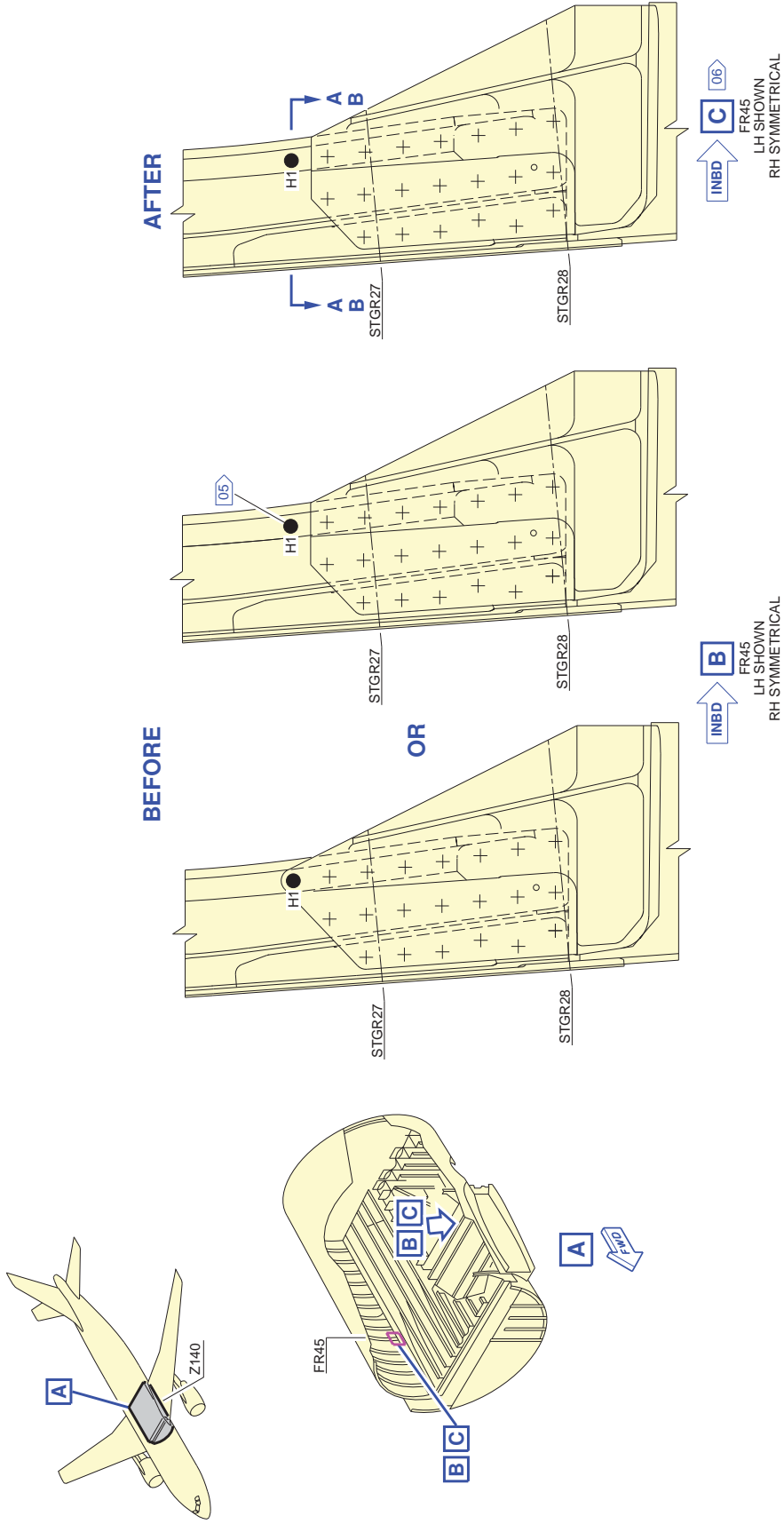
HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
	(3)	26	EN6115K6-8	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 06 08
	(4)	4	ASNA2529-6	NUT	OR			
	(3)	27	EN6115K5Y9	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 06 08
	(4)	6	ASNA2529-5	NUT	OR			
	(3)	7	NSA5368-516B	WASHER	OR		FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 06 08
	(4)	6	ASNA2529-5	NUT	OR			
	(3)	19	EN6115K5-8	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 06 08
	(4)	6	ASNA2529-5	NUT	OR			
	(3)	38	EN6115K4-9	BOLT	6.310 mm (0.2485 in)	6.350 mm (0.2500 in)	FASTENERS IN TRANSITION FIT	02 04 06
	(4)	11	ASNA2529-4	NUT	OR			

NOTE:

- 01 - VALID ONLY IF THE HOLE DIAMETER IS LESS THAN OR EQUAL TO 9.418 mm (0.3708 in).
- 02 - VALID IF THE HOLE DIAMETER IS MORE THAN 9.418 mm (0.3708 in).
- 03 - COUNTERDRILL THE SHIM ITEM 1 TO THE FASTENER DIAMETER TO BE INSTALLED.
- 04 - OVERSIZE THE HOLE BETWEEN 11 mm (0.4331 in) AND 11.018 mm (0.4337 in) BEFORE THE INSTALLATION OF THE BUSH ITEM 37.
- 05 - PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JIME4.
- 06 - IF SPOTFACING NECESSARY CONTACT AIRBUS.
- 07 - BEFORE THE INSTALLATION OF THE BUSH ITEM 37, PROTECT THE HOLE INNER FACE WITH MATERIAL No 06ABC1.
- 08 - OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).

Figure A-FBEAA - Sheet 03
Replacement of the Fastener on the Hole H1 of Frame 45

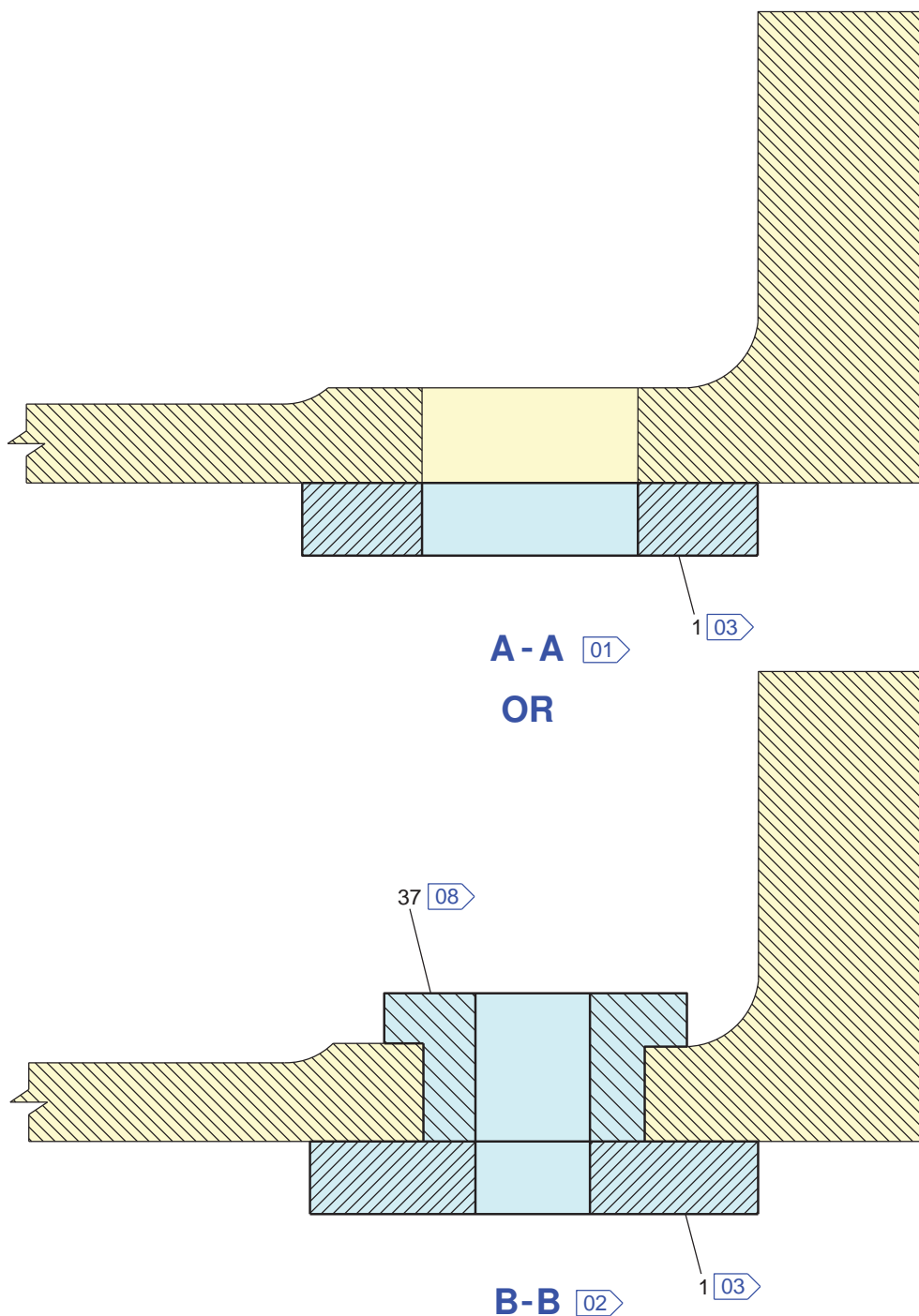
**CONF 002, 004 thru 005



NOTE:
 + FASTENER NOT AFFECTED.
 REFER TO SHEET 03 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

Figure A-FBEAB - Sheet 01
 Replacement of the Fastener on the Hole H1 of Frame 45

****CONF 002, 004 thru 005**



NOTE:
REFER TO SHEET 03 FOR THE APPLICABLE FLAG NOTES.

D_SB_536178_5_BEAB_02_05

Figure A-FBEAB - Sheet 02
Replacement of the Fastener on the Hole H1 of Frame 45

**CONF 002, 004 thru 005

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
●	(3)	26	EN6115K6-8	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 07 09
	(4)	4	ASNA2529-6	NUT	OR			
	(3)	27	EN6115K5Y9	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 07 09
	(4)	6	ASNA2529-5	NUT	OR			
		7	NSA5368-516B	WASHER	OR		FASTENERS IN TRANSITION FIT	02 04 07
	(3)	10	EN6115K4-8	BOLT	6.310 mm (0.2485 in)	6.350 mm (0.2500 in)		
	(4)	11	ASNA2529-4	NUT				

NOTE:

- 01 - VALID ONLY IF THE HOLE DIAMETER IS LESS THAN OR EQUAL TO 9.418 mm (0.3708 in).
- 02 - VALID IF THE HOLE DIAMETER IS MORE THAN 9.418 mm (0.3708 in).
- 03 - COUNTERDRILL THE SHIM ITEM 1 TO THE FASTENER DIAMETER TO BE INSTALLED.
- 04 - OVERSIZE THE HOLE BETWEEN 11 mm (0.4331 in) AND 11.018 mm (0.4337 in) BEFORE THE INSTALLATION OF THE BUSH ITEM 37.
- 05 - IF THE FRAME FOOT IS ALREADY CUT, DO NOT REMOVE THE FASTENER.
- 06 - PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JIME4.
- 07 - IF SPOTFACING NECESSARY CONTACT AIRBUS.
- 08 - BEFORE THE INSTALLATION OF THE BUSH ITEM 37, PROTECT THE HOLE INNER FACE WITH MATERIAL No 06ABC1.
- 09 - OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).

Figure A-FBEAB - Sheet 03
Replacement of the Fastener on the Hole H1 of Frame 45

**CONF 001, 003

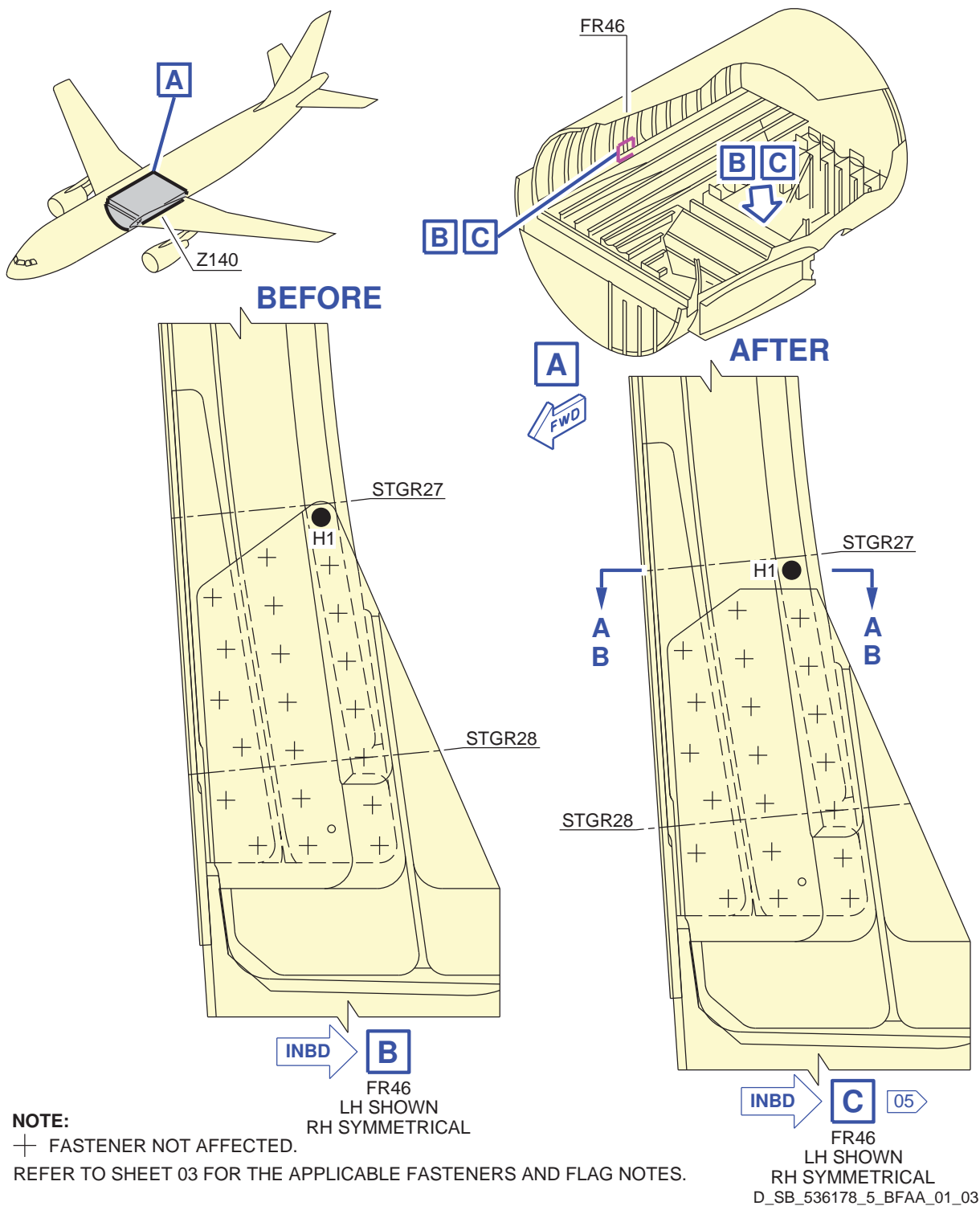
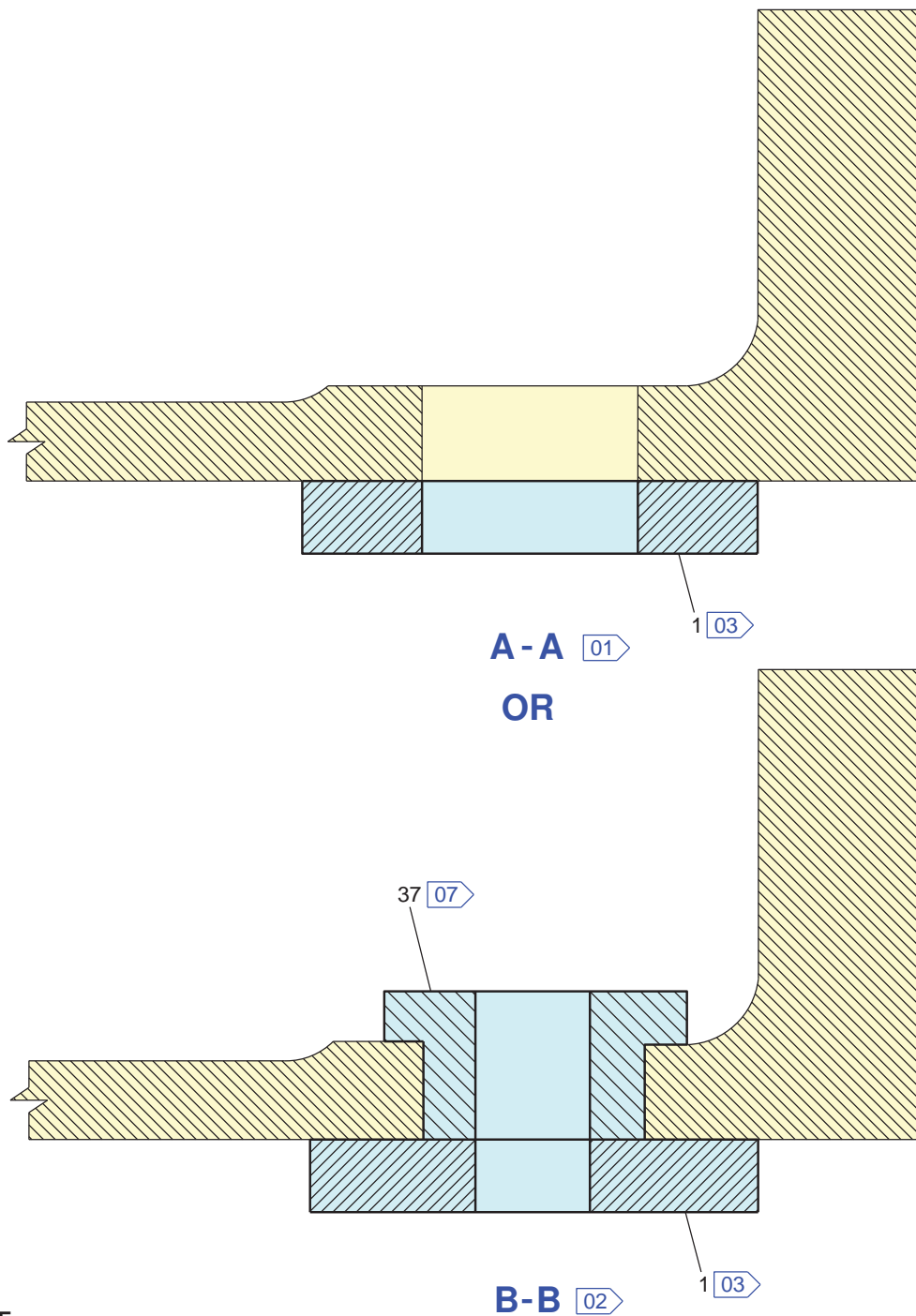


Figure A-FBFAA - Sheet 01
 Replacement of the Fastener on the Hole H1 of Frame 46

**CONF 001, 003



NOTE:
REFER TO SHEET 03 FOR THE APPLICABLE FLAG NOTES.

D_SB_536178_5_BFAA_02_05

Figure A-FBFAA - Sheet 02
Replacement of the Fastener on the Hole H1 of Frame 46

**CONF 001, 003

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
●	(3)	26	EN6115K6-8	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 06 08 06
	(4)	4	ASNA2529-6	NUT				
	(3)	27	EN6115K5Y9	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 06 08 06
	(4)	6	ASNA2529-5	NUT				
		7	NSA5368-516B	WASHER				
	(3)	28	EN6115K5X8	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 06 08 06
	(4)	6	ASNA2529-5	NUT				
	(3)	19	EN6115K5-8	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 06 08 08
	(4)	6	ASNA2529-5	NUT				
	(3)	38	EN6115K4-9	BOLT	6.310 mm (0.2485 in)	6.350 mm (0.2500 in)	FASTENERS IN TRANSITION FIT	02 04 06 06
	(4)	11	ASNA2529-4	NUT				

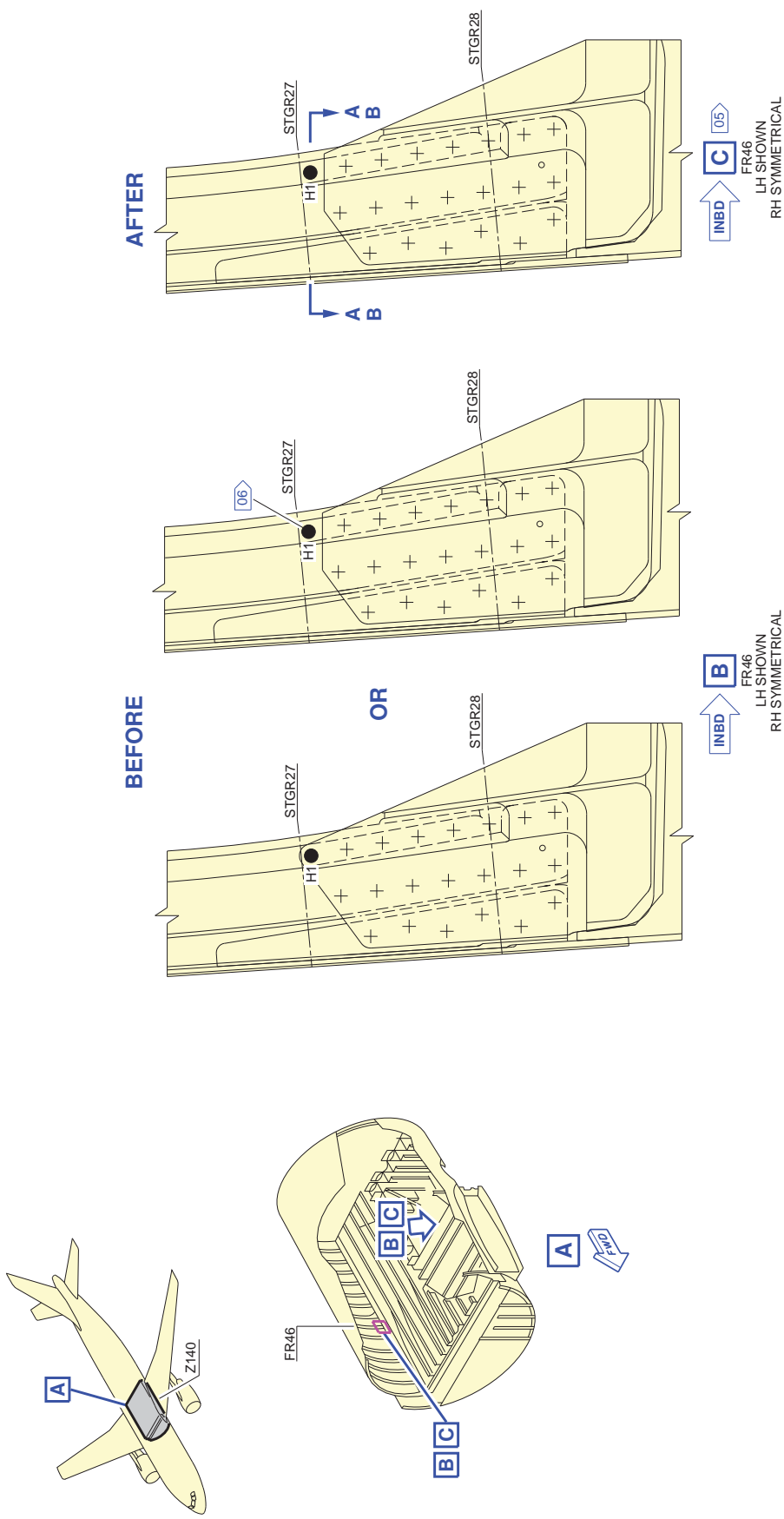
NOTE:

- 01 VALID ONLY IF THE HOLE DIAMETER IS LESS THAN OR EQUAL TO 9.418 mm (0.3708 in).
- 02 VALID IF THE HOLE DIAMETER IS MORE THAN 9.418 mm (0.3708 in).
- 03 COUNTERDRILL THE SHIM ITEM 1 TO THE FASTENER DIAMETER TO BE INSTALLED.
- 04 OVERSIZE THE HOLE BETWEEN 11 mm (0.4331 in) AND 11.018 mm (0.4337 in) BEFORE THE INSTALLATION OF THE BUSH ITEM 37.
- 05 PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JIME4.
- 06 IF SPOTFACING NECESSARY CONTACT AIRBUS.
- 07 BEFORE THE INSTALLATION OF THE BUSH ITEM 37, PROTECT THE HOLE INNER FACE WITH MATERIAL No 06ABC1.
- 08 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).

Figure A-FBFAA - Sheet 03

Replacement of the Fastener on the Hole H1 of Frame 46

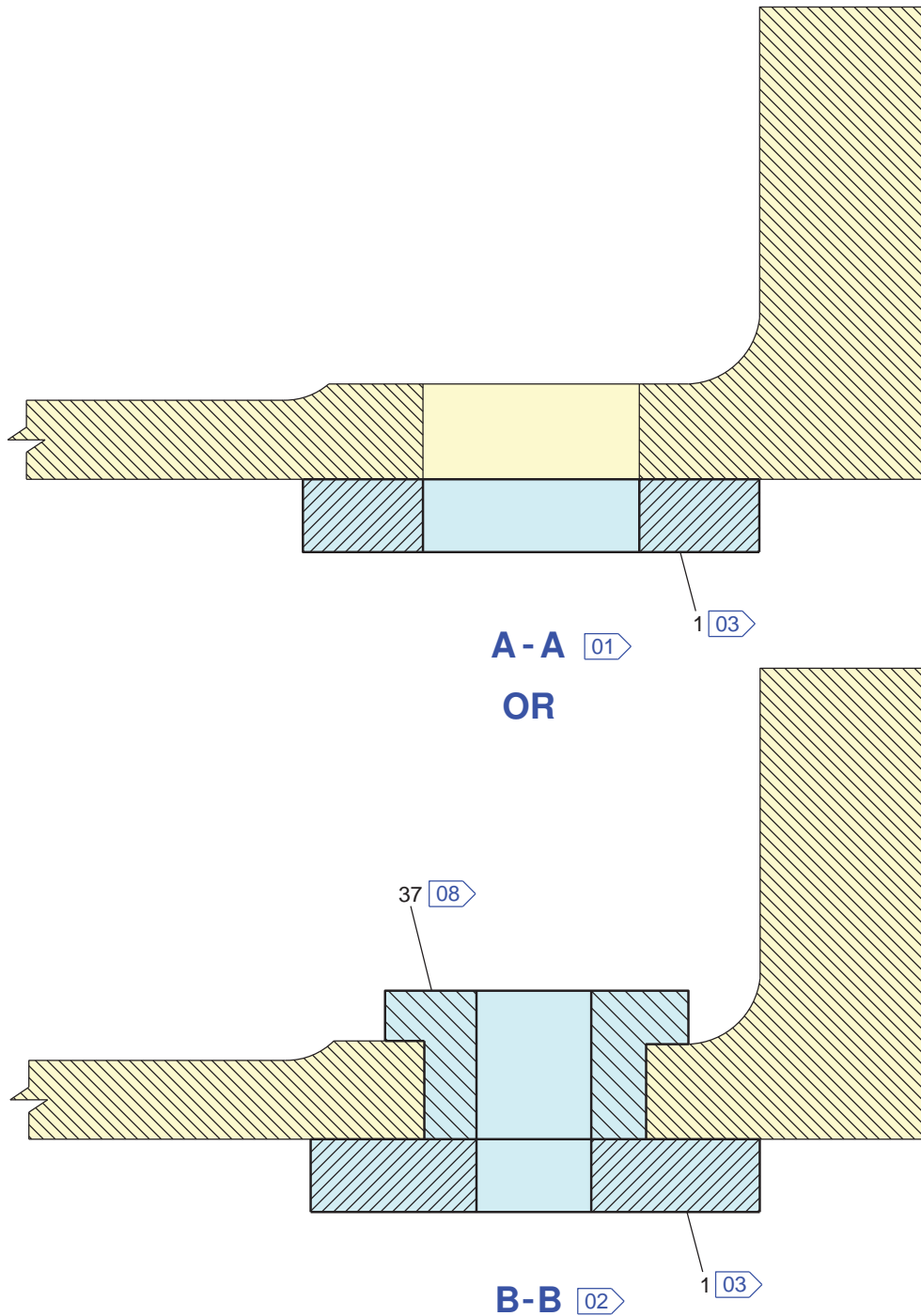
**CONF 002, 004 thru 005



NOTE:
+ FASTENER NOT AFFECTED.
REFER TO SHEET 03 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

Figure A-FFBAB - Sheet 01
Replacement of the Fastener on the Hole H1 of Frame 46

**CONF 002, 004 thru 005



NOTE:
REFER TO SHEET 03 FOR THE APPLICABLE FLAG NOTES.

D_SB_536178_5_BFAB_02_05

Figure A-FBFAB - Sheet 02
Replacement of the Fastener on the Hole H1 of Frame 46

**CONF 002, 004 thru 005

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
●	(3)	26	EN6115K6-8	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 07 09
	(4)	4	ASNA2529-6	NUT	OR			
	(3)	27	EN6115K5Y9	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 07 09
	(4)	6	ASNA2529-5	NUT	OR			
		7	NSA5368-516B	WASHER	OR			
	(3)	10	EN6115K4-8	BOLT	6.310 mm (0.2486 in)	6.350 mm (0.2500 in)	FASTENERS IN TRANSITION FIT	02 04 07
	(4)	11	ASNA2529-4	NUT	OR			

NOTE:

- 01 VALID ONLY IF THE HOLE DIAMETER IS LESS THAN OR EQUAL TO 9.418 mm (0.3708 in).
- 02 VALID IF THE HOLE DIAMETER IS MORE THAN 9.418 mm (0.3708 in).
- 03 COUNTERDRILL THE SHIM ITEM 1 TO THE FASTENER DIAMETER TO BE INSTALLED.
- 04 OVERSIZE THE HOLE BETWEEN 11 mm (0.4331 in) AND 11.018 mm (0.4337 in) BEFORE THE INSTALLATION OF THE BUSH ITEM 37.
- 05 PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JIME4.
- 06 IF THE FRAME FOOT IS ALREADY CUT, DO NOT REMOVE THE FASTENER.
- 07 IF SPOTFACING NECESSARY CONTACT AIRBUS.
- 08 BEFORE THE INSTALLATION OF THE BUSH ITEM 37, PROTECT THE HOLE INNER FACE WITH MATERIAL No 06ABC1.
- 09 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).

Figure A-FFBAB - Sheet 03
Replacement of the Fastener on the Hole H1 of Frame 46

**CONF 001, 003

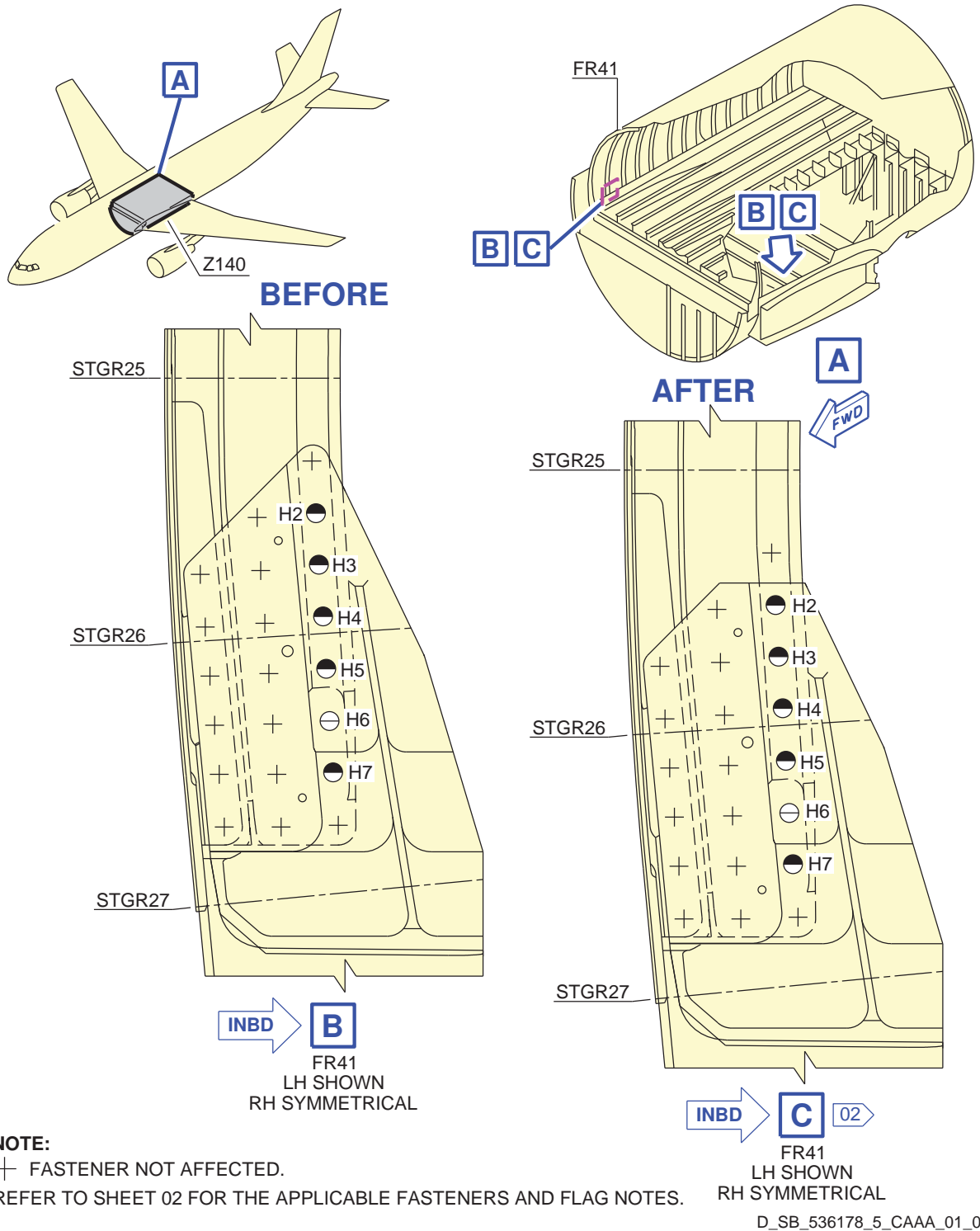


Figure A-FCAAA - Sheet 01
 Replacement of the Fastener on Holes H2 to H7 of Frame 41

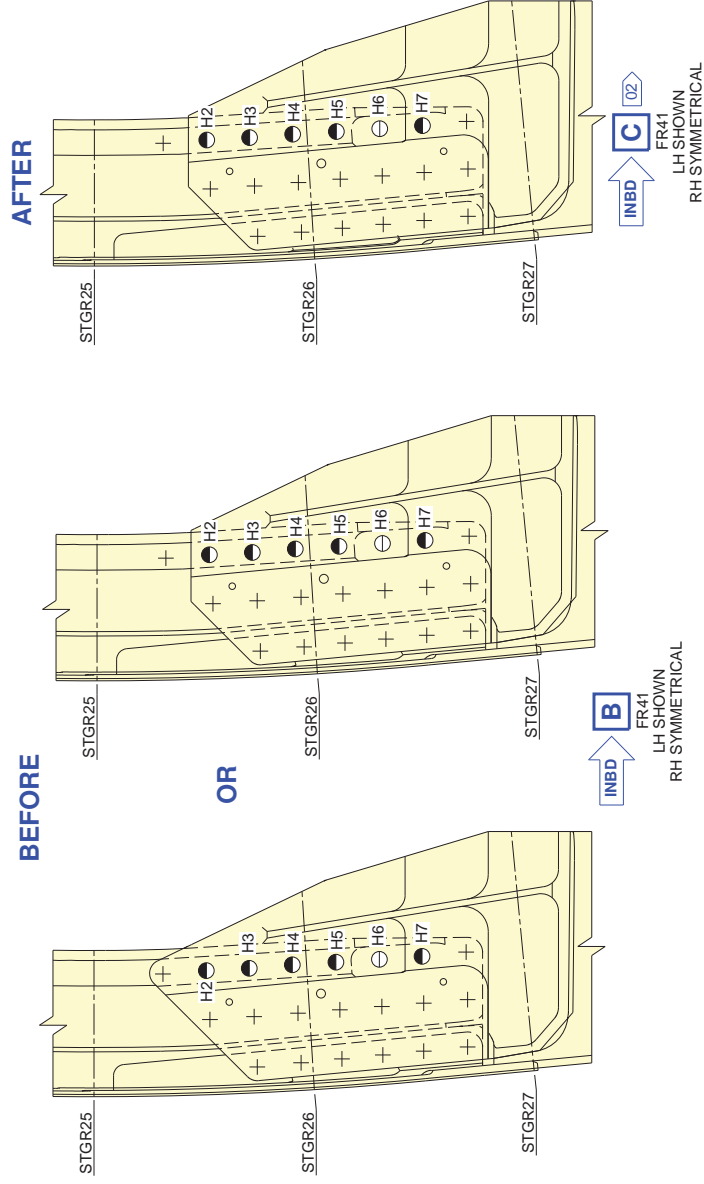
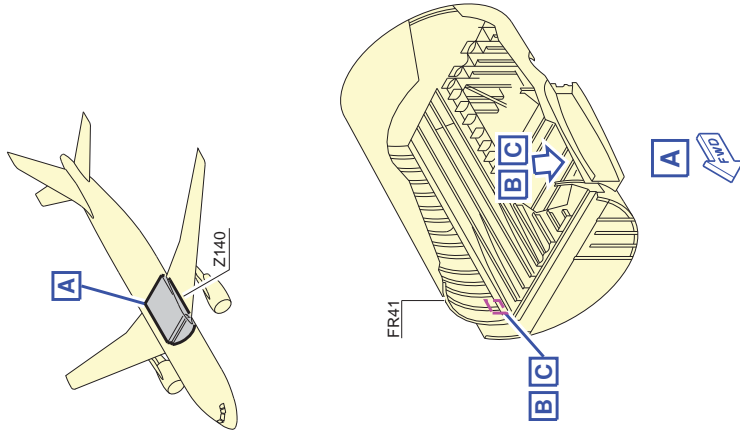
**CONF 001, 003

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
○	(3)	3	EN6115K6-7	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 03
	(4)	4	ASNA2529-6	NUT	OR			
○	(3)	5	EN6115K5Y8	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(4)	6	ASNA2529-5	NUT	OR			
○	(3)	7	NSA5368-516B	WASHER	OR		FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03
	(4)	6	ASNA2529-5	NUT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)		
○	(3)	9	EN6115K5-7	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 03
	(4)	6	ASNA2529-5	NUT	OR			
○	(3)	43	EN6115K6Y8	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(4)	4	ASNA2529-6	NUT	OR			
○	(3)	46	NSA5368-616B	WASHER	OR		FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03
	(4)	4	ASNA2529-6	NUT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)		
○	(3)	12	EN6115K6-6	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 03
	(4)	4	ASNA2529-6	NUT	OR			
○	(3)	13	EN6115K5Y7	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(4)	6	ASNA2529-5	NUT	OR			
○	(3)	7	NSA5368-516B	WASHER	OR		FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03
	(4)	6	ASNA2529-5	NUT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)		
○	(3)	14	EN6115K5X6	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 03
	(4)	6	ASNA2529-5	NUT	OR			
○	(3)	15	EN6115K5-6	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(4)	6	ASNA2529-5	NUT	OR			
○	(3)	42	EN6115K6Y7	BOLT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03
	(4)	4	ASNA2529-6	NUT	OR			
○	(3)	46	NSA5368-616B	WASHER	OR		FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(4)	4	ASNA2529-6	NUT	7.849 mm (0.3090 in)	7.889 mm (0.3113 in)		
○	(3)	38	EN6115K6X6	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03
	(4)	4	ASNA2529-6	NUT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)		

NOTE:
 01 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in)
 (MAXIMUM DIAMETER 10.218 mm (0.4023 in)).
 02 PROTECT WITH PRIMER MATERIAL No 04EACz AND APPLY FINISH MATERIAL No 04JME4.
 03 IF SPOTFACING NECESSARY CONTACT AIRBUS.

Figure A-FCAAA - Sheet 02
 Replacement of the Fastener on Holes H2 to H7 of Frame 41

**CONF 002, 004 thru 005



NOTE:
+ FASTENER NOT AFFECTED.
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

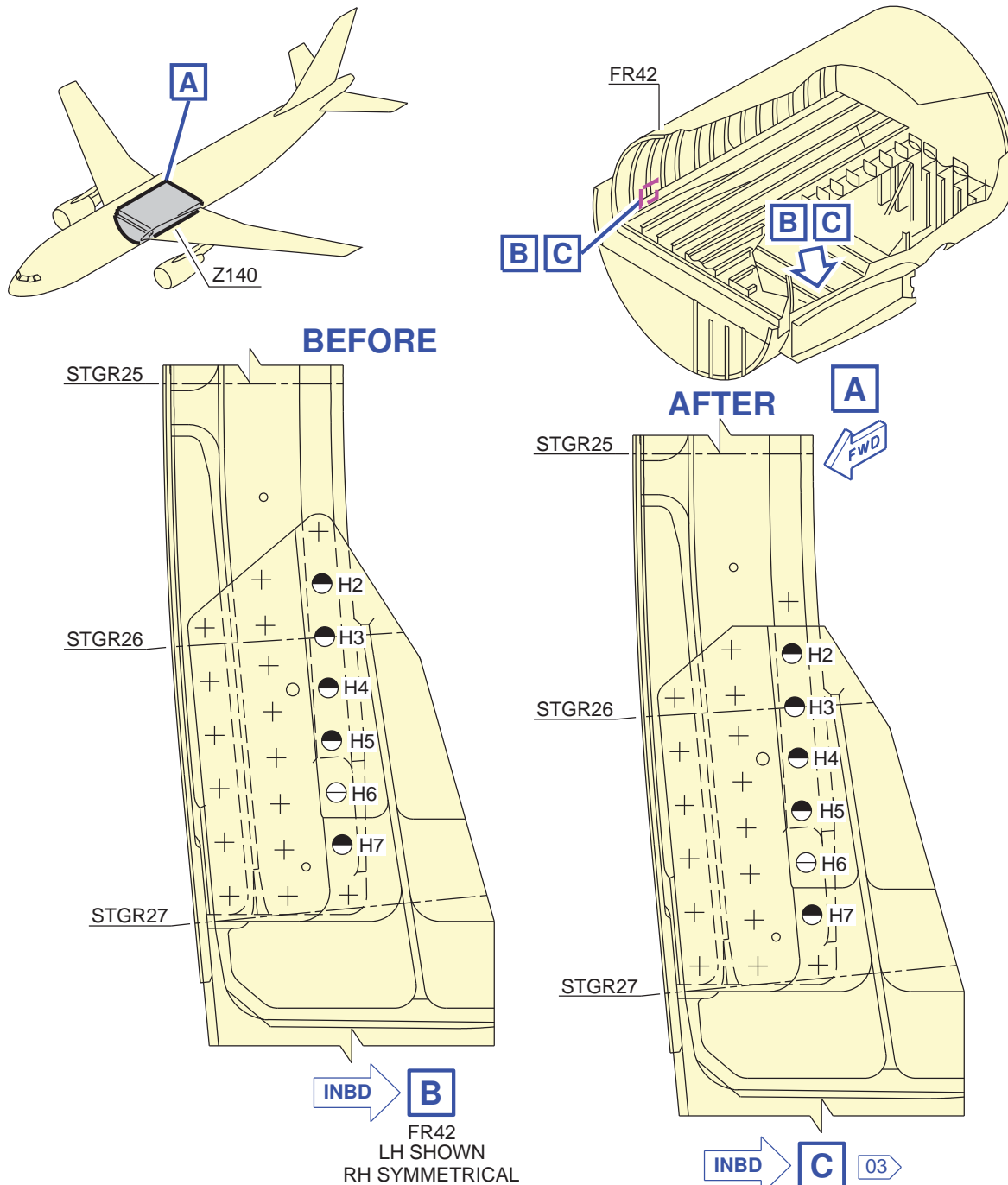
Figure A- FCAAB - Sheet 01
Replacement of the Fastener on Holes H2 to H7 of Frame 41

**CONF 002, 004 thru 005

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
⊕	(3)	43	EN6115K6Y8	BOLT	10.219 mm	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03	
	(4)	4	ASNA2529-6	NUT	(0.4007 in)			
	(4)	46	NSA5368-616B	WASHER	(0.4023 in)			
⊕	(3)	39	EN6115K6X7	BOLT	9.823 mm	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03	
	(4)	4	ASNA2529-6	NUT	(0.3852 in)			
					OR			
					9.823 mm			
					(0.3867 in)			
					OR			
⊕	(3)	3	EN6115K6-7	BOLT	9.427 mm	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 03	
	(4)	4	ASNA2529-6	NUT	(0.3696 in)			
					OR			
					9.427 mm			
					(0.3711 in)			
					OR			
⊕	(3)	5	EN6115K5Y8	BOLT	8.602 mm	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03	
	(4)	6	ASNA2529-5	NUT	(0.3387 in)			
					OR			
					8.642 mm			
					(0.3402 in)			
					OR			
					8.602 mm			
⊕	(3)	42	EN6115K6Y7	BOLT	10.219 mm	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03	
	(4)	4	ASNA2529-6	NUT	(0.4007 in)			
					OR			
					9.823 mm			
					(0.3852 in)			
					OR			
					9.823 mm			
⊕	(3)	12	EN6115K6-6	BOLT	9.427 mm	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 03	
	(4)	4	ASNA2529-6	NUT	(0.3696 in)			
					OR			
					9.427 mm			
⊕	(3)	13	EN6115K5Y7	BOLT	8.602 mm	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03	
	(4)	6	ASNA2529-5	NUT	(0.3387 in)			
					OR			
					8.642 mm			
				(0.3402 in)				

NOTE:
 01 > OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 10.218 mm (0.4023 in)).
 02 > PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JME4.
 03 > IF SPOTFACING NECESSARY CONTACT AIRBUS.

**CONF 001, 003



NOTE:

+ FASTENER NOT AFFECTED.

REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

RH SYMMETRICAL

D_SB_536178_5_CBAA_01_00

Figure A-FCBAA - Sheet 01
Replacement of the Fastener on Holes H2 to H7 of Frame 42

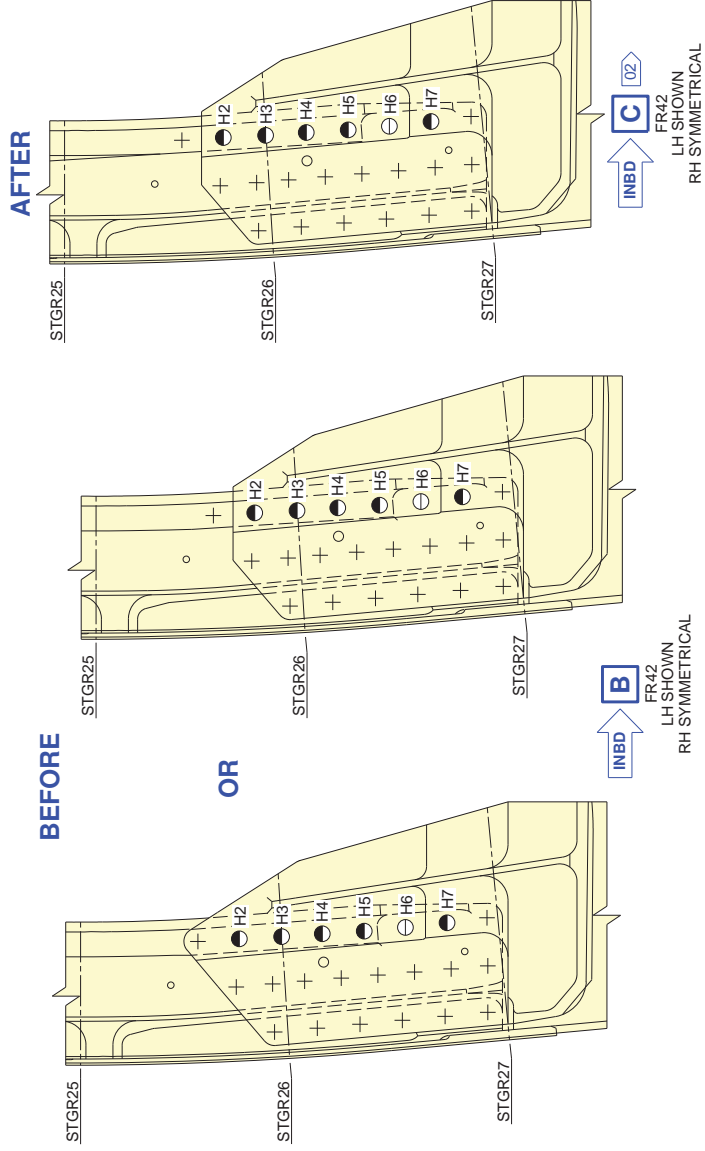
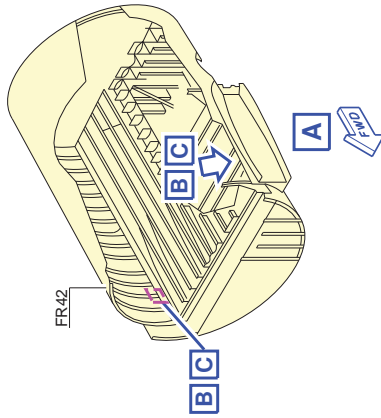
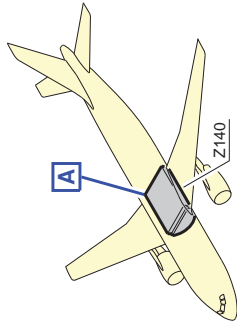
**CONF 001, 003

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
⊕	(3)	43	EN6115K6Y8	BOLT	10.177 mm	10.219 mm	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 02
	(4)	4	ASNA2529-6	NUT	(0.4007 in)	(0.4023 in)		
		46	NSA5368-616B	WASHER				
⊖	(3)	39	EN6115K6X7	BOLT	9.784 mm	9.823 mm	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 02
	(4)	4	ASNA2529-6	NUT	(0.3852 in)	(0.3867 in)		
							OR	
	(3)	3	EN6115K6-7	BOLT	9.387 mm	9.427 mm	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 02
	(4)	4	ASNA2529-6	NUT	(0.3696 in)	(0.3711 in)		
							OR	
	(3)	5	EN6115K5Y8	BOLT	8.602 mm	8.642 mm	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 02
	(4)	6	ASNA2529-5	NUT	(0.3387 in)	(0.3402 in)		
		7	NSA5368-516B	WASHER				
							OR	
	(3)	8	EN6115K5X7	BOLT	8.206 mm	8.246 mm	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 02
	(4)	6	ASNA2529-5	NUT	(0.3231 in)	(0.3246 in)		
							OR	
	(3)	9	EN6115K5-7	BOLT	7.809 mm	7.849 mm	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 02
(4)	6	ASNA2529-5	NUT	(0.3075 in)	(0.3090 in)			
(3)	42	EN6115K6Y7	BOLT	10.177 mm	10.219 mm	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 02	
(4)	4	ASNA2529-6	NUT	(0.4007 in)	(0.4023 in)			
	46	NSA5368-616B	WASHER					
						OR		
(3)	38	EN6115K6X6	BOLT	9.784 mm	9.823 mm	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 02	
(4)	4	ASNA2529-6	NUT	(0.3852 in)	(0.3867 in)			
						OR		
(3)	12	EN6115K6-6	BOLT	9.387 mm	9.427 mm	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 02	
(4)	4	ASNA2529-6	NUT	(0.3696 in)	(0.3711 in)			
						OR		
(3)	13	EN6115K5Y7	BOLT	8.602 mm	8.642 mm	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 02	
(4)	6	ASNA2529-5	NUT	(0.3387 in)	(0.3402 in)			
	7	NSA5368-516B	WASHER					
						OR		
(3)	14	EN6115K5X6	BOLT	8.206 mm	8.246 mm	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 02	
(4)	6	ASNA2529-5	NUT	(0.3231 in)	(0.3246 in)			
						OR		
(3)	15	EN6115K5-6	BOLT	7.809 mm	7.849 mm	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 02	
(4)	6	ASNA2529-5	NUT	(0.3075 in)	(0.3090 in)			

NOTE:
 01 > OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in)
 (MAXIMUM DIAMETER 10.218 mm (0.4023 in)).
 02 > IF SPOTFACING NECESSARY CONTACT AIRBUS.
 03 > PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JME4.

Figure A-FCBAA - Sheet 02
 Replacement of the Fastener on Holes H2 to H7 of Frame 42
 SERVICE BULLETIN No.: A300-53-6178
 DATE: Mar 17/15
 REVISION No.: 01 - Sep 20/19

**CONF 002, 004 thru 005



NOTE:
+ FASTENER NOT AFFECTED.
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

Figure A-FCBAB - Sheet 01
Replacement of the Fastener on Holes H2 to H7 of Frame 42

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**CONF 002, 004 thru 005

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE	
					MIN	MAX			
⊖	(3)	43	EN6115K6Y8	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03	
	(4)	4	ASNA2529-6	NUT					
		46	NSA5368-616B	WASHER					
		(3)	39	EN6115K6X7	BOLT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03
	(4)	4	ASNA2529-6	NUT					
		(3)	3	EN6115K6-7	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 03
(4)	4	ASNA2529-6	NUT						
⊖	(3)	5	EN6115K5Y8	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03	
	(4)	6	ASNA2529-5	NUT					
		7	NSA5368-516B	WASHER					
		(3)	42	EN6115K6Y7	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(4)	4	ASNA2529-6	NUT					
		46	NSA5368-616B	WASHER					
		(3)	38	EN6115K6X6	BOLT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03
	(4)	4	ASNA2529-6	NUT					
		(3)	12	EN6115K6-6	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 03
	(4)	4	ASNA2529-6	NUT					
		(3)	13	EN6115K5Y7	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(4)	6	ASNA2529-5	NUT					
		7	NSA5368-516B	WASHER					

NOTE:
 01 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 10.218 mm (0.4023 in)).
 02 PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JME4.
 03 IF SPOTFACING NECESSARY CONTACT AIRBUS.

Figure A-FCBAB - Sheet 02
Replacement of the Fastener on Holes H2 to H7 of Frame 42

**CONF 001, 003

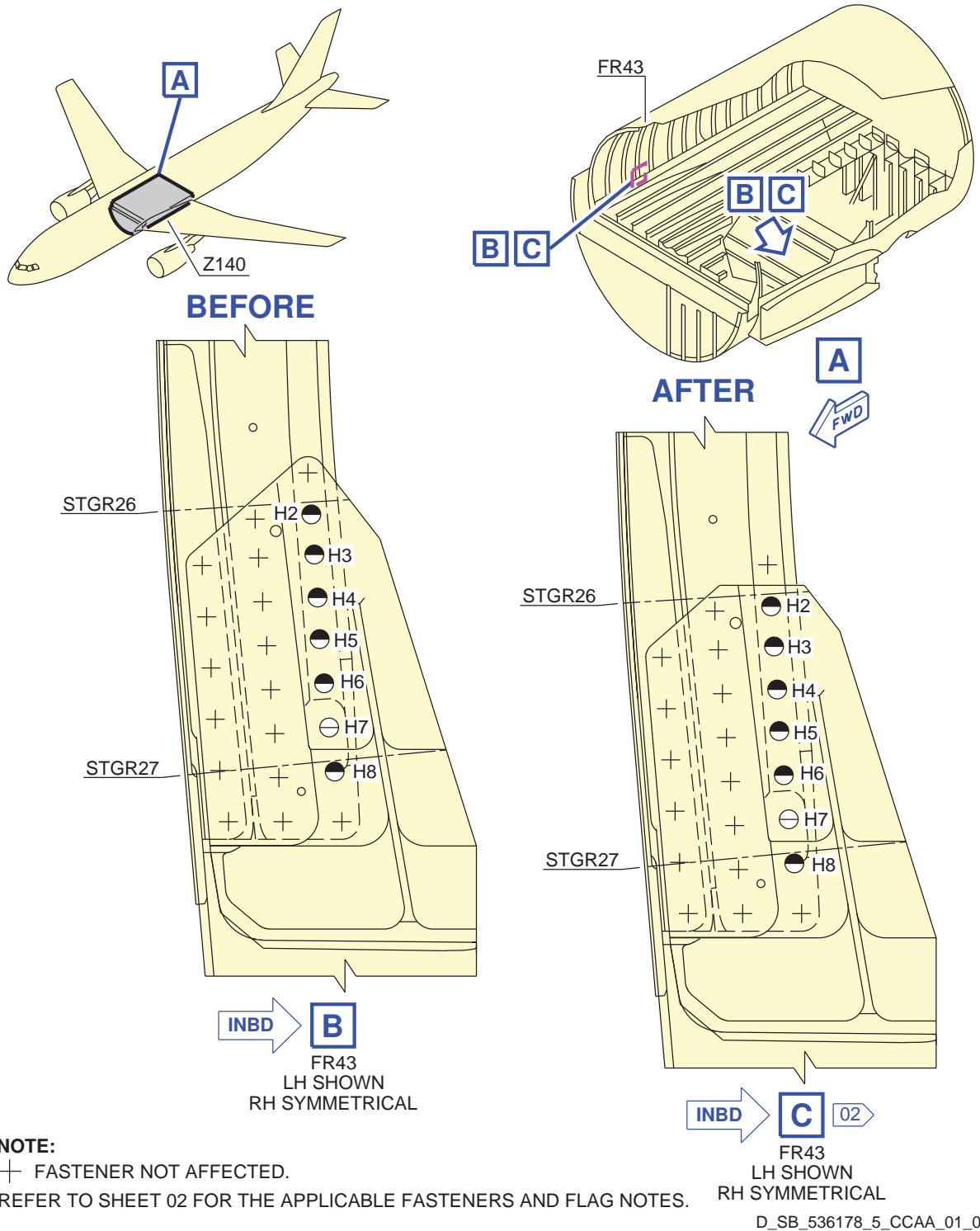


Figure A-FCCAA - Sheet 01
Replacement of the Fastener on Holes H2 to H8 of Frame 43

**CONF 001, 003

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
⊖	(3)	3	EN6115K6-7	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 03
	(4)	4	ASNA2529-6	NUT	OR			
	(3)	5	EN6115K5Y8	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(4)	6	ASNA2529-5	NUT	OR			
	(4)	7	NSA5368-516B	WASHER	OR			
	(3)	8	EN6115K5X7	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03
	(4)	6	ASNA2529-5	NUT	OR			
	(3)	9	EN6115K5-7	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 03
	(4)	6	ASNA2529-5	NUT	OR			
	(3)	43	EN6115K6Y8	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(4)	4	ASNA2529-6	NUT	OR			
	(4)	46	NSA5368-616B	WASHER	OR			
(3)	39	EN6115K6X7	BOLT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03	
(4)	4	ASNA2529-6	NUT	OR				
(3)	12	EN6115K6-6	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 03	
(4)	4	ASNA2529-6	NUT	OR				
(3)	13	EN6115K5Y7	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03	
(4)	6	ASNA2529-5	NUT	OR				
(4)	7	NSA5368-516B	WASHER	OR				
(3)	14	EN6115K5X6	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03	
(4)	6	ASNA2529-5	NUT	OR				
(3)	15	EN6115K5-6	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 03	
(4)	6	ASNA2529-5	NUT	OR				
(3)	42	EN6115K6Y7	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03	
(4)	4	ASNA2529-6	NUT	OR				
(4)	46	NSA5368-616B	WASHER	OR				
(3)	38	EN6115K6X6	BOLT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03	
(4)	4	ASNA2529-6	NUT	OR				

NOTE:

01 > OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 10.218 mm (0.4023 in)).

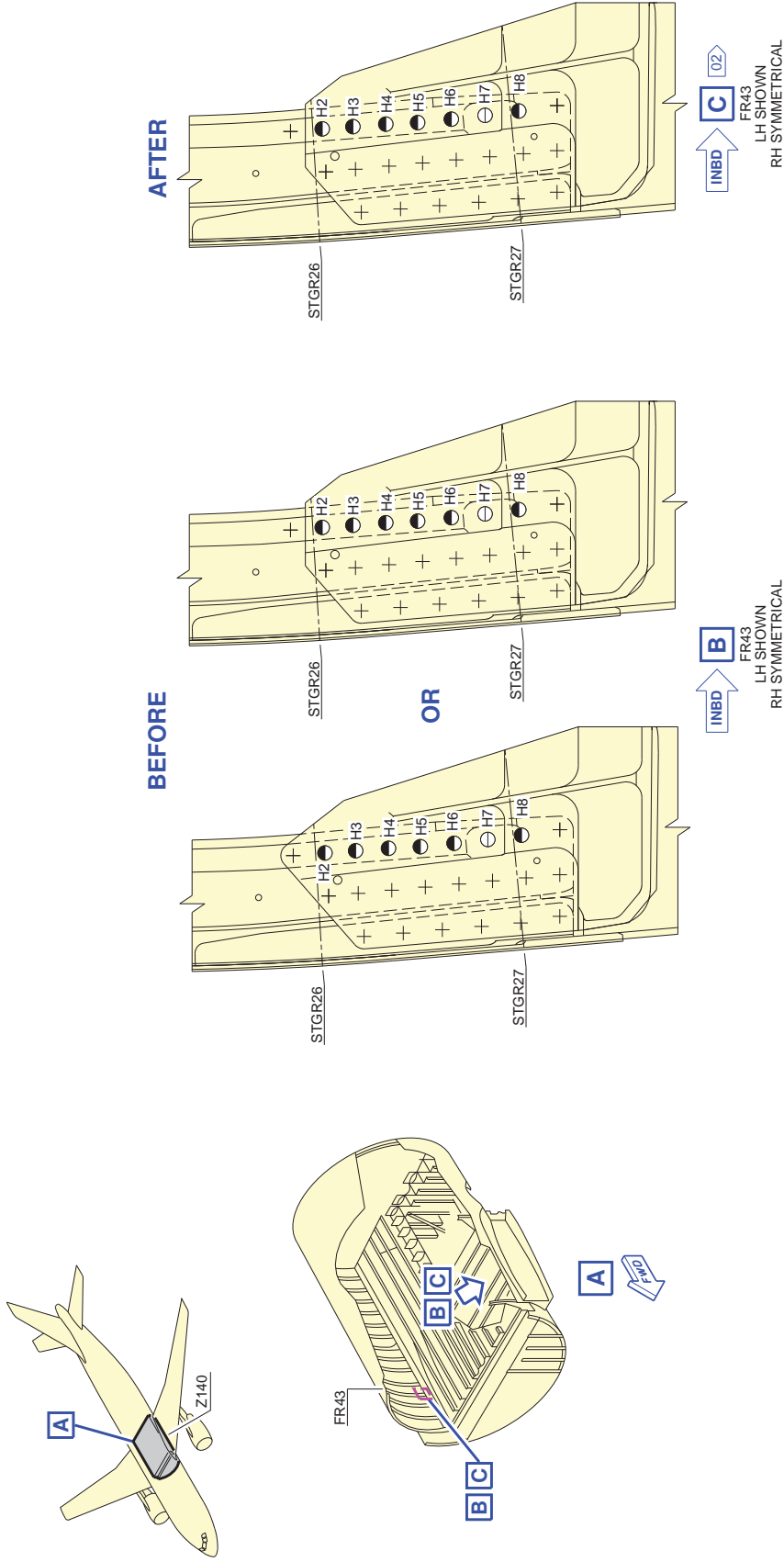
02 > PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JME4.

03 > IF SPOTFACING NECESSARY CONTACT AIRBUS.

D_SB_536776_5_CCAA_02_00

Figure A-FCCAA - Sheet 02
Replacement of the Fastener on Holes H2 to H8 of Frame 43

**CONF 002, 004 thru 005



NOTE:
+ FASTENER NOT AFFECTED.
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

Figure A-FCCAB - Sheet 01
Replacement of the Fastener on Holes H2 to H8 of Frame 43

**CONF 002, 004 thru 005

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
⊖	(3)	3	EN6115K6-7	BOLT	9.427 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 03
	(4)	4	ASNA2529-6	NUT	OR			
	(3)	5	EN6115K5Y8	BOLT	8.642 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(4)	6	ASNA2529-5	NUT	OR			
	(4)	7	NSA5368-516B	WASHER	OR			
	(3)	43	EN6115K6Y8	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(4)	4	ASNA2529-6	NUT	OR			
	(4)	46	NSA5368-616B	WASHER	OR			
	(3)	39	EN6115K6X7	BOLT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03
	(4)	4	ASNA2529-6	NUT	OR			
	(3)	12	EN6115K6-6	BOLT	9.427 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 03
	(4)	4	ASNA2529-6	NUT	OR			
(3)	13	EN6115K5Y7	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03	
(4)	6	ASNA2529-5	NUT	OR				
(4)	7	NSA5368-516B	WASHER	OR				
(3)	43	EN6115K6Y7	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03	
(4)	4	ASNA2529-6	NUT	OR				
(4)	46	NSA5368-616B	WASHER	OR				
(3)	38	EN6115K6X6	BOLT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03	
(4)	4	ASNA2529-6	NUT	OR				

NOTE:
 01 > OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 10.218 mm (0.4023 in)).
 02 > PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JME4.
 03 > IF SPOTFACING NECESSARY CONTACT AIRBUS.

Figure A-FCCAB - Sheet 02
 Replacement of the Fastener on Holes H2 to H8 of Frame 43

**CONF 001, 003

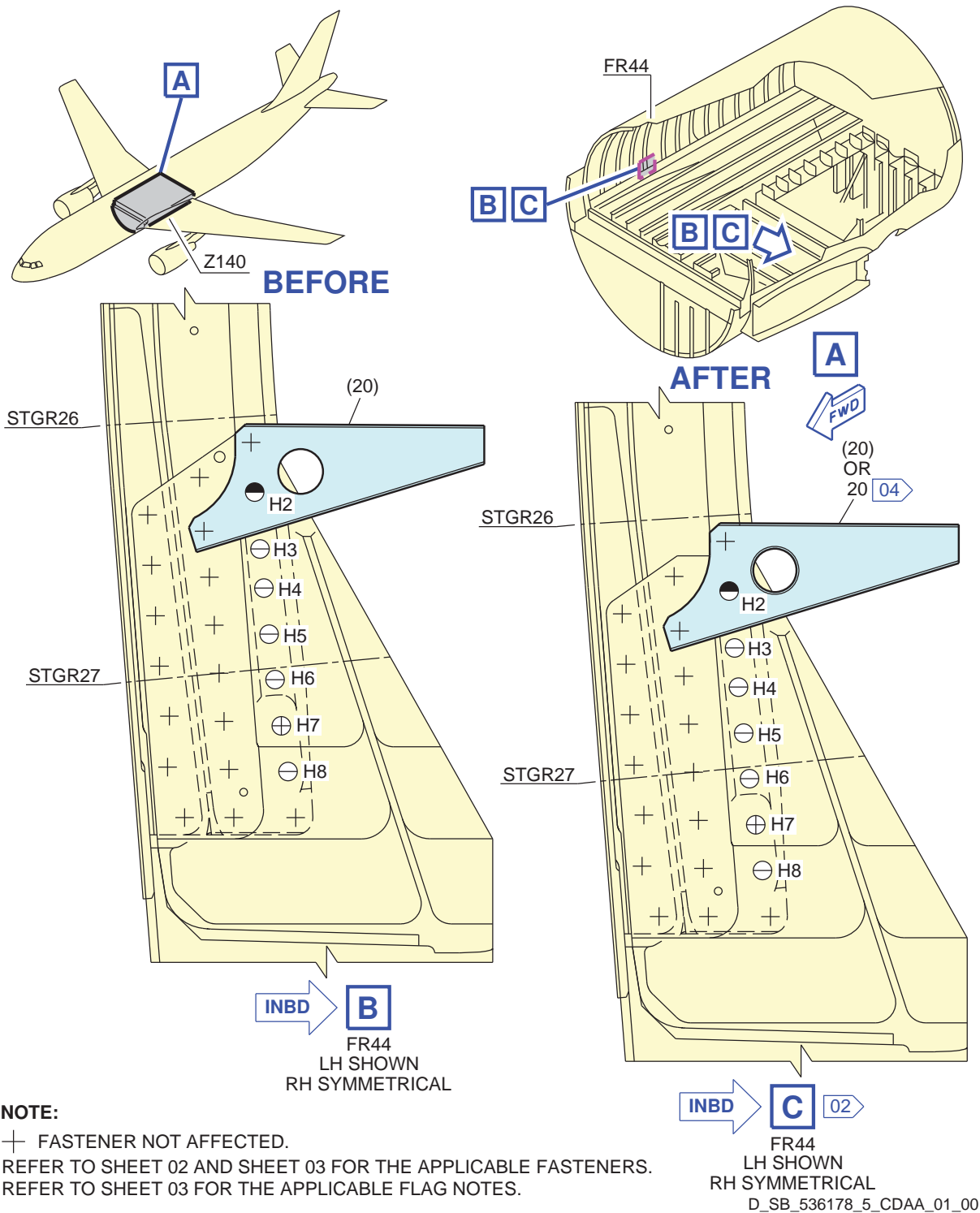


Figure A-FCDA - Sheet 01
 Replacement of the Fastener on Holes H2 to H8 of Frame 44

**CONF 001, 003

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
⊖	(3)	22	EN6115K6-9	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 03
	(4)	4	ASNA2529-6	NUT	OR			
	(3)	27	EN6115K5Y9	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(4)	6	ASNA2529-5	NUT	OR			
	(4)	7	NSA5368-516B	WASHER	OR		FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03
	(3)	24	EN6115K5X9	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)		
	(4)	6	ASNA2529-5	NUT	OR		FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 03
	(3)	25	EN6115K5-9	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)		
	(4)	6	ASNA2529-5	NUT	OR		FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(3)	45	EN6115K6Y10	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)		
	(4)	4	ASNA2529-6	NUT	OR		FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03
	(4)	46	NSA5368-616B	WASHER	OR			
(3)	41	EN6115K6X9	BOLT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03	
(4)	4	ASNA2529-6	NUT	OR				FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE
(3)	26	EN6115K6-8	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 03	
(4)	4	ASNA2529-6	NUT	OR				FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE
(3)	27	EN6115K5Y9	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03	
(4)	6	ASNA2529-5	NUT	OR				FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER
(4)	7	NSA5368-516B	WASHER	OR		FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03	
(3)	28	EN6115K5X8	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)			FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE
(4)	6	ASNA2529-5	NUT	OR		FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 03	
(3)	19	EN6115K5-8	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)			FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE
(4)	6	ASNA2529-5	NUT	OR		FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03	
(3)	44	EN6115K6Y9	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)			FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE
(4)	4	ASNA2529-6	NUT	OR		FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03	
(4)	46	NSA5368-616B	WASHER	OR				FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER
(3)	40	EN6115K6X8	BOLT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03	
(4)	4	ASNA2529-6	NUT	OR				FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE

NOTE:
REFER TO SHEET 03 FOR THE APPLICABLE FLAG NOTES.

D_SB_536776_5_CDA002_00

Figure A-FCDA002 - Sheet 02
Replacement of the Fastener on Holes H2 to H8 of Frame 44

**CONF 001, 003

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
	(3)	3	EN6115K6-7	BOLT	9.387 mm	9.427 mm	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 03
	(4)	4	ASNA2529-6	NUT	(0.3696 in)	(0.3711 in)		
	(3)	5	EN6115K5Y8	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(4)	6	ASNA2529-5	NUT				
		7	NSA5368-516B	WASHER	OR			
	(3)	8	EN6115K5X7	BOLT	8.206 mm	8.246 mm	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03
(4)	6	ASNA2529-5	NUT	(0.3231 in)	(0.3246 in)			
	(3)	9	EN6115K5-7	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 03
	(4)	6	ASNA2529-5	NUT				
					OR			
	(3)	43	EN6115K6Y8	BOLT	10.177 mm	10.219 mm	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 03
(4)	4	ASNA2529-6	NUT	(0.4007 in)	(0.4023 in)			
		47	NSA5368-616B	WASHER	OR			
	(3)	39	EN6115K6X7	BOLT	9.784 mm	9.823 mm	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03
(4)	4	ASNA2529-6	NUT	(0.3852 in)	(0.3867 in)			

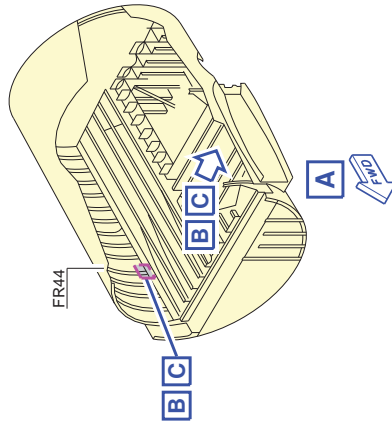
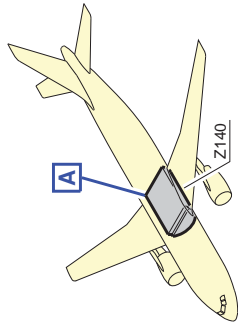
NOTE:

- 01 > OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 10.218 mm (0.4023 in)).
- 02 > PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JME4.
- 03 > IF SPOTFACING NECESSARY CONTACT AIRBUS.
- 04 > IF THE HOLES OF THE BRACKET, ITEM (20), IS MORE THAN 6.35 mm (0.250 in), INSTALL A NEW BRACKET ITEM 20.

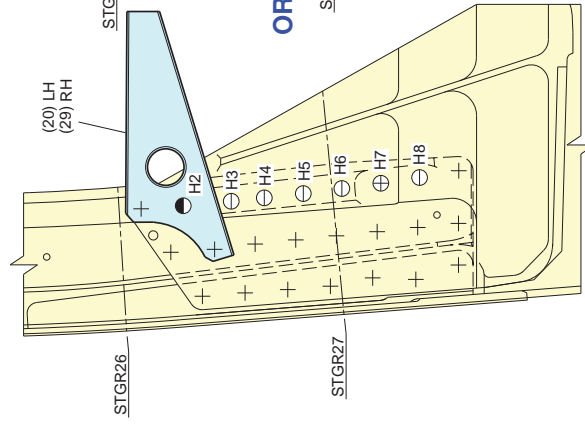
Figure A-FCDA - Sheet 03

Replacement of the Fastener on Holes H2 to H8 of Frame 44

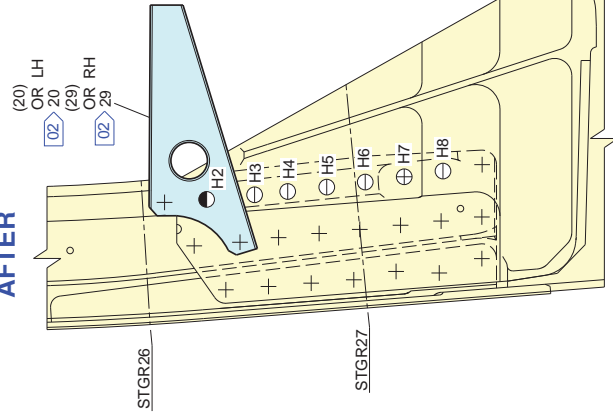
**CONF 002, 004



BEFORE



AFTER



NOTE:
+ FASTENERS NOT AFFECTED
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

B INBD
FR44
LH SHOWN
RH SYMMETRICAL

C INBD
FR44
LH SHOWN
RH SYMMETRICAL

Figure A-FCDAB - Sheet 01
Replacement of the Fastener on Holes H2 to H8 of Frame 44

D_SB_536178_5_CDAB_01_00

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE		
					MIN	MAX				
⊖	(3)	22	EN6115K6-9	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 04		
	(4)	4	ASNA2529-6	NUT	OR					
	(3)	23	EN6115K6Y10	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)			FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 04
	(4)	6	ASNA2529-5	NUT	OR					
	7	NSA5368-516B	WASHER	OR						
⊖	(3)	41	EN6115K6X9	BOLT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 04		
	(4)	4	ASNA2529-6	NUT	OR					
	(3)	45	EN6115K6Y10	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)			FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 04
	(4)	4	ASNA2529-6	NUT	OR					
	46	NSA5368-616B	WASHER	OR						
⊖	(3)	26	EN6115K6-8	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 04		
	(4)	4	ASNA2529-6	NUT	OR					
	(3)	27	EN6115K6Y9	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)			FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 04
	(4)	6	ASNA2529-5	NUT	OR					
	7	NSA5368-516B	WASHER	OR						
⊖	(3)	40	EN6115K6X8	BOLT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 04		
	(4)	4	ASNA2529-6	NUT	OR					
	(3)	44	EN6115K6Y9	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)			FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 04
	(4)	4	ASNA2529-6	NUT	OR					
	46	NSA5368-616B	WASHER	OR						
⊖	(3)	3	EN6115K6-7	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 04		
	(4)	4	ASNA2529-6	NUT	OR					
	(3)	5	EN6115K6Y8	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)			FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 04
	(4)	6	ASNA2529-5	NUT	OR					
	7	NSA5368-516B	WASHER	OR						
⊕	(3)	39	EN6115K6X7	BOLT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 04		
	(4)	4	ASNA2529-6	NUT	OR					
	(3)	43	EN6115K6Y8	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)			FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 04
	(4)	4	ASNA2529-6	NUT	OR					
	46	NSA5368-616B	WASHER	OR						

NOTE:
 01 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in)
 (MAXIMUM DIAMETER 10.218 mm (0.4023 in)).
 02 IF THE HOLE OF THE BRACKET ITEM (20) OR ITEM (29) IS MORE THAN
 6.35 mm (0.250 in), INSTALL A NEW BRACKET ITEM 20 OR ITEM 29.
 03 PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH
 MATERIAL No 04JME4.
 04 IF SPOTFACING NECESSARY CONTACT AIRBUS.

Figure A-FCDAB - Sheet 02
 Replacement of the Fastener on Holes H2 to H8 of Frame 44

**CONF 005

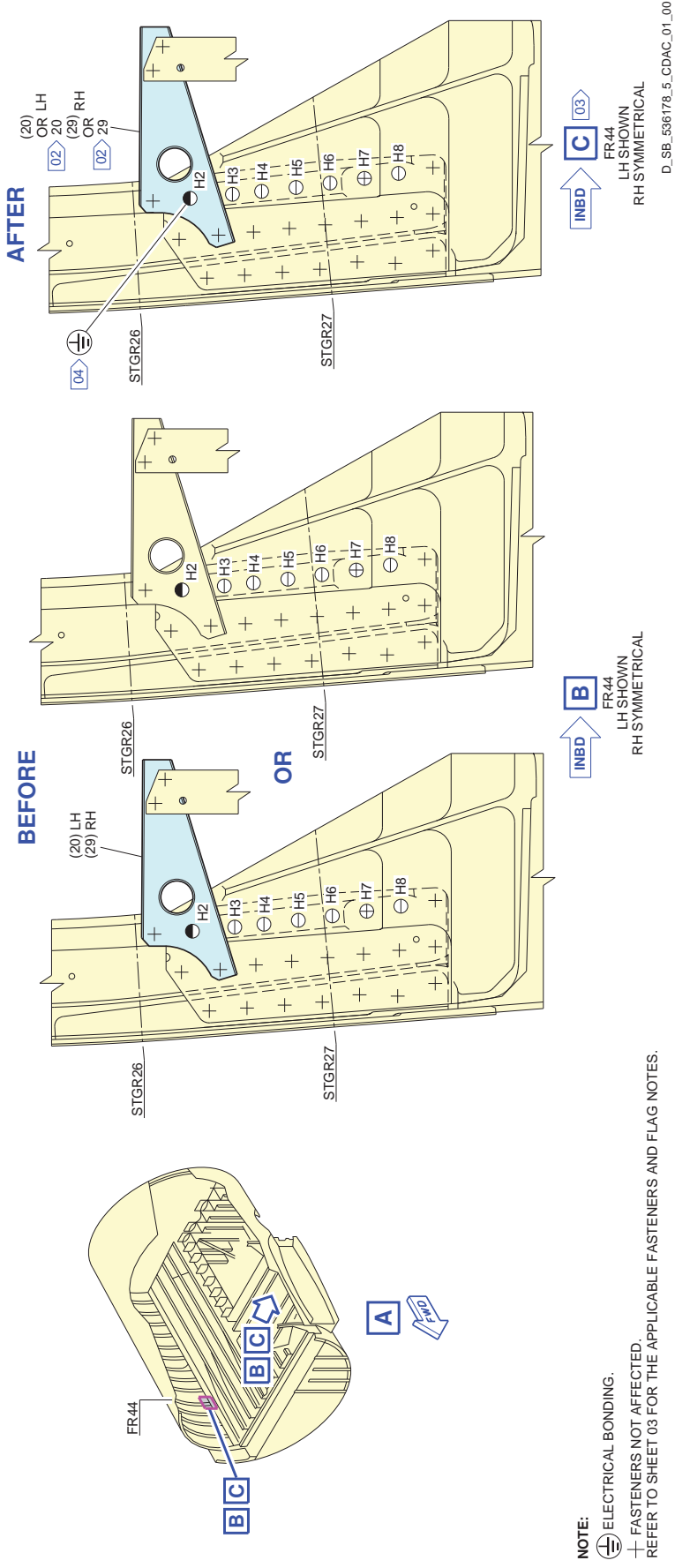
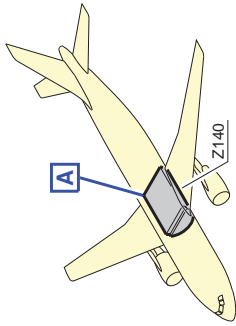


Figure A-FCDAC - Sheet 01
Replacement of the Fastener on Holes H2 to H7 of Frame 44

**CONF 005

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
⊖	(3)	22	EN6115K6-9	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 05
	(4)	4	ASNA2529-6	NUT				
						OR		
	(3)	23	EN6115K5Y10	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 05
	(4)	6	ASNA2529-5	NUT				
						OR		
	(3)	41	EN6115K6X9	BOLT	9.784 mm (0.3862 in)	9.823 mm (0.3867 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 05
	(4)	4	ASNA2529-6	NUT				
						OR		
	(3)	45	EN6115K6Y10	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 05
	(4)	4	ASNA2529-6	NUT				
					OR			
(3)	26	EN6115K6-8	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 05	
(4)	4	ASNA2529-6	NUT					
					OR			
(3)	27	EN6115K5Y9	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 05	
(4)	6	ASNA2529-5	NUT					
					OR			
(3)	40	EN6115K6X8	BOLT	9.784 mm (0.3862 in)	9.823 mm (0.3867 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 05	
(4)	4	ASNA2529-6	NUT					
					OR			
(3)	44	EN6115K6Y9	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 05	
(4)	4	ASNA2529-6	NUT					
					OR			

NOTE:
REFER TO SHEET 03 FOR THE APPLICABLE FLAG NOTES.

D_SB_536778_5_CDAC_02_00

Figure A-FCDAC - Sheet 02
Replacement of the Fastener on Holes H2 to H7 of Frame 44

⊕	(3)	3	EN6115K6-7	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01	05
	(4)	4	ASNA2529-6	NUT					
					OR				
	(3)	5	EN6115K5Y8	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01	05
	(4)	6	ASNA2529-5	NUT					
		7	NSA5368-516B	WASHER					
					OR				
	(3)	39	EN6115K6X7	BOLT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01	05
	(4)	4	ASNA2529-6	NUT					
					OR				
	(3)	43	EN6115K6Y8	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01	05
	(4)	4	ASNA2529-6	NUT					
		46	NSA5368-616B	WASHER					

NOTE:

- 01 > OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 10.218 mm (0.4023 in)).
- 02 > IF THE HOLE IS GREATER THAN 6.35 mm (0.250 in), INSTALL A NEW BRACKET ITEM 20 OR ITEM 29.
- 03 > PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JME4.
- 04 > IF NOT ALREADY DONE ON THE SUPPORT, DO A STRIPPING DIAMETER 14 mm (0.551 in) ON VISIBLE FACE OF THE SUPPORT ITEM 20 OR ITEM 29.
- 05 > IF SPOTFACING NECESSARY CONTACT AIRBUS.

Figure A-FCDAC - Sheet 03
Replacement of the Fastener on Holes H2 to H7 of Frame 44

**CONF 001, 003

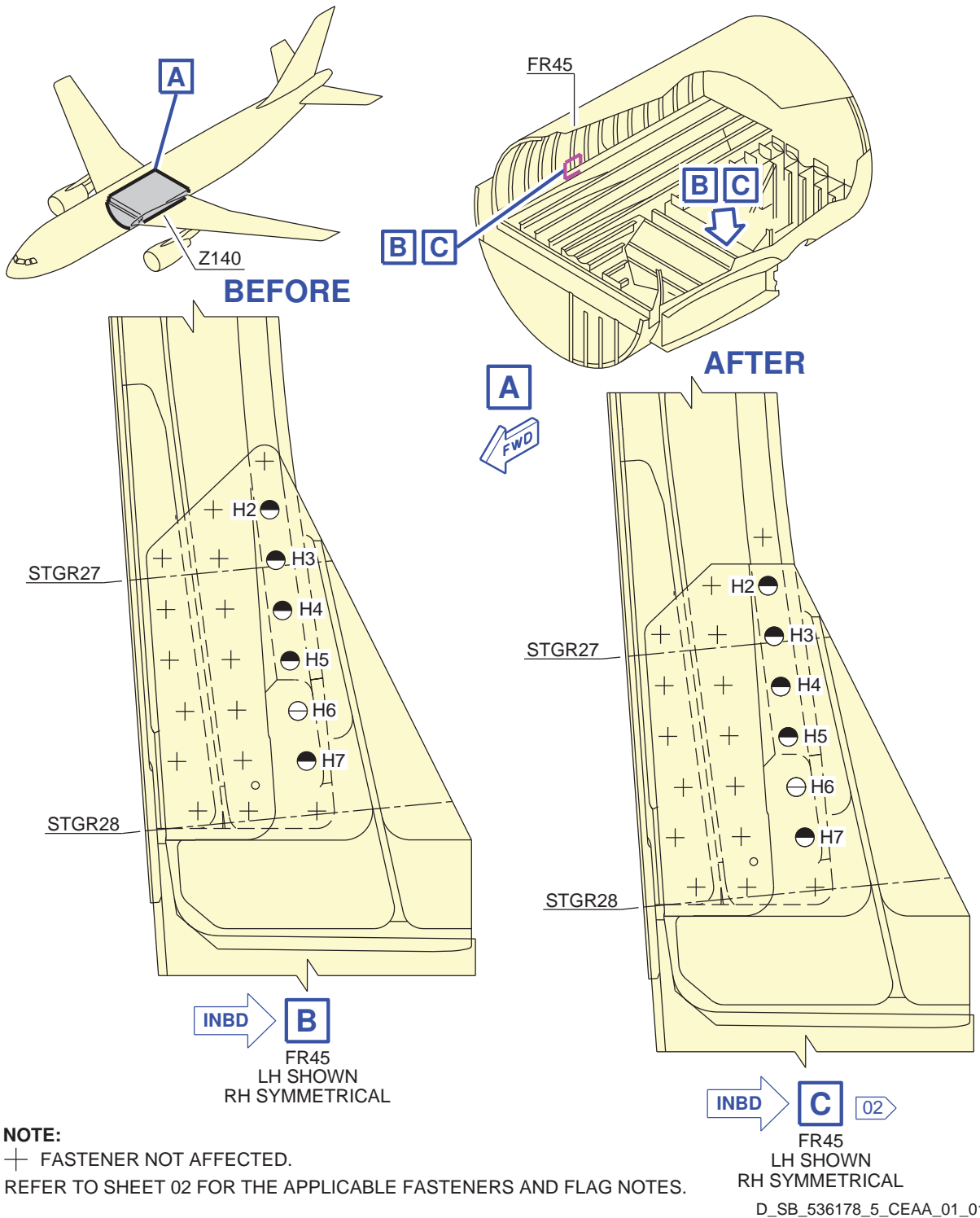


Figure A-FCEAA - Sheet 01
 Replacement of the Fastener on Holes H2 to H7 of Frame 45

**CONF 001, 003

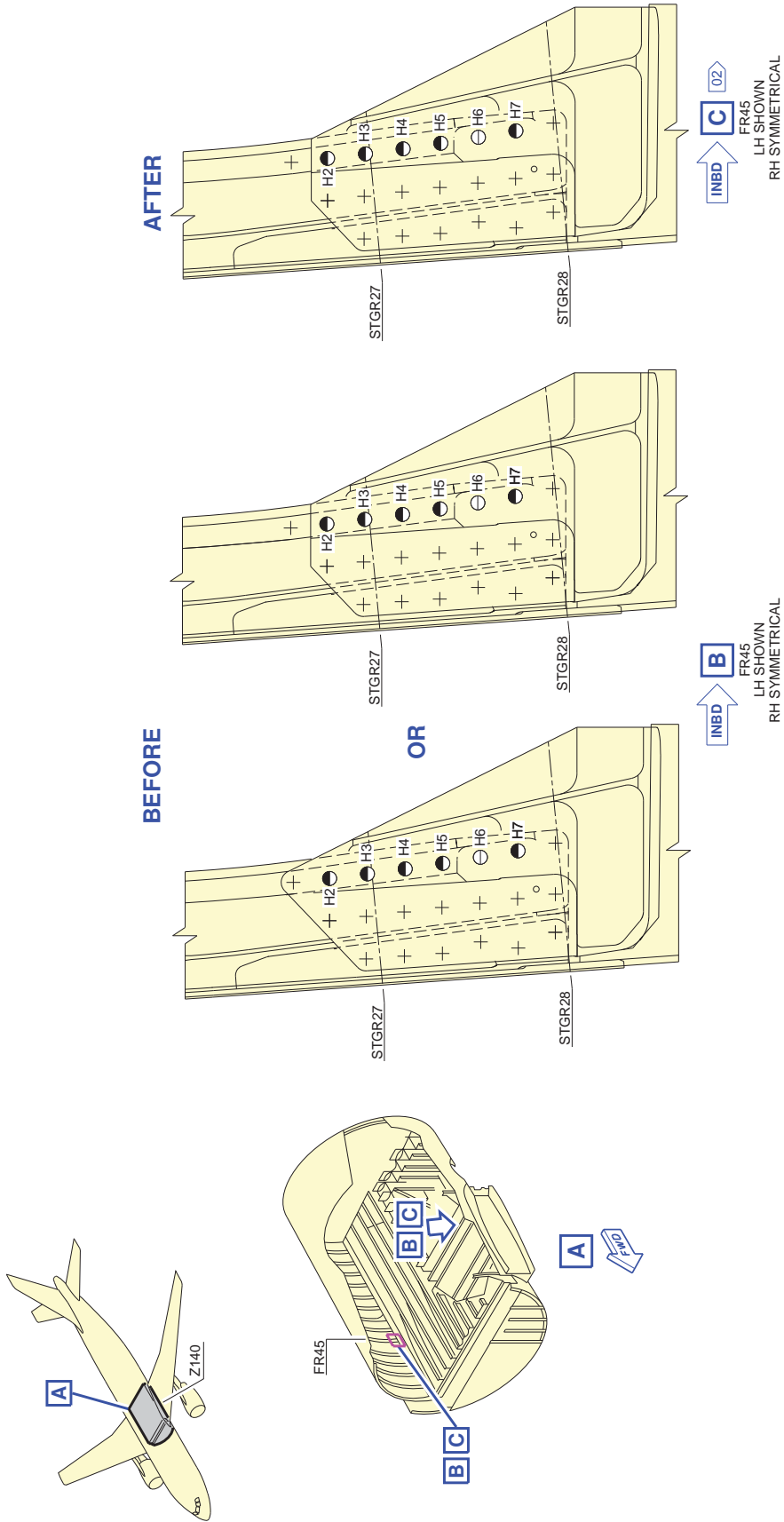
HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
⊖	(3)	26	EN6115K6-8	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 03
	(4)	4	ASNA2529-6	NUT	OR			
	(3)	27	EN6115K5Y9	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(4)	6	ASNA2529-5	NUT	OR			
⊖	(3)	28	EN6115K5X8	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03
	(4)	6	ASNA2529-5	NUT	OR			
	(3)	19	EN6115K5-8	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 03
	(4)	6	ASNA2529-5	NUT	OR			
⊖	(3)	44	EN6115K6Y9	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(4)	4	ASNA2529-6	NUT	OR			
	(3)	40	EN6115K6X8	BOLT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03
	(4)	4	ASNA2529-6	NUT	OR			
⊖	(3)	43	EN6115K6Y8	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(4)	4	ASNA2529-6	NUT	OR			
	(3)	39	EN6115K6X7	BOLT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03
	(4)	4	ASNA2529-6	NUT	OR			
⊖	(3)	3	EN6115K6-7	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 03
	(4)	4	ASNA2529-6	NUT	OR			
	(3)	5	EN6115K5Y8	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(4)	6	ASNA2529-5	NUT	OR			
⊖	(3)	8	EN6115K5X7	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03
	(4)	6	ASNA2529-5	NUT	OR			
	(3)	9	EN6115K5-7	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 03
	(4)	6	ASNA2529-5	NUT	OR			

NOTE:
 01 > OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in)
 (MAXIMUM DIAMETER 10.218 mm (0.4023 in)).
 02 > PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04IME4.
 03 > IF SPOTFACING NECESSARY CONTACT AIRBUS.

D_SB_536178_5_CEEA_02_00

Figure A-FCEAA - Sheet 02
Replacement of the Fastener on Holes H2 to H7 of Frame 45

**CONF 002, 004 thru 005



NOTE:
+ FASTENER NOT AFFECTED.
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

Figure A-FCEAB - Sheet 01
Replacement of the Fastener on Holes H2 to H7 of Frame 45

**CONF 002, 004 thru 005

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE	
					MIN	MAX			
⊖	(3)	26	EN6115K6-8	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 03	
	(4)	4	ASNA2529-6	NUT	OR				
	(3)	27	EN6115K5Y9	BOLT	8.642 mm (0.3387 in)	8.642 mm (0.3402 in)			FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE
	(4)	6	ASNA2529-5	NUT	OR				
⊖	(4)	7	NSA5368-516B	WASHER	OR		FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE		
	(3)	44	EN6115K6Y9	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)		FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	
	(4)	4	ASNA2529-6	NUT	OR				
	(3)	40	EN6115K6X8	BOLT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)			FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE
(4)	4	ASNA2529-6	NUT	OR					
⊖	(3)	43	EN6115K6Y8	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE		
	(4)	4	ASNA2529-6	NUT	OR				
	(3)	39	EN6115K6X7	BOLT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)		FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	
	(4)	4	ASNA2529-6	NUT	OR				
⊖	(3)	3	EN6115K6-7	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE		
	(4)	4	ASNA2529-6	NUT	OR				
	(3)	5	EN6115K5Y8	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)		FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	
	(4)	6	ASNA2529-5	NUT	OR				
⊖	(4)	7	NSA5368-516B	WASHER	OR		FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE		

NOTE:

01 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 10.218 mm (0.4023 in)).

02 PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JIME4.

03 IF SPOTFACING NECESSARY CONTACT AIRBUS.

Figure A-FCEAB - Sheet 02

Replacement of the Fastener on Holes H2 to H7 of Frame 45

**CONF 001, 003

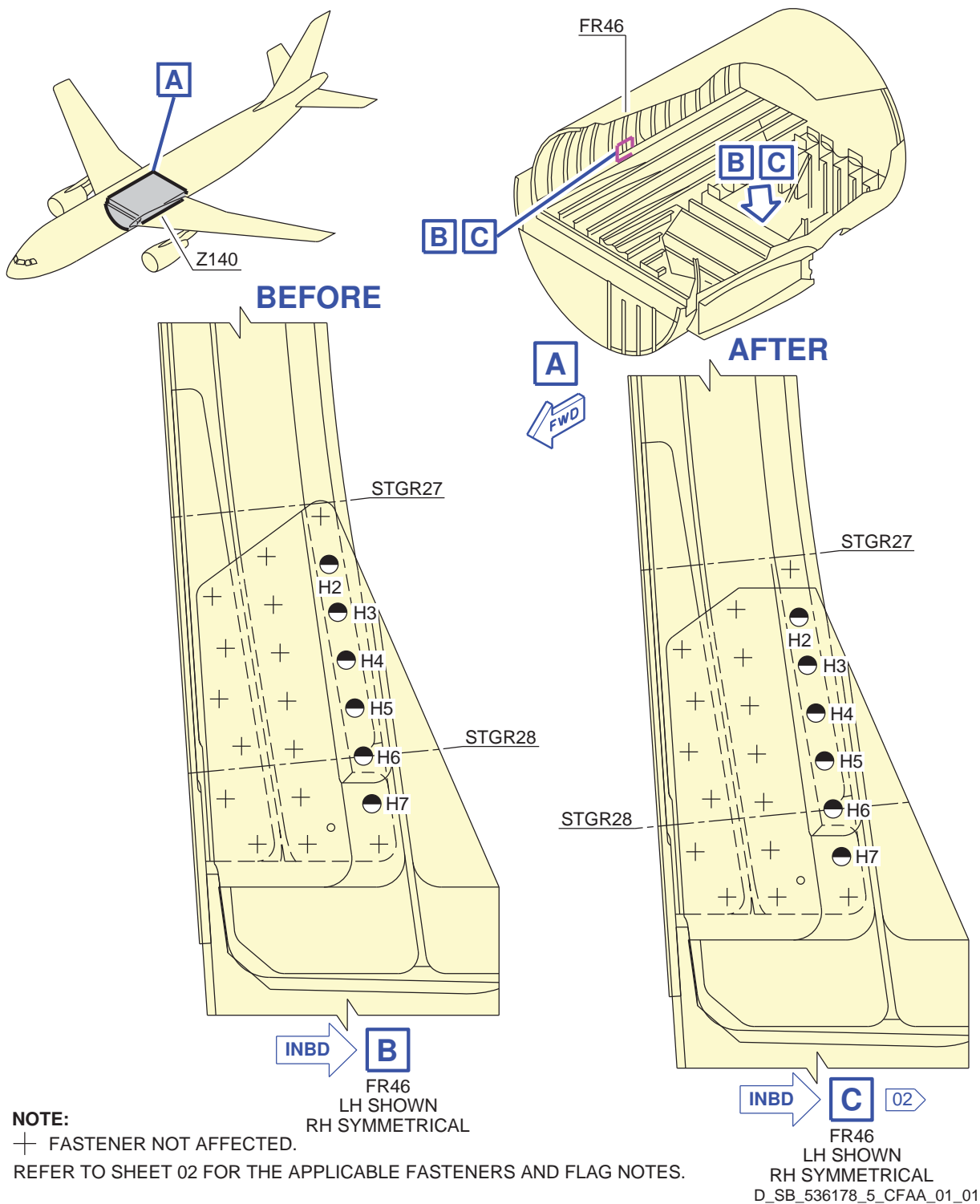


Figure A-FCFAA - Sheet 01
 Replacement of the Fastener on Holes H2 to H7 of Frame 46

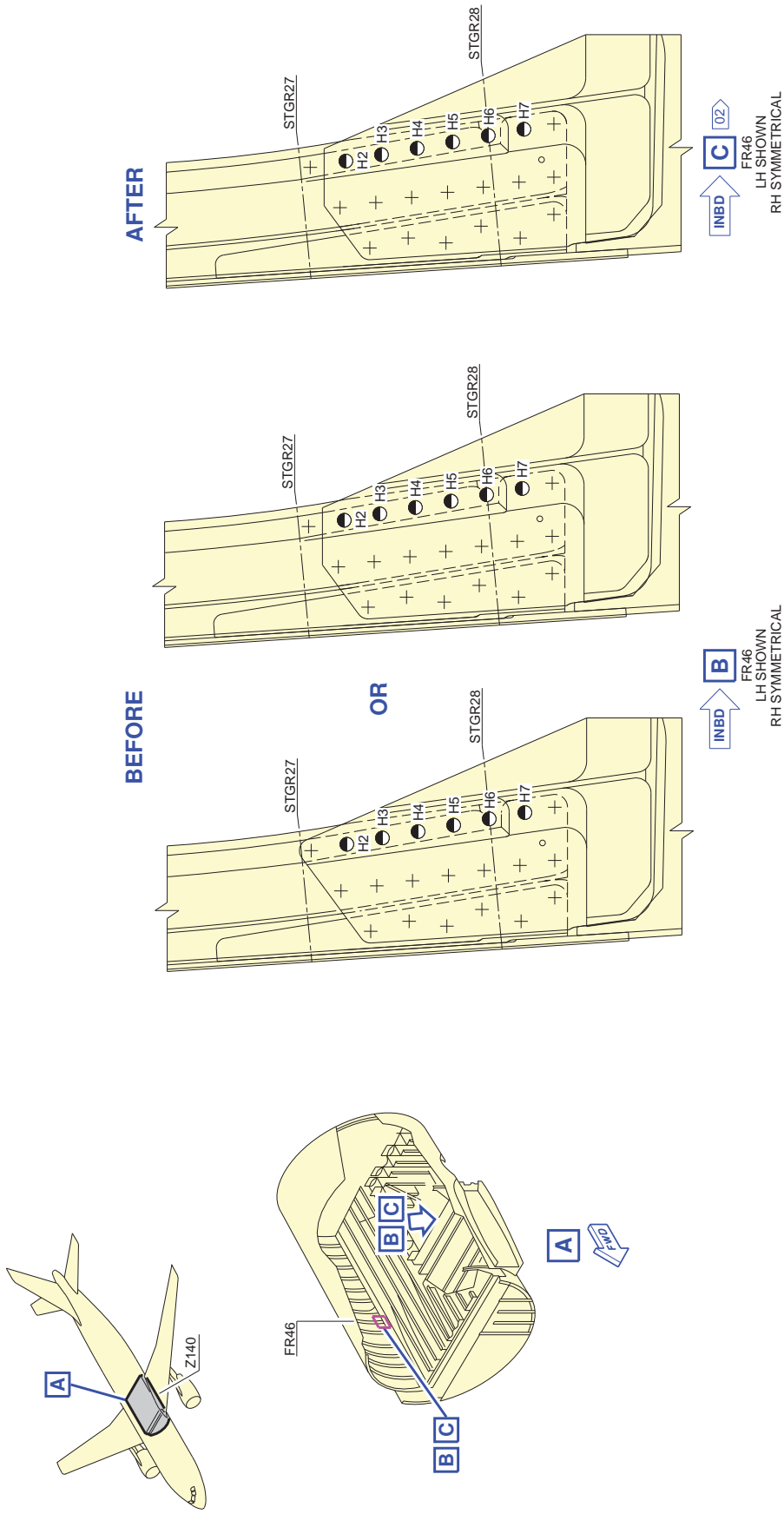
**CONF 001, 003

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE	
					MIN	MAX			
⊙	(3)	26	EN6115K6-8	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 03	
	(4)	4	ASNA2529-6	NUT					
	OR								
	(3)	27	EN6115K5Y9	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03	
	(4)	6	ASNA2529-5	NUT					
		7	NSA5368-516B	WASHER					
	OR								
	(3)	28	EN6115K5X8	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03	
	(4)	6	ASNA2529-5	NUT					
	OR								
	(3)	19	EN6115K5-8	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 03	
	(4)	6	ASNA2529-5	NUT					
	OR								
	(3)	44	EN6115K6Y9	BOLT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03	
(4)	4	ASNA2529-6	NUT						
	46	NSA5368-616B	WASHER						
OR									
(3)	40	EN6115K6X8	BOLT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03		
(4)	4	ASNA2529-6	NUT						

NOTE:
 01 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 10.218 mm (0.4023 in)).
 02 PROTECT WITH PRIMER MATERIAL No 04EACZ AND APPLY FINISH MATERIAL No 04JME4.
 03 IF SPOTFACING NECESSARY CONTACT AIRBUS.

Figure A-FCFAA - Sheet 02
 Replacement of the Fastener on Holes H2 to H7 of Frame 46
 SERVICE BULLETIN No.: A300-53-6178
 DATE: Mar 17/15
 REVISION No.: 01 - Sep 20/19
 Page: 1527


**CONF 002, 004 thru 005



NOTE:
+ FASTENER NOT AFFECTED.
02 REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

Figure A-FCFAB - Sheet 01
Replacement of the Fastener on Holes H2 to H7 of Frame 46

**CONF 002, 004 thru 005

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
	(3)	26	EN6115K6-8	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 03
	(4)	4	ASNA2529-6	NUT	OR			
	(3)	27	EN6115K5Y9	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(4)	6	ASNA2529-5	NUT	OR			
	(4)	4	ASNA2529-6	NUT	10.177 mm (0.4007 in)	10.219 mm (0.4023 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03
	(4)	46	NSA5368-616B	WASHER	OR			
	(3)	40	EN6115K6X8	BOLT	9.784 mm (0.3852 in)	9.823 mm (0.3867 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03
(4)	4	ASNA2529-6	NUT					

NOTE:

- 01 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 10.218 mm (0.4023 in)).
- 02 PROTECT WITH PRIMER MATERIAL No 94EAC2 AND APPLY FINISH MATERIAL No 04JME4.
- 03 IF SPOTFACING NECESSARY CONTACT AIRBUS.

Figure A-FCFAB - Sheet 02
Replacement of the Fastener on Holes H2 to H7 of Frame 46

**CONF 001, 003

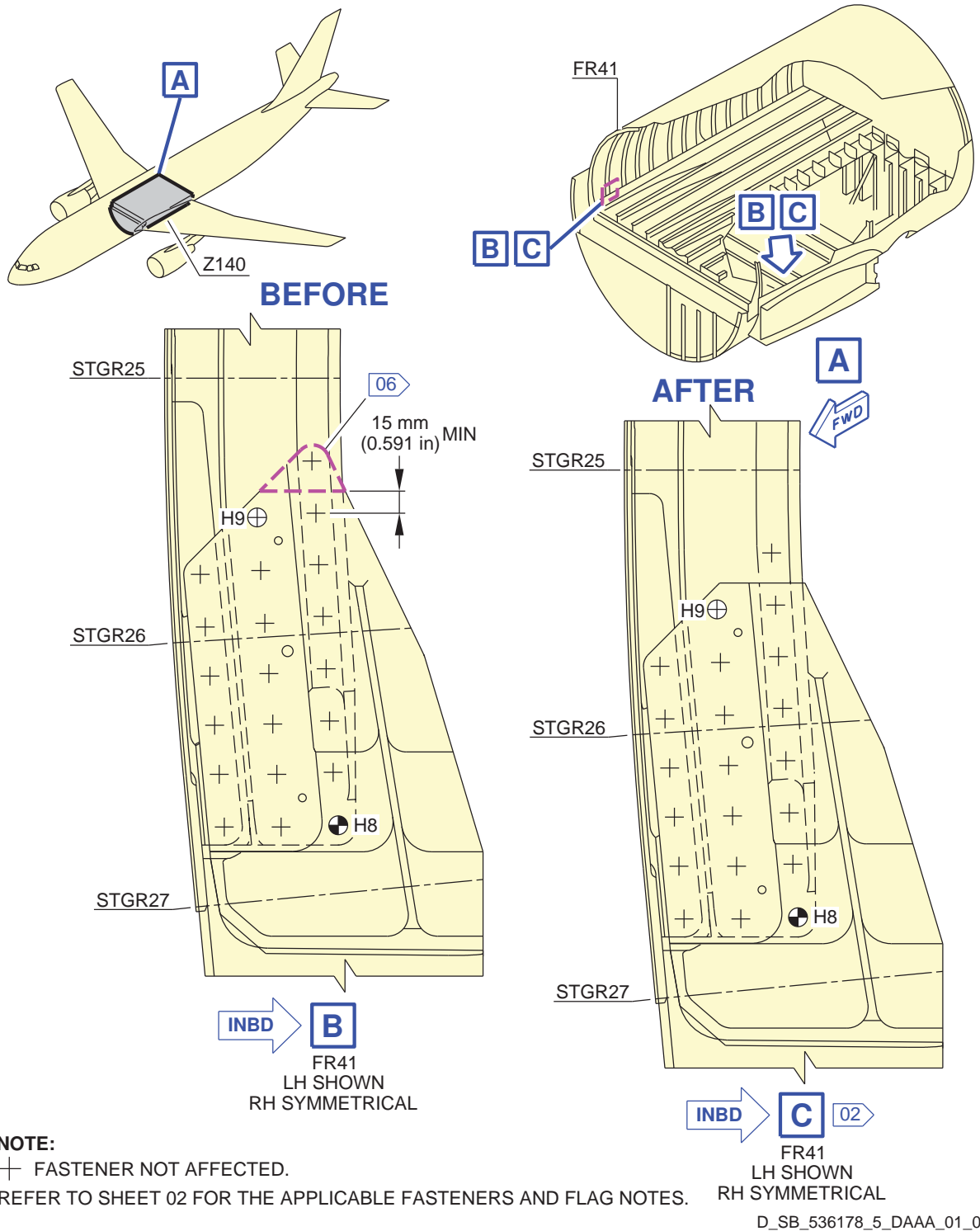


Figure A-FDAAA - Sheet 01
Replacement of the Fastener on Holes H8 to H9 of Frame 41

**CONF 001, 003

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
	(3)	16	EN6115K5Y6	BOLT	8.602 mm	8.642 mm	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03 05
	(4)	6	ASNA2529-5	NUT	(0.3387 in)	(0.3402 in)		
		7	NSA5368-516B	WASHER				
⊕	(3)	17	EN6115K5X5	BOLT	8.206 mm	8.246 mm	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03 05
	(4)	6	ASNA2529-5	NUT	(0.3387 in)	(0.3246 in)		
					OR			
	(3)	18	EN6115K5-5	BOLT	7.809 mm	7.849 mm	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 03 05
	(4)	6	ASNA2529-5	NUT	(0.3075 in)	(0.3090 in)		
					OR			
(3)	15	EN6115K5-6	BOLT	7.900 mm	7.940 mm	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	01 03 04 05	
(4)	6	ASNA2529-5	NUT	(0.3111 in)	(0.3125 in)			
				OR				
(3)	3	EN6115K6-7	BOLT	9.387 mm	9.427 mm	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 03 05	
(4)	4	ASNA2529-6	NUT	(0.3696 in)	(0.3711 in)			
⊕	(3)	5	EN6115K5Y8	BOLT	8.602 mm	8.642 mm	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 03 05
	(4)	6	ASNA2529-5	NUT	(0.3387 in)	(0.3402 in)		
					OR			
	(3)	8	EN6115K5X7	BOLT	8.206 mm	8.246 mm	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 03 05
	(4)	6	ASNA2529-5	NUT	(0.3231 in)	(0.3246 in)		
					OR			
(3)	9	EN6115K5-7	BOLT	7.809 mm	7.849 mm	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 03 05	
(4)	6	ASNA2529-5	NUT	(0.3075 in)	(0.3090 in)			
				OR				
(3)	19	EN6115K5-8	BOLT	7.900 mm	7.940 mm	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	01 03 04 05	
(4)	6	ASNA2529-5	NUT	(0.3111 in)	(0.3125 in)			
				OR				
		47	NSA5379-5W	WASHER				

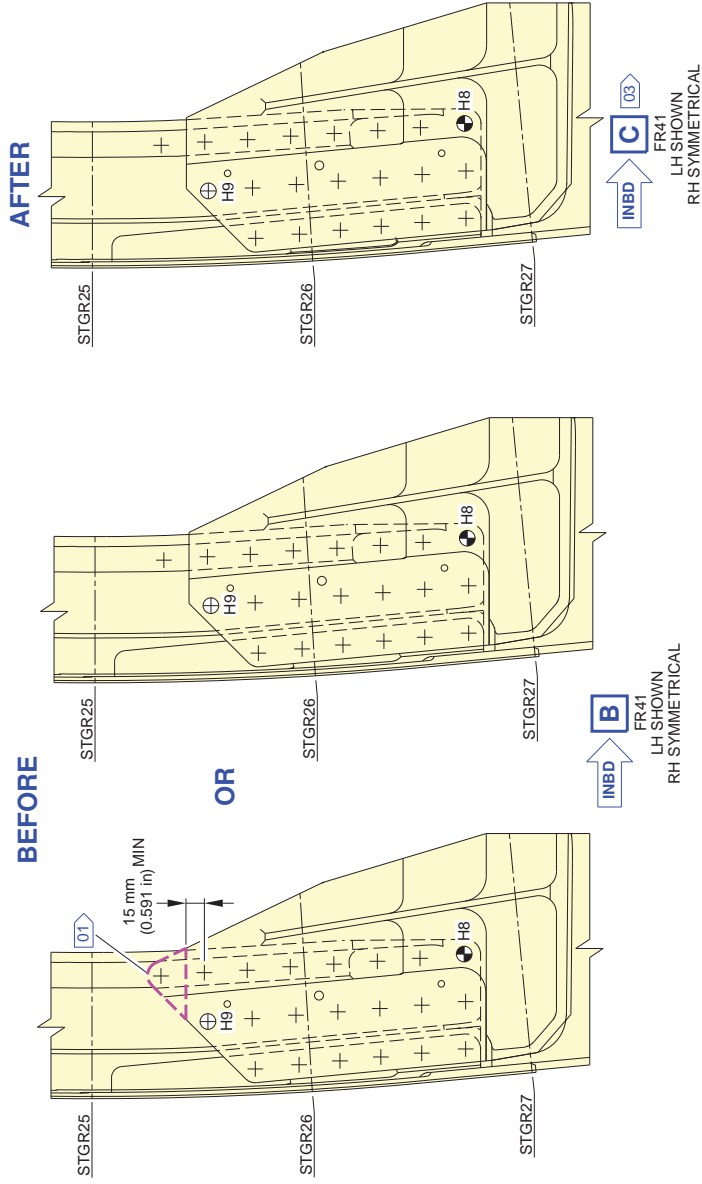
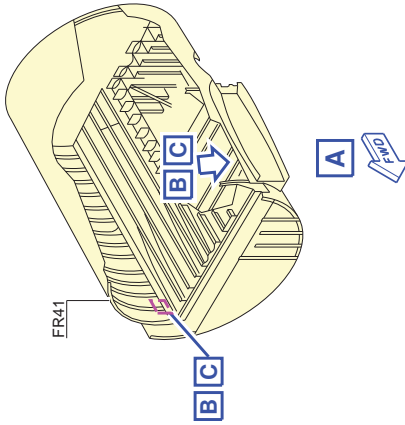
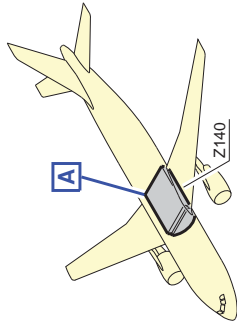
NOTE:

- 01 > IF (EDGE DISTANCE) / (DIAMETER HOLE + 1.60) < 1.27 AND (EDGE DISTANCE) / (DIAMETER HOLE + 0.80) ≥ 1.30 AND DIAMETER HOLE > 7.920 mm (0.3119 in), INSTALL A BUSH.
- 02 > PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JME4.
- 03 > IF SPOTFACING NECESSARY CONTACT AIRBUS.
- 04 > VALID ONLY IF THE BUSH IS INSTALLED.
- 05 > OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).
- 06 > FRAME FOOT PORTION TO CUT.

Figure A-FDAAA - Sheet 02

Replacement of the Fastener on Holes H8 to H9 of Frame 41

**CONF 002, 004 thru 005



NOTE:
+ FASTENER NOT AFFECTED.
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

Figure A-FDAAB - Sheet 01
Replacement of the Fastener on Holes H8 to H9 of Frame 41

**CONF 002, 004 thru 005

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
	(3)	17	EN6115K5X5	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT	OR			
	(3)	18	EN6115K5-5	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	02 04 06
	(4)	6	ASNA2529-5	NUT	OR			
⊕	(3)	16	EN6115K5Y6	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT				
	7	NSA5368-516B	WASHER					
	(3)	15	EN6115K5-6	BOLT	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 04 05 06
	(4)	6	ASNA2529-5	NUT				
	47	NSA5379-5W	WASHER					
	(3)	3	EN6115K6-7	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	02 04 06
	(4)	4	ASNA2529-6	NUT				
⊖	(3)	5	EN6115K5Y8	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT				
	7	NSA5368-516B	WASHER					
	(3)	19	EN6115K5-8	BOLT	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 04 05 06
	(4)	6	ASNA2529-5	NUT				
		47	NSA5379-5W	WASHER				

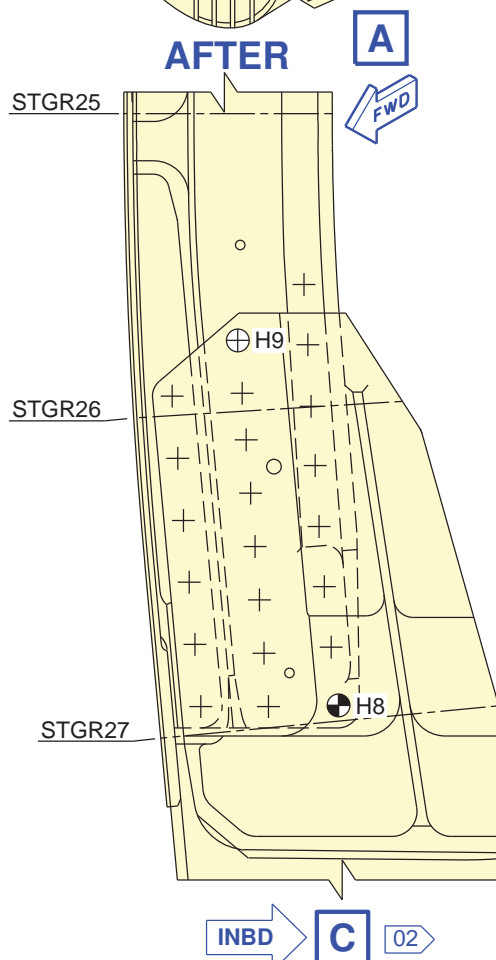
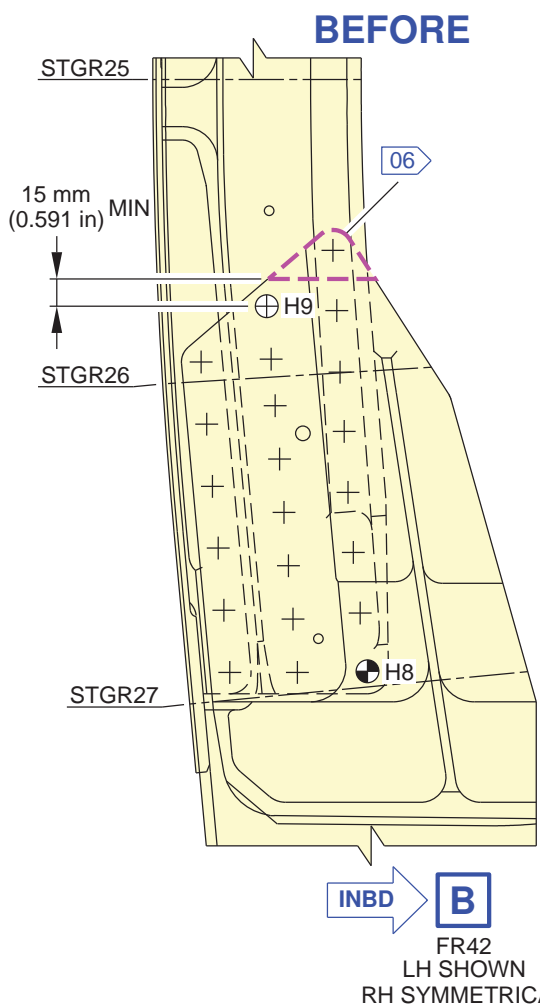
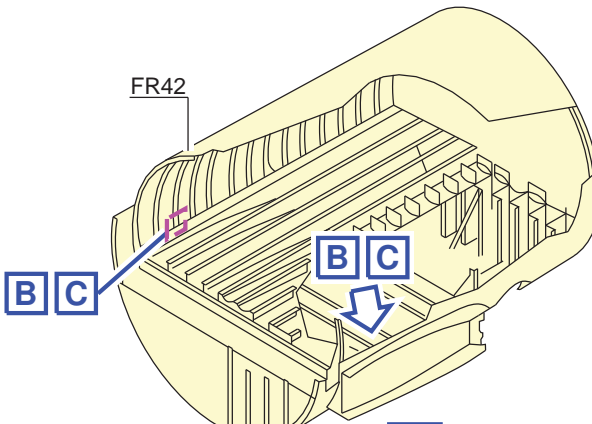
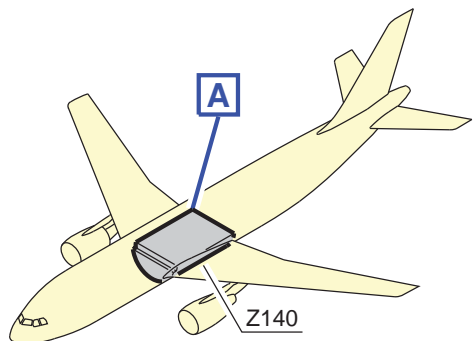
NOTE:

- 01 IF THE FRAME FOOT IS NOT CUT, PORTION TO CUT.
- 02 IF (EDGE DISTANCE) / (DIAMETER HOLE + 1.60) < 1.27 AND (EDGE DISTANCE) / (DIAMETER HOLE + 0.80) ≥ 1.30 AND DIAMETER HOLE > 7.920 mm (0.3119 in), INSTALL A BUSH.
- 03 PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JIME4.
- 04 IF SPOTFACING NECESSARY CONTACT AIRBUS.
- 05 VALID ONLY IF A BUSH IS INSTALLED.
- 06 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).

Figure A-FDAAB - Sheet 02

Replacement of the Fastener on Holes H8 to H9 of Frame 41

**CONF 001, 003



NOTE:

+ FASTENER NOT AFFECTED.

REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

D_SB_536178_5_DBAA_01_00

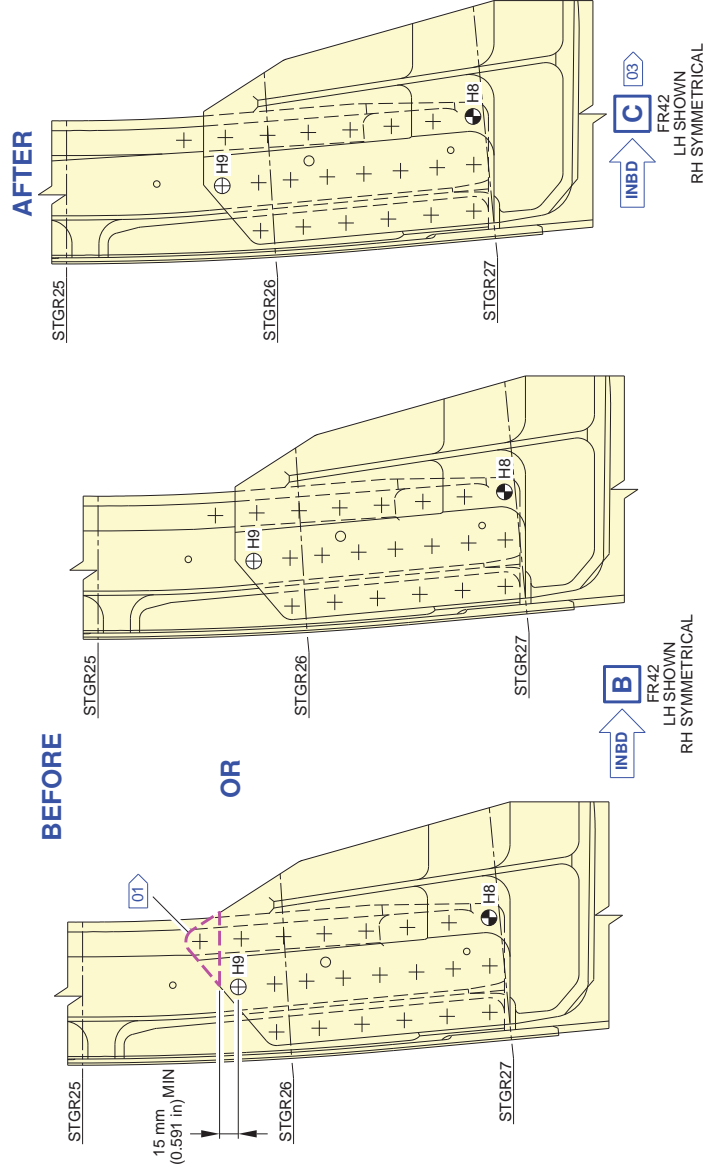
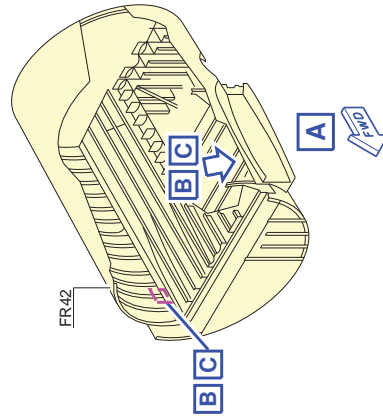
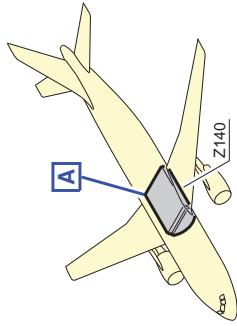
Figure A-FDBAA - Sheet 01
Replacement of the Fastener on Holes H8 to H9 of Frame 42

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE	
					MIN	MAX			
⊕	(3)	16	EN6115K5Y6	BOLT	8,602 mm (0.3387 in)	8,642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 > 03 05 >	
	(4)	6	ASNA2529-5	NUT					
		7	NSA5368-516B	WASHER					
		(3)	17	EN6115K5X5	BOLT	8,206 mm (0.3231 in)	8,246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 > 03 05 >
	(4)	6	ASNA2529-5	NUT					
		(3)	18	EN6115K5-5	BOLT	7,809 mm (0.3075 in)	7,849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 > 03 05 >
	(4)	6	ASNA2529-5	NUT					
	(3)	15	EN6115K5-6	BOLT	7,900 mm (0.3111 in)	7,940 mm (0.3125 in)	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	01 > 03 04 > 05	
(4)	6	ASNA2529-5	NUT						
	47	NSA5379-5W	WASHER						
	(3)	3	EN6115K6-7	BOLT	9,387 mm (0.3696 in)	9,427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	01 > 03 05 >	
(4)	4	ASNA2529-6	NUT						
	(3)	5	EN6115K5Y8	BOLT	8,602 mm (0.3387 in)	8,642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	01 > 03 05 >	
(4)	6	ASNA2529-5	NUT						
	7	NSA5368-516B	WASHER						
⊗	(3)	8	EN6115K5X7	BOLT	8,206 mm (0.3231 in)	8,246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	01 > 03 05 >	
	(4)	6	ASNA2529-5	NUT					
		(3)	9	EN6115K5-7	BOLT	7,809 mm (0.3075 in)	7,849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	01 > 03 05 >
	(4)	6	ASNA2529-5	NUT					
		(3)	19	EN6115K5-8	BOLT	7,900 mm (0.3111 in)	7,940 mm (0.3125 in)	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	01 > 03 04 > 05
	(4)	6	ASNA2529-5	NUT					
		47	NSA5379-5W	WASHER					

NOTE:
 01 > IF (EDGE DISTANCE) / (DIAMETER HOLE + 1.60) < 1.27 AND (EDGE DISTANCE) / (DIAMETER HOLE + 0.80) ≥ 1.30 AND DIAMETER HOLE > 7.920 mm (0.3119 in), INSTALL A BUSH.
 02 > PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JIME4.
 03 > IF SPOTTACING NECESSARY CONTACT AIRBUS.
 04 > VALID ONLY IF A BUSH IS INSTALLED.
 05 > OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).
 06 > FRAME FOOT PORTION TO CUT.

Figure A-FDBAA - Sheet 02
 Replacement of the Fastener on Holes H8 to H9 of Frame 42
 SERVICE BULLETIN No.: A300-53-6178
 DATE: Mar 17/15
 REVISION No.: 01 - Sep 20/19
 Page: 1535

**CONF 002, 004 thru 005



NOTE:
+ FASTENER NOT AFFECTED
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

Figure A-FDBAB - Sheet 01
Replacement of the Fastener on Holes H8 to H9 of Frame 42

D_SB_536178_5_DBAB_01_00

**CONF 002, 004 thru 005

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
	(3)	17	EN6115K5X5	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT	OR			
⊕	(3)	18	EN6115K5-5	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	02 04 06
	(4)	6	ASNA2529-5	NUT	OR			
	(3)	16	EN6115K5Y6	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT				
	7	NSA5368-516B	WASHER					
	(3)	15	EN6115K5-6	BOLT	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 04 05 06
	(4)	6	ASNA2529-5	NUT				
	(4)	47	NSA5379-5W	WASHER	OR		FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	02 04 06
	(3)	3	EN6115K6-7	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)		
	(4)	4	ASNA2529-6	NUT	OR		FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	02 04 06
	(3)	5	EN6115K5Y8	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)		
	(4)	6	ASNA2529-5	NUT	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 04 05 06
	7	NSA5368-516B	WASHER					
⊖	(3)	19	EN6115K5-8	BOLT	OR		FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT				
	(4)	47	NSA5379-5W	WASHER	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	02 04 05 06
	(3)	8	EN6115K5X7	BOLT	OR			
	(4)	6	ASNA2529-5	NUT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	02 04 06
	(3)	9	EN6115K5-7	BOLT	OR			
	(4)	6	ASNA2529-5	NUT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	02 04 06
	(3)	8	EN6115K5X7	BOLT	OR			
	(4)	6	ASNA2529-5	NUT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	02 04 06
	(3)	9	EN6115K5-7	BOLT	OR			

- NOTE:**
- 01 IF THE FRAME FOOT IS NOT CUT, PORTION TO CUT.
 - 02 IF (EDGE DISTANCE) / (DIAMETER HOLE + 1.60) < 1.27 AND (EDGE DISTANCE) / (DIAMETER HOLE + 0.80) ≥ 1.30 AND DIAMETER HOLE > 7.920 mm (0.3119 in), INSTALL A BUSH.
 - 03 PROTECT WITH PRIMER MATERIAL No 04EACZ AND APPLY FINISH MATERIAL No 04JME4.
 - 04 IF SPOTFACING NECESSARY CONTACT AIRBUS.
 - 05 VALID ONLY IF A BUSH IS INSTALLED.
 - 06 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).

Figure A-FDBAB - Sheet 02
 Replacement of the Fastener on Holes H8 to H9 of Frame 42

**CONF 001, 003

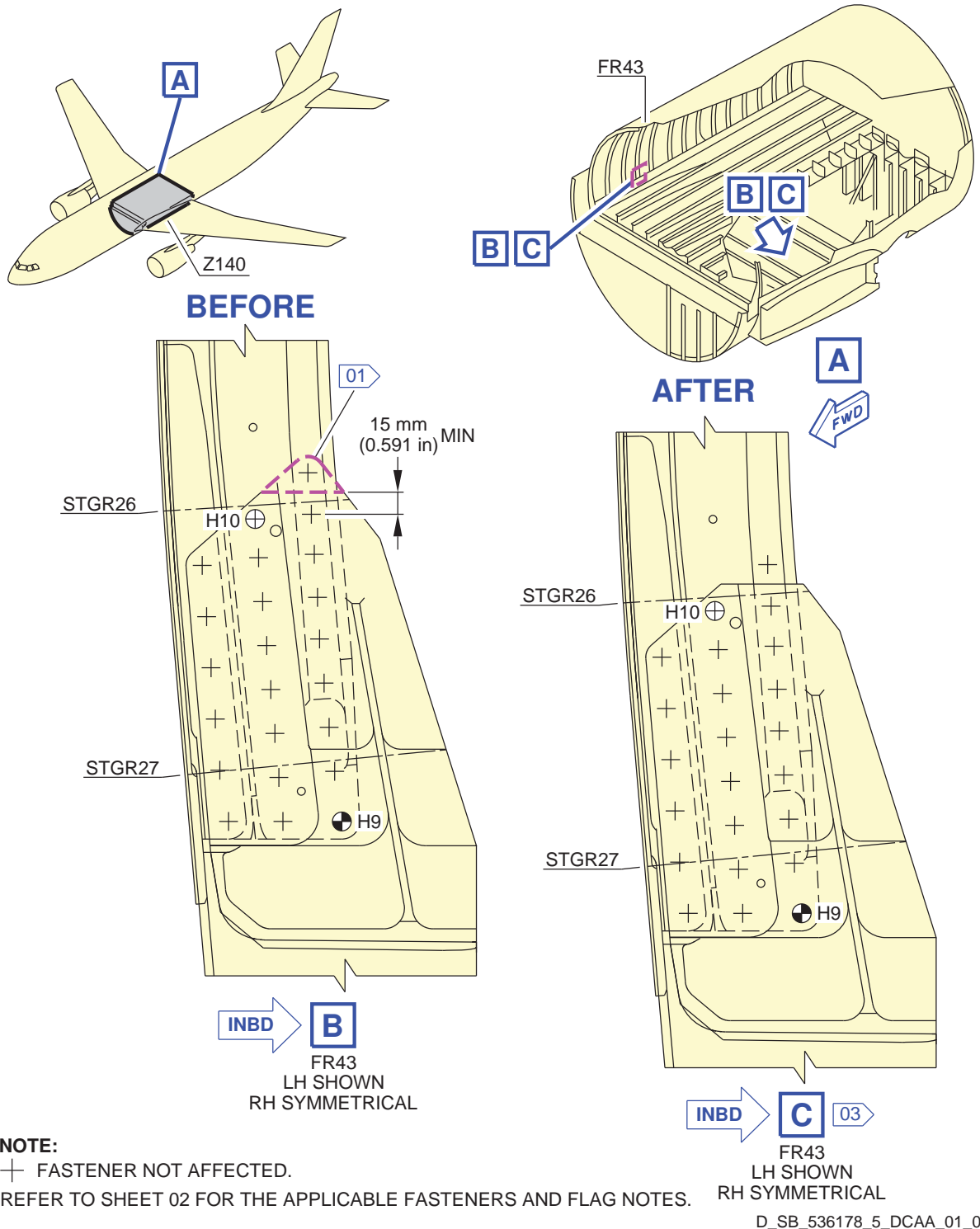


Figure A-FDCAA - Sheet 01
 Replacement of the Fastener on Holes H9 to H10 of Frame 43

**CONF 001, 003

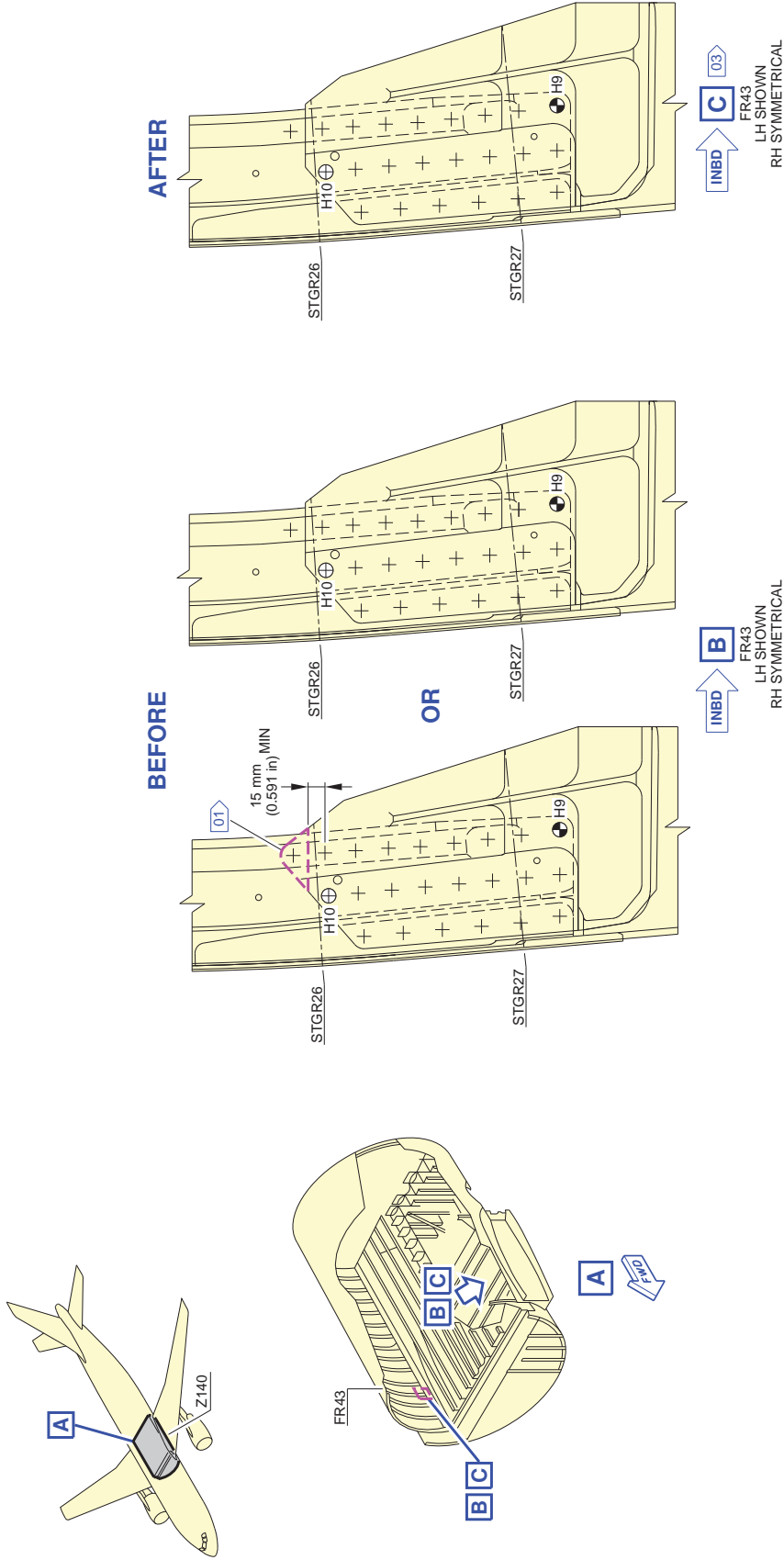
HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
⊕	(3)	16	EN6115K5Y6	BOLT	8.602 mm	8.642 mm	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT	(0.3387 in)	(0.3402 in)		
		7	NSA5368-516B	WASHER				
					OR			
	(3)	17	EN6115K5X5	BOLT	8.206 mm	8.246 mm	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT	(0.3231 in)	(0.3246 in)		
					OR			
(3)	18	EN6115K5-5	BOLT	7.809 mm	7.849 mm	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	02 04 06	
(4)	6	ASNA2529-5	NUT	(0.3075 in)	(0.3090 in)			
				OR				
⊕	(3)	15	EN6115K5-6	BOLT	7.900 mm	7.940 mm	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 04 05 06
	(4)	6	ASNA2529-5	NUT	(0.3111 in)	(0.3125 in)		
		47	NSA5379-5W	WASHER				
	(3)	3	EN6115K6-7	BOLT	9.387 mm	9.427 mm	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	02 04 06
	(4)	4	ASNA2529-6	NUT	(0.3696 in)	(0.3711 in)		
					OR			
	(3)	5	EN6115K5Y8	BOLT	8.602 mm	8.642 mm	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT	(0.3387 in)	(0.3402 in)		
		7	NSA5368-516B	WASHER				
					OR			
(3)	8	EN6115K5X7	BOLT	8.206 mm	8.246 mm	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	02 04 06	
(4)	6	ASNA2529-5	NUT	(0.3231 in)	(0.3246 in)			
				OR				
(3)	9	EN6115K5-7	BOLT	7.809 mm	7.849 mm	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	02 04 06	
(4)	6	ASNA2529-5	NUT	(0.3075 in)	(0.3090 in)			
				OR				
(3)	15	EN6115K5-8	BOLT	7.900 mm	7.940 mm	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 04 05 06	
(4)	6	ASNA2529-5	NUT	(0.3111 in)	(0.3125 in)			
	47	NSA5379-5W	WASHER					

NOTE:

- 01 > FRAME FOOT PORTION TO CUT.
- 02 > IF (EDGE DISTANCE) / (DIAMETER HOLE + 1.60) < 1.27 AND (EDGE DISTANCE) / (DIAMETER HOLE + 0.80) ≥ 1.30 AND DIAMETER HOLE > 7.920 mm (0.3119 in), INSTALL A BUSH.
- 03 > PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JIME4.
- 04 > IF SPOTFACING NECESSARY CONTACT AIRBUS.
- 05 > VALID ONLY IF THE BUSH IS INSTALLED.
- 06 > OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).

Figure A-FDCAA - Sheet 02
Replacement of the Fastener on Holes H9 to H10 of Frame 43

**CONF 002, 004 thru 005



NOTE:
+ FASTENER NOT AFFECTED.
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

Figure A-FDCAB - Sheet 01
Replacement of the Fastener on Holes H9 to H10 of Frame 43

**CONF 002, 004 thru 005

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
⊕	(3)	17	EN6115K5X5	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT				
	(3)	18	EN6115K5-5	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	02 04 06
	(4)	6	ASNA2529-5	NUT				
	(3)	16	EN6115K5Y6	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT				
			7	NSA5368-516B	WASHER			
	(3)	15	EN6115K5-6	BOLT	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 04 05 06
	(4)	6	ASNA2529-5	NUT				
			47	NSA5379-5W	WASHER			
	(3)	3	EN6115K6-7	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	02 04 06
	(4)	4	ASNA2529-6	NUT				
⊖	(3)	5	EN6115K5Y8	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT				
			7	NSA5368-516B	WASHER			
	(3)	19	EN6115K5-8	BOLT	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 04 05 06
	(4)	6	ASNA2529-5	NUT				
			47	NSA5379-5W	WASHER			

NOTE:

- 01 IF THE FRAME FOOT IS NOT CUT, PORTION TO CUT.
- 02 IF (EDGE DISTANCE) / (DIAMETER HOLE + 1.60) < 1,27 AND (EDGE DISTANCE) / (DIAMETER HOLE + 0.80) ≥ 1.30 AND DIAMETER HOLE > 7.920 mm (0.3119 in), INSTALL A BUSH.
- 03 PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JME4.
- 04 IF SPOTFACING NECESSARY CONTACT AIRBUS.
- 05 VALID ONLY IF THE BUSH IS INSTALLED.
- 06 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9,427 mm (0,3711 in)).

Figure A-FDCAB - Sheet 02
Replacement of the Fastener on Holes H9 to H10 of Frame 43

**CONF 001, 003

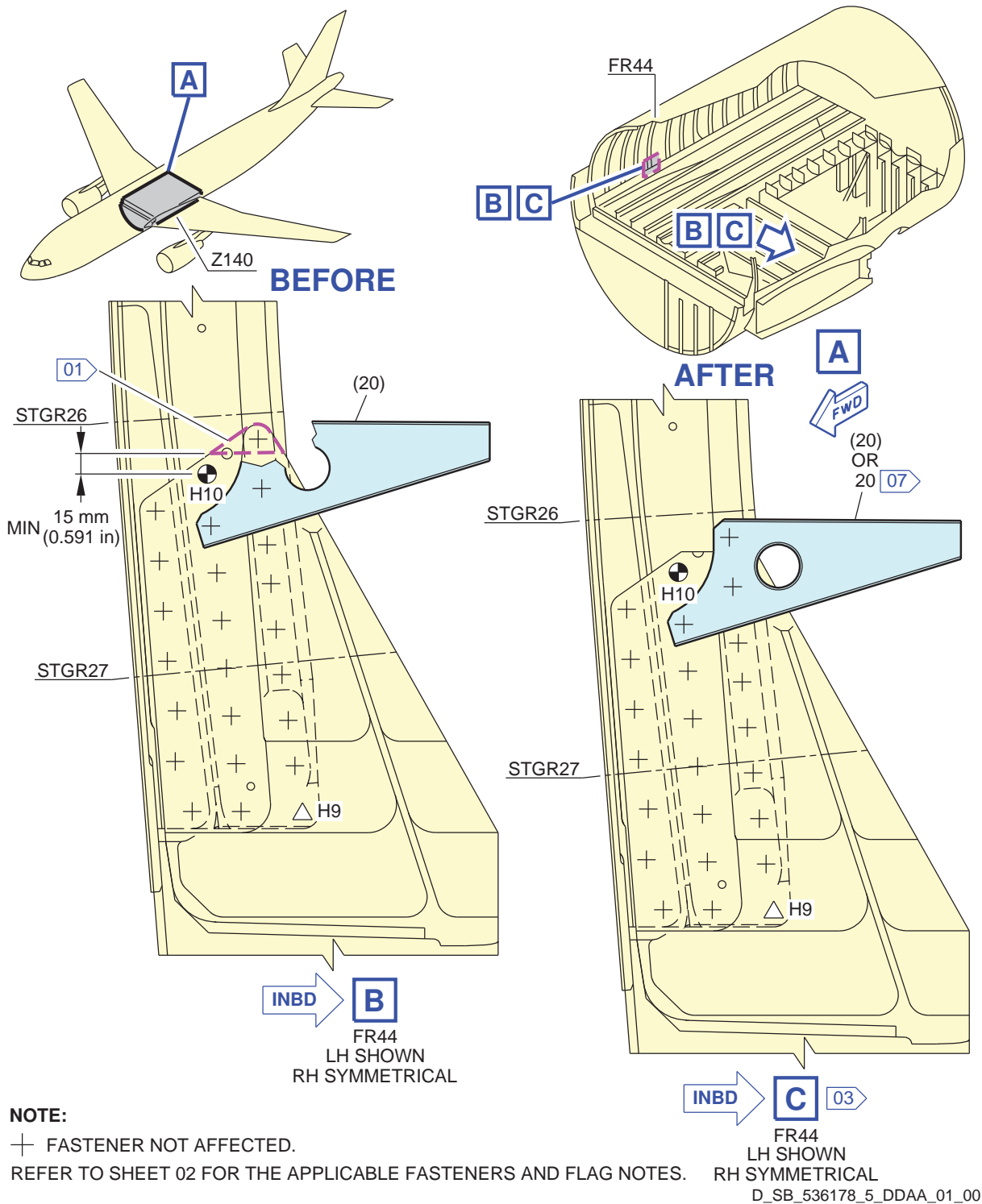


Figure A-FDDAA - Sheet 01
Replacement of the Fastener on Holes H9 to H10 of Frame 44

**CONF 001, 003

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
	(3)	13	EN6115K5Y7	BOLT	8.602 mm	8.642 mm	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT	(0.3387 in)	(0.3402 in)		
		7	NSA5368-516B	WASHER				
●	(3)	14	EN6115K5X6	BOLT	8.206 mm	8.246 mm	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT	(0.3231 in)	(0.3246 in)		
							OR	
	(3)	15	EN6115K5-6	BOLT	7.809 mm	7.849 mm	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	02 04 06
	(4)	6	ASNA2529-5	NUT	(0.3075 in)	(0.3090 in)		
							OR	
	(3)	9	EN6115K5-7	BOLT	7.900 mm	7.940 mm	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 04 05 06
	(4)	6	ASNA2529-5	NUT	(0.3111 in)	(0.3125 in)		
							OR	
		47	NSA5379-5W	WASHER				
	(3)	26	EN6115K6-8	BOLT	9.387 mm	9.427 mm	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	02 04 06
	(4)	4	ASNA2529-6	NUT	(0.3696 in)	(0.3711 in)		
						OR		
(3)	27	EN6115K5Y9	BOLT	8.602 mm	8.642 mm	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	02 04 06	
(4)	6	ASNA2529-5	NUT	(0.3387 in)	(0.3402 in)			
						OR		
						OR		
(3)	28	EN6115K5X8	BOLT	8.206 mm	8.246 mm	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	02 04 06	
(4)	6	ASNA2529-5	NUT	(0.3231 in)	(0.3246 in)			
						OR		
(3)	19	EN6115K5-8	BOLT	7.809 mm	7.849 mm	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	02 04 06	
(4)	6	ASNA2529-5	NUT	(0.3074 in)	(0.3090 in)			
						OR		
(3)	19	EN6115K5-8	BOLT	7.900 mm	7.940 mm	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 04 05 06	
(4)	6	ASNA2529-5	NUT	(0.3111 in)	(0.3125 in)			
						OR		
	17	NSA5379-5W	WASHER					

NOTE:
 01 FRAME FOOT PORTION TO CUT.
 02 IF (EDGE DISTANCE) / (DIAMETER HOLE + 1.60) < 1.27 AND (EDGE DISTANCE) / (DIAMETER HOLE + 0.80) ≥ 1.30 AND DIAMETER HOLE > 7.920 mm (0.3119 in), INSTALL A BUSH.
 03 PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JIME4.
 04 IF SPOTFACING NECESSARY CONTACT AIRBUS.
 05 VALID ONLY IF THE BUSH IS INSTALLED.
 06 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.6 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).
 07 IF THE HOLES OF THE BRACKET, ITEM (20), IS MORE THAN 6.35 mm (0.250 in), INSTALL A NEW BRACKET ITEM 20.

Figure A-FDDAA - Sheet 02
Replacement of the Fastener on Holes H9 to H10 of Frame 44

**CONF 002, 004

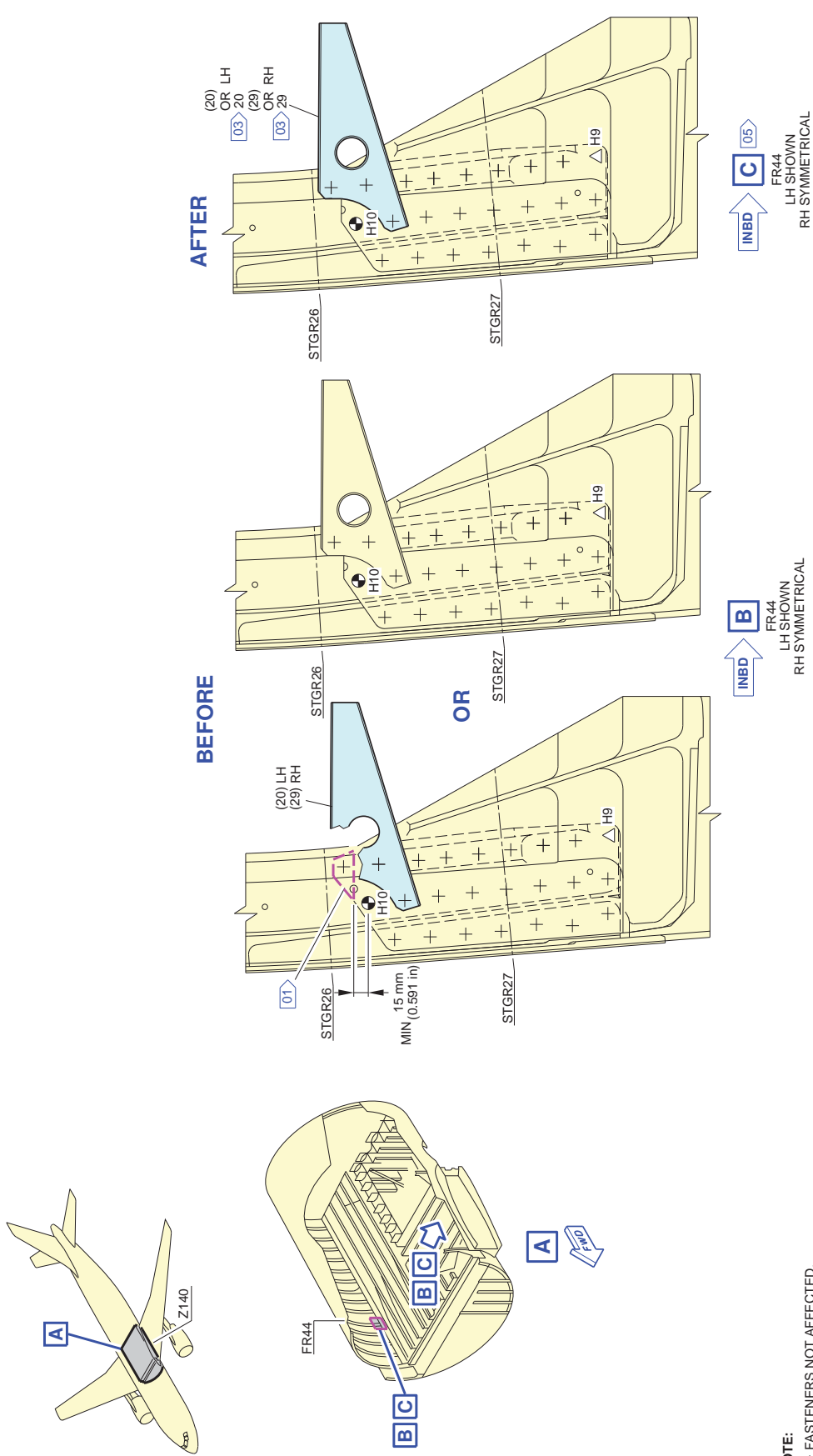


Figure A-FDDAB - Sheet 01
Replacement of the Fastener on Holes H9 to H10 of Frame 44

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
	(3)	14	EN6115K5X6	BOLT	8,206 mm (0.3231 in)	8,246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	02 06 08
	(4)	6	ASNA2529-5	NUT				
	(3)	15	EN6115K5-6	BOLT	7,809 mm (0.3075 in)	7,849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	02 06 08
	(4)	6	ASNA2529-5	NUT				
	(3)	13	EN6115K5Y7	BOLT	8,602 mm (0.3387 in)	8,642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	02 06 08
	(4)	6	ASNA2529-5	NUT				
		7	NSA5368-516B	WASHER				
	(3)	15	EN6115K5-6	BOLT	7,900 mm (0.3111 in)	7,940 mm (0.3125 in)	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 06 07 08
(4)	6	ASNA2529-5	NUT					
	47		NSA5379-5W	WASHER				
	(3)	26	EN6115K6-8	BOLT	9,387 mm (0.3696 in)	9,427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	02 06 08
(4)	4	ASNA2529-6	NUT					
	(3)	27	EN6115K5Y9	BOLT	8,602 mm (0.3387 in)	8,642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	02 06 08
	(4)	6	ASNA2529-5	NUT				
		7	NSA5368-516B	WASHER				
	(3)	19	EN6115K5-8	BOLT	7,900 mm (0.3111 in)	7,940 mm (0.3125 in)	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 06 07 08
(4)	6	ASNA2529-5	NUT					
		47	NSA5379-5W	WASHER				

NOTE:

- 01 IF THE FRAME FOOT IS NOT CUT, PORTION TO CUT.
- 02 IF (EDGE DISTANCE) / (DIAMETER HOLE + 1.60) < 1.27 AND (EDGE DISTANCE) / (DIAMETER HOLE + 0.80) ≥ 1.30 AND DIAMETER HOLE > 7.920 mm (0.3119 in), INSTALL A BUSH.
- 03 IF THE HOLE OF THE BRACKET ITEM (20) OR ITEM (29) IS GREATER THAN 6.35 mm (0.250 in), INSTALL A NEW BRACKET ITEM 20 OR ITEM 29.
- 04 FASTENERS TO BE REPLACED IF SUPPORT ITEM (20) OR ITEM (29) HAS TO BE REPLACED/REMOVED.
- 05 PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JME4.
- 06 IF SPOTFACING NECESSARY CONTACT AIRBUS.
- 07 VALID ONLY IF THE BUSH IS INSTALLED.
- 08 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).

Figure A-FDDAB - Sheet 02
Replacement of the Fastener on Holes H9 to H10 of Frame 44

**CONF 005

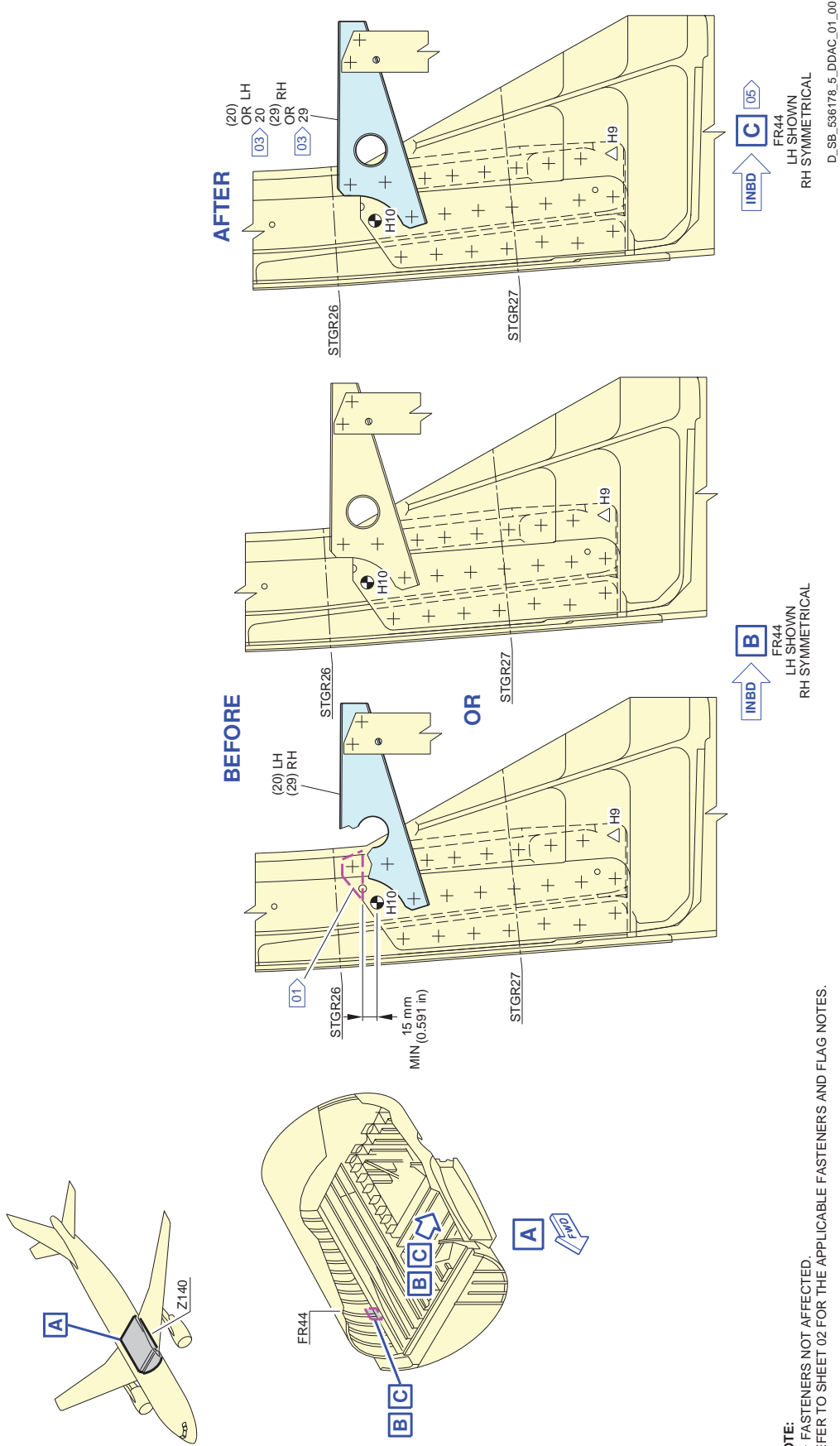


Figure A-FDDAC - Sheet 01
Replacement of the Fastener on Holes H9 to H10 of Frame 44

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
⊙	(3)	14	EN6115K5X6	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	02 06 07
	(4)	6	ASNA2529-5	NUT				
						OR		
	(3)	15	EN6115K5-6	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	02 06 07
	(4)	6	ASNA2529-5	NUT				
						OR		
	(3)	13	EN6115K5Y7	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	02 06 07
	(4)	6	ASNA2529-5	NUT				
		7	NSA5368-516B	WASHER				
						OR		
(3)	9	EN6115K5-7	BOLT	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 06 07	
(4)	6	ASNA2529-5	NUT					
	47	NSA5379-5W	WASHER					
					OR			
(3)	26	EN6115K6-8	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	02 06 07	
(4)	4	ASNA2529-6	NUT					
					OR			
△	(3)	27	EN6115K5Y9	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	02 06 07
	(4)	6	ASNA2529-5	NUT				
		7	NSA5368-516B	WASHER				
						OR		
	(3)	19	EN6115K5-8	BOLT	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 06 07
	(4)	6	ASNA2529-5	NUT				
		47	NSA5379-5W	WASHER				

NOTE:

- 01 IF THE FRAME FOOT IS NOT CUT, PORTION TO CUT.
- 02 IF (EDGE DISTANCE) / (DIAMETER HOLE + 1.60) < 1.27 AND (EDGE DISTANCE) / (DIAMETER HOLE + 0.80) ≥ 1.30 AND DIAMETER HOLE > 7.920 mm (0.3119 in), INSTALL A BUSH.
- 03 IF THE HOLE OF THE BRACKET ITEM (20) OR ITEM (29) IS GREATER THAN 6.35 mm (0.250 in), INSTALL A NEW BRACKET ITEM 20 OR ITEM 29.
- 04 FASTENERS TO BE REPLACED IF SUPPORT ITEM (20) OR ITEM (29) HAS TO BE REPLACED/REMOVED.
- 05 PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JME4.
- 06 IF SPOTFACING NECESSARY CONTACT AIRBUS.
- 07 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in)(MAXIMUM DIAMETER 9.427 mm (0.3711 in)).

Figure A-FDDAC - Sheet 02
Replacement of the Fastener on Holes H9 to H10 of Frame 44

**CONF 001, 003

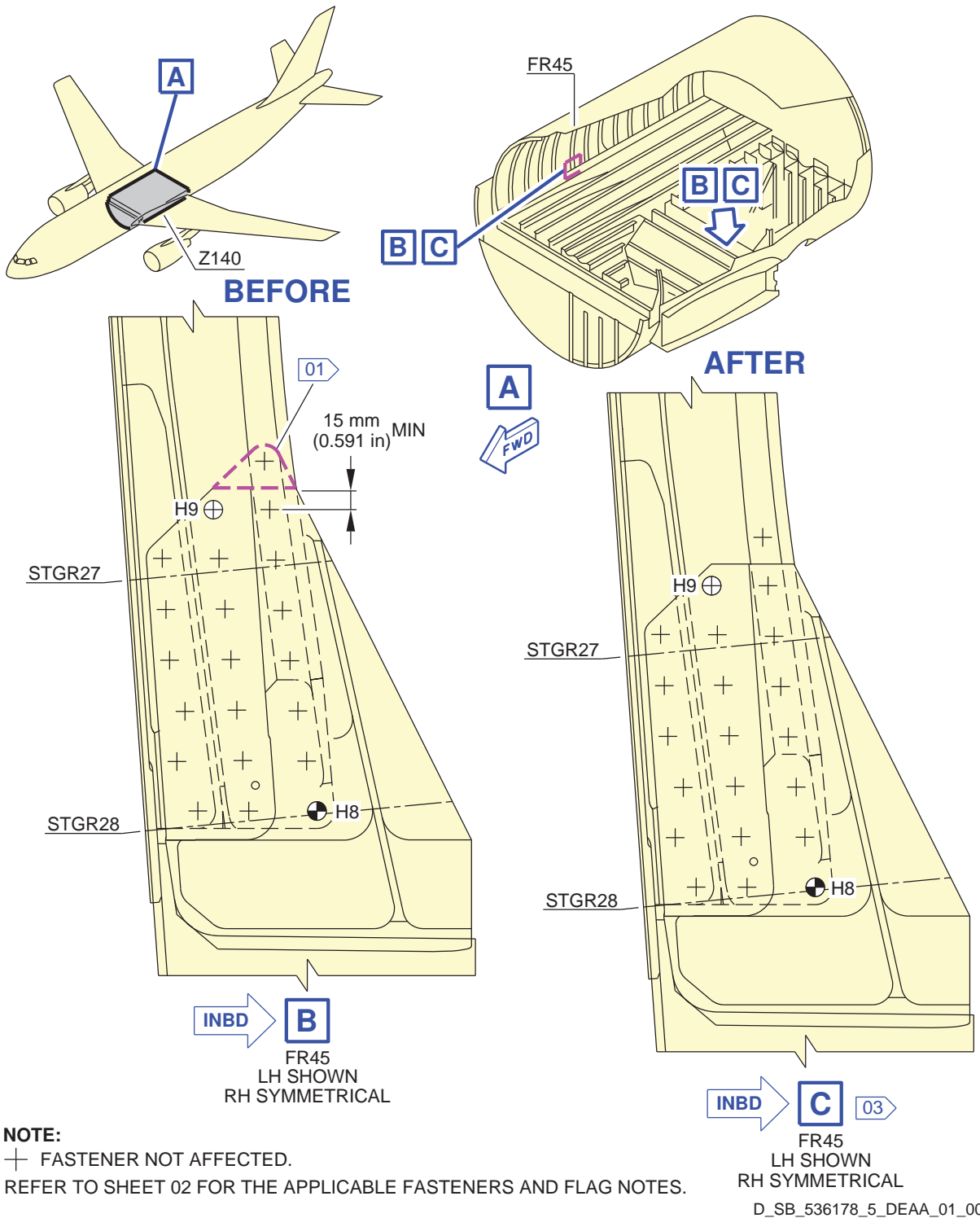


Figure A-FDEAA - Sheet 01
 Replacement of the Fastener on Holes H8 to H9 of Frame 45

**CONF 001, 003

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
	(3)	9	EN6115K5-7	BOLT	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 04 05 06
	(4)	6	ASNA2529-5	NUT				
		47	NSA5379-5W	WASHER				
⊕	(3)	13	EN6115K5Y7	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	02 04 06
	(4)	6	ASNA2529-5	NUT				
		7	NSA5368-516B	WASHER				
	(3)	14	EN6115K5X6	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT				
	(3)	15	EN6115K5-6	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT				
	(3)	15	EN6115K6-8	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	02 04 06
	(4)	4	ASNA2529-6	NUT				
	(3)	3	EN6115K5Y9	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	02 04 06
	(4)	6	ASNA2529-5	NUT				
		7	NSA5368-516B	WASHER				
●	(3)	5	EN6115K5X8	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT				
	(3)	8	EN6115K5-8	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT				
	(3)	8	EN6115K5-8	BOLT	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 04 05 06
	(4)	6	ASNA2529-5	NUT				
		47	NSA5379-5W	WASHER				

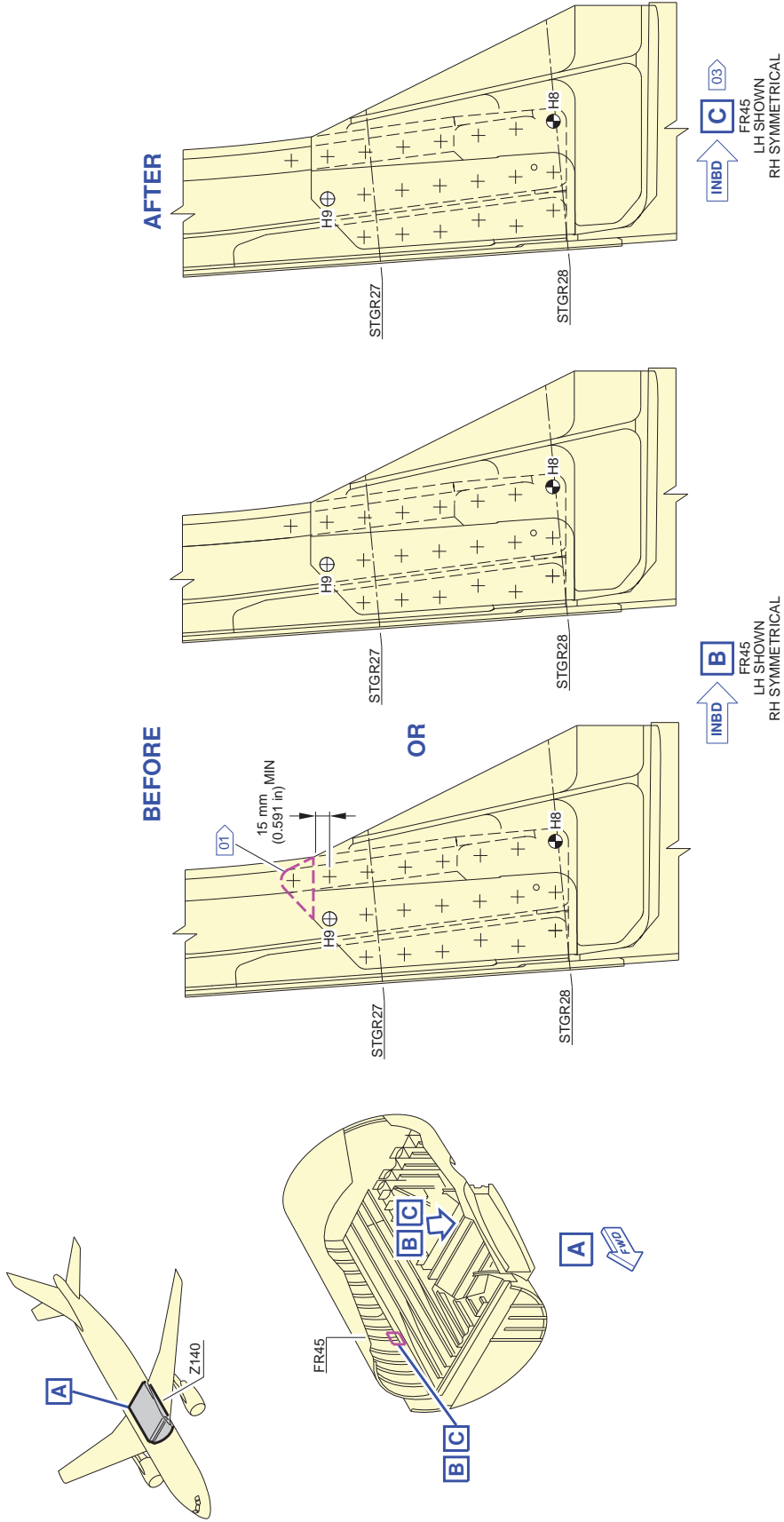
NOTE:

- 01 > FRAME FOOT PORTION TO CUT.
- 02 > IF (EDGE DISTANCE) / (DIAMETER HOLE + 1.60) < 1.27 AND (EDGE DISTANCE) / (DIAMETER HOLE + 0.80) ≥ 1.30 AND DIAMETER HOLE > 7.920 mm (0.3119 in), INSTALL A BUSH.
- 03 > PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JME4.
- 04 > IF SPOTFACING NECESSARY CONTACT AIRBUS.
- 05 > VALID ONLY IF THE BUSH IS INSTALLED.
- 06 > OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).

Figure A-FDEAA - Sheet 02

Replacement of the Fastener on Holes H8 to H9 of Frame 45

**CONF 002, 004 thru 005



NOTE:
+ FASTENER NOT AFFECTED.
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

Figure A-FDEAB - Sheet 01
Replacement of the Fastener on Holes H8 to H9 of Frame 45

**CONF 002, 004 thru 005

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
	(3)	14	EN6115K5X6	BOLT	8.206 mm	8.246 mm	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT	(0.3231 in)	(0.3246 in)		
	(3)	15	EN6115K5-6	BOLT	7.809 mm	7.849 mm	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	02 04 06
	(4)	6	ASNA2529-5	NUT	(0.3075 in)	(0.3090 in)		
⊕	(3)	9	EN6115K5-7	BOLT	7.900 mm	7.940 mm	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 04 06
	(4)	6	ASNA2529-5	NUT	(0.3111 in)	(0.3125 in)		
		47	NSA5379-5W	WASHER				
	(3)	13	EN6115K5Y7	BOLT	8.602 mm	8.642 mm	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	02 04 06
(4)	6	ASNA2529-5	NUT	(0.3387 in)	(0.3402 in)			
		7	NSA5368-516B	WASHER				
	(3)	26	EN6115K6-8	BOLT	9.387 mm	9.427 mm	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	02 04 06
(4)	4	ASNA2529-6	NUT	(0.3696 in)	(0.3711 in)			
⊖	(3)	27	EN6115K5Y9	BOLT	8.602 mm	8.642 mm	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	02 04 06
	(4)	6	ASNA2529-5	NUT	(0.3387 in)	(0.3402 in)		
		7	NSA5368-516B	WASHER				
	(3)	19	EN6115K5-8	BOLT	7.900 mm	7.940 mm	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 04 06
(4)	6	ASNA2529-5	NUT	(0.3111 in)	(0.3125 in)			
		47	NSA5379-5W	WASHER				

NOTE:

- 01 IF THE FRAME FOOT IS NOT CUT, PORTION TO CUT.
- 02 IF (EDGE DISTANCE) / (DIAMETER HOLE + 1.60) < 1.27 AND (EDGE DISTANCE) / (DIAMETER HOLE + 0.80) ≥ 1.30 AND DIAMETER HOLE > 7.920 mm (0.3119 in), INSTALL A BUSH.
- 03 PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JIME4.
- 04 IF SPOTFACING NECESSARY CONTACT AIRBUS.
- 05 VALID ONLY IF THE BUSH IS INSTALLED.
- 06 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).

Figure A-FDEAB - Sheet 02
Replacement of the Fastener on Holes H8 to H9 of Frame 45

**CONF 001, 003

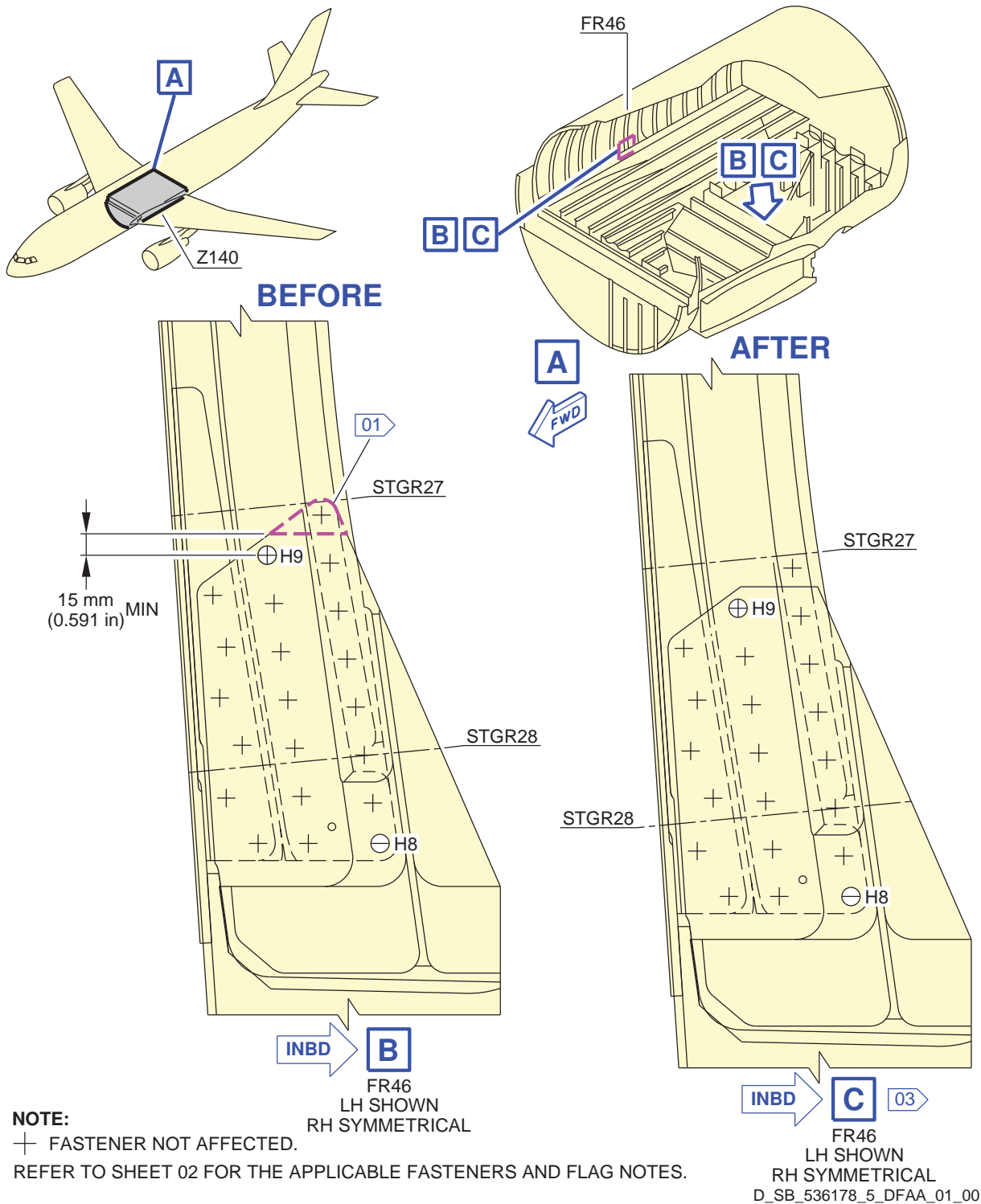


Figure A-FDFAA - Sheet 01
 Replacement of the Fastener on Holes H8 to H9 of Frame 46

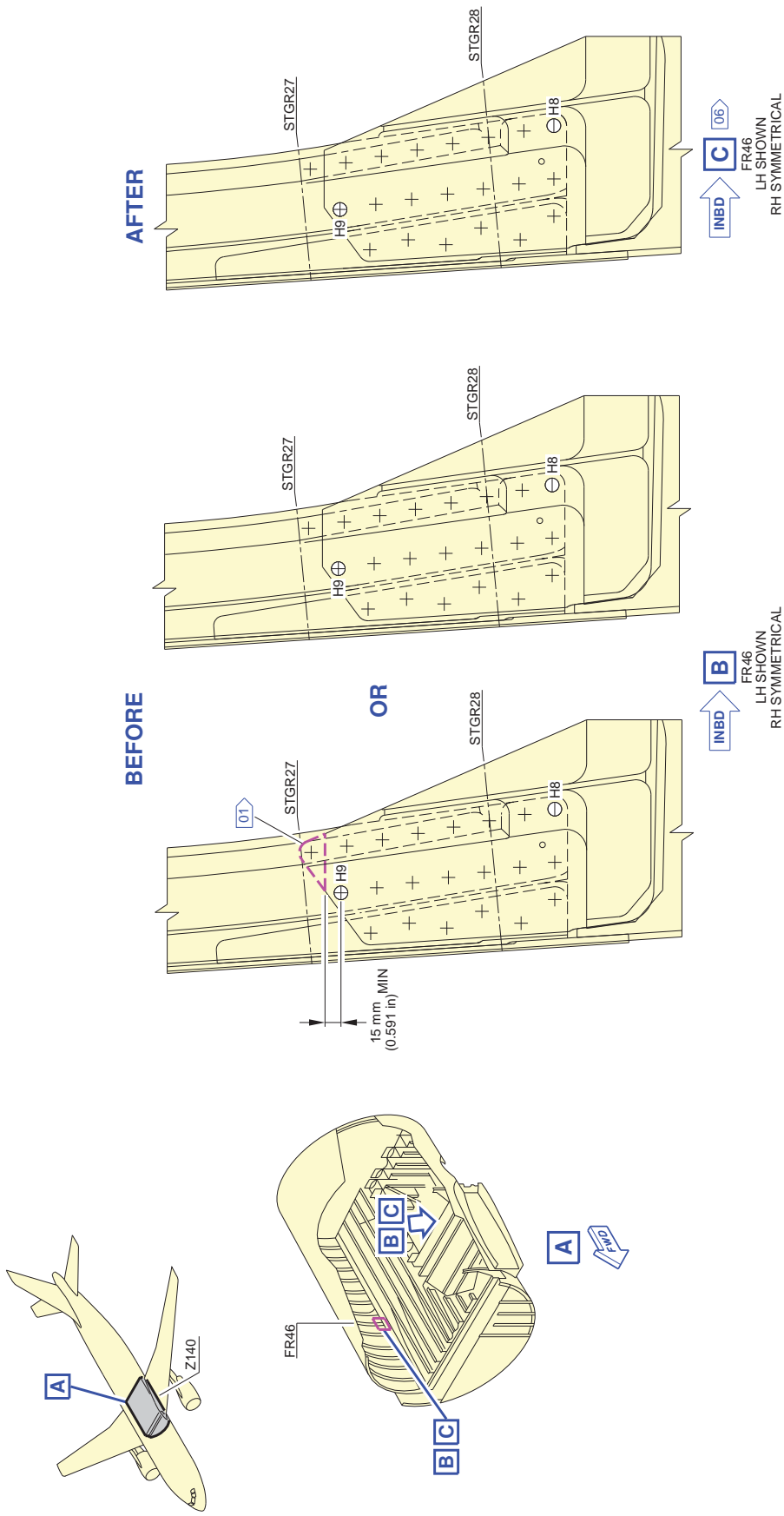
**CONF 001, 003

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE
					MIN	MAX		
⊖	(3)	26	EN6115K6-8	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	02 04 06
	(4)	4	ASNA2529-6	NUT	OR			
	(3)	27	EN6115K5Y9	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT	OR			
	(4)	7	NSA5368-516B	WASHER	OR			
	(3)	28	EN6115K5X8	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT	OR			
	(3)	19	EN6115K5-8	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	02 04 06
	(4)	6	ASNA2529-5	NUT	OR			
	(3)	19	EN6115K5-8	BOLT	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 04 05 06
	(4)	6	ASNA2529-5	NUT	OR			
	(47)			NSA5379-5W	WASHER	OR		
(3)	13	EN6115K5Y7	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	02 04 06	
(4)	6	ASNA2529-5	NUT	OR				
(4)	7	NSA5368-516B	WASHER	OR				
⊕	(3)	14	EN6115K5X6	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	02 04 06
	(4)	6	ASNA2529-5	NUT	OR			
	(3)	15	EN6115K5-6	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	02 04 06
	(4)	6	ASNA2529-5	NUT	OR			
	(3)	9	EN6115K5-7	BOLT	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 04 05 06
	(4)	6	ASNA2529-5	NUT	OR			
	(47)			NSA5379-5W	WASHER	OR		

NOTE:
 01 FRAME FOOT PORTION TO CUT.
 02 IF (EDGE DISTANCE) / (DIAMETER HOLE + 1.60) < 1.27, AND (EDGE DISTANCE) / (DIAMETER HOLE + 0.80) ≥ 1.30 AND DIAMETER HOLE > 7.920 mm (0.3119 in), INSTALL A BUSH.
 03 PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04IME4.
 04 IF SPOTFACING NECESSARY CONTACT AIRBUS.
 05 VALID ONLY IF THE BUSH IS INSTALLED.
 06 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).

Figure A-FDFAA - Sheet 02
 Replacement of the Fastener on Holes H8 to H9 of Frame 46
 SERVICE BULLETIN No.: A300-53-6178
 DATE: Mar 17/15
 REVISION No.: 01 - Sep 20/19
 Page: 1553

**CONF 002, 004 thru 005



NOTE:
+ FASTENER NOT AFFECTED.
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS AND FLAG NOTES.

Figure A-DFAB - Sheet 01
Replacement of the Fastener on Holes H8 to H9 of Frame 46

**CONF 002, 004 thru 005

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	HOLE DIAMETER		REMARKS	NOTE	
					MIN	MAX			
⊖	(3)	3	EN6115K6-8	BOLT	9.387 mm (0.3696 in)	9.427 mm (0.3711 in)	FASTENERS IN HIGH INTERFERENCE FIT NEXT NOMINAL DIAMETER	02 03 05	
	(4)	4	ASNA2529-6	NUT					
							OR		
	(3)	5	EN6115K5Y9	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	02 03 05	
	(4)	6	ASNA2529-5	NUT					
							OR		
		(3)	19	EN6115K5-8	BOLT	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 03 04 05
	(4)	6	ASNA2529-5	NUT					
							OR		
	(3)	13	EN6115K5Y7	BOLT	8.602 mm (0.3387 in)	8.642 mm (0.3402 in)	FASTENERS IN HIGH INTERFERENCE FIT SECOND OVERSIZE	02 03 05	
	(4)	6	ASNA2529-5	NUT					
							OR		
⊕	(3)	15	EN6115K5-7	BOLT	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	FASTENERS IN TRANSITION FIT NOMINAL DIAMETER	02 03 04 05	
	(4)	6	ASNA2529-5	NUT					
							OR		
		(3)	14	EN6115K5X6	BOLT	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FASTENERS IN HIGH INTERFERENCE FIT FIRST OVERSIZE	02 03 05
		(4)	6	ASNA2529-5	NUT				
							OR		
		(3)	15	EN6115K5-6	BOLT	7.809 mm (0.3075 in)	7.849 mm (0.3090 in)	FASTENERS IN HIGH INTERFERENCE FIT NOMINAL DIAMETER	02 03 05
	(4)	6	ASNA2529-5	NUT					

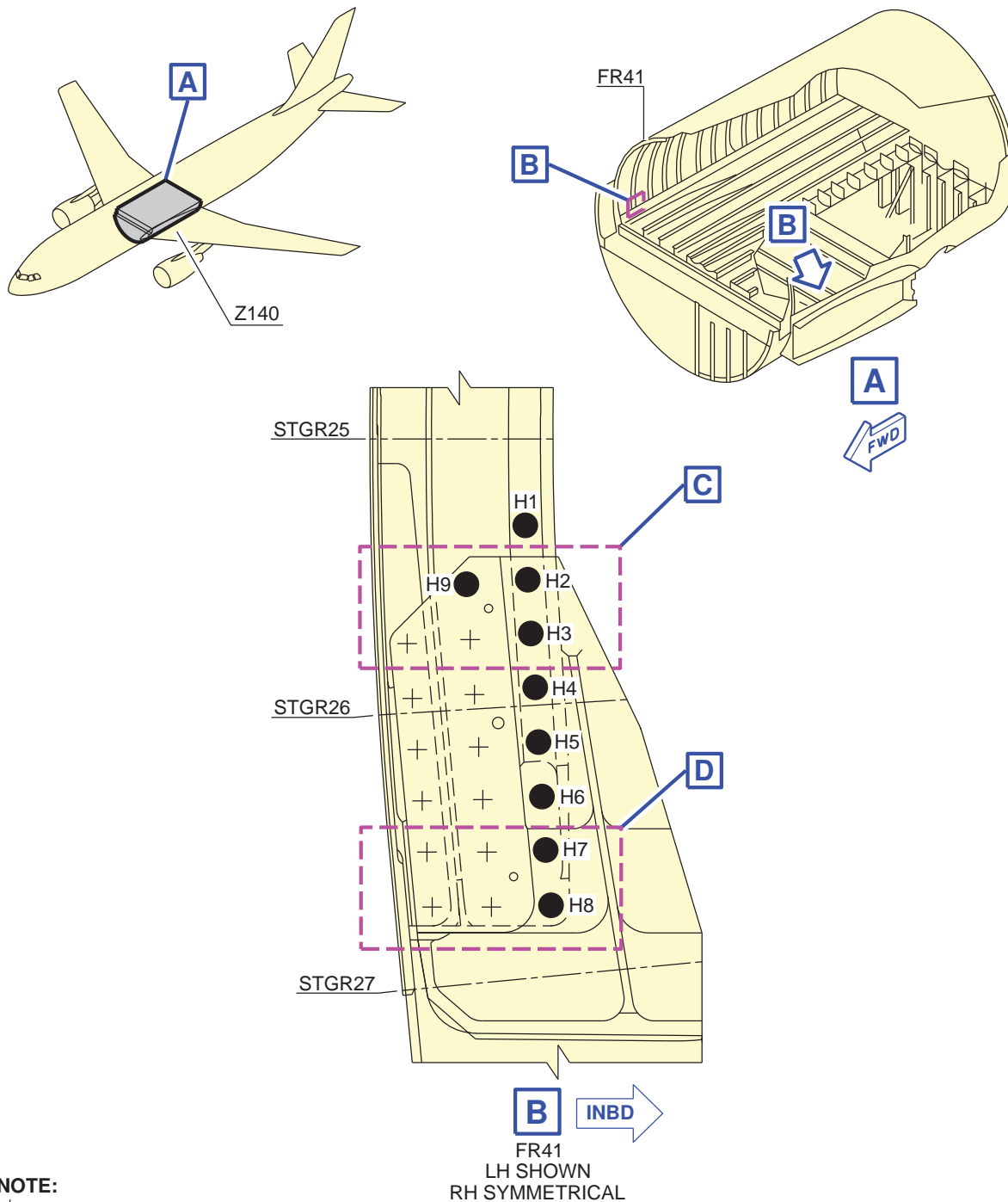
NOTE:

- 01 IF THE FRAME FOOT IS NOT CUT, PORTION TO CUT.
- 02 IF (EDGE DISTANCE) / (DIAMETER HOLE + 1.60) < 1.27 AND (EDGE DISTANCE) / (DIAMETER HOLE + 0.80) ≥ 1.30 AND DIAMETER HOLE > 7.920 mm (0.3119 in), INSTALL A BUSH.
- 03 IF SPOTFACING NECESSARY CONTACT AIRBUS.
- 04 VALID ONLY IF THE BUSH IS INSTALLED.
- 05 OVERSIZE THE HOLE TO THE EXISTING DIAMETER PLUS 1.60 mm (0.063 in) (MAXIMUM DIAMETER 9.427 mm (0.3711 in)).
- 06 PROTECT WITH PRIMER MATERIAL No 04EAC2 AND APPLY FINISH MATERIAL No 04JME4.

Figure A-FDFAB - Sheet 02

Replacement of the Fastener on Holes H8 to H9 of Frame 46

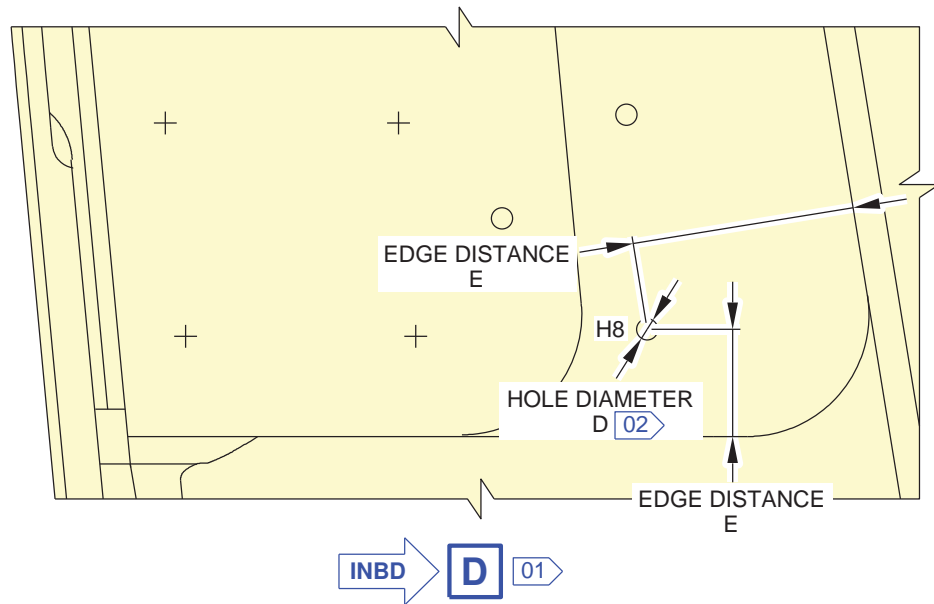
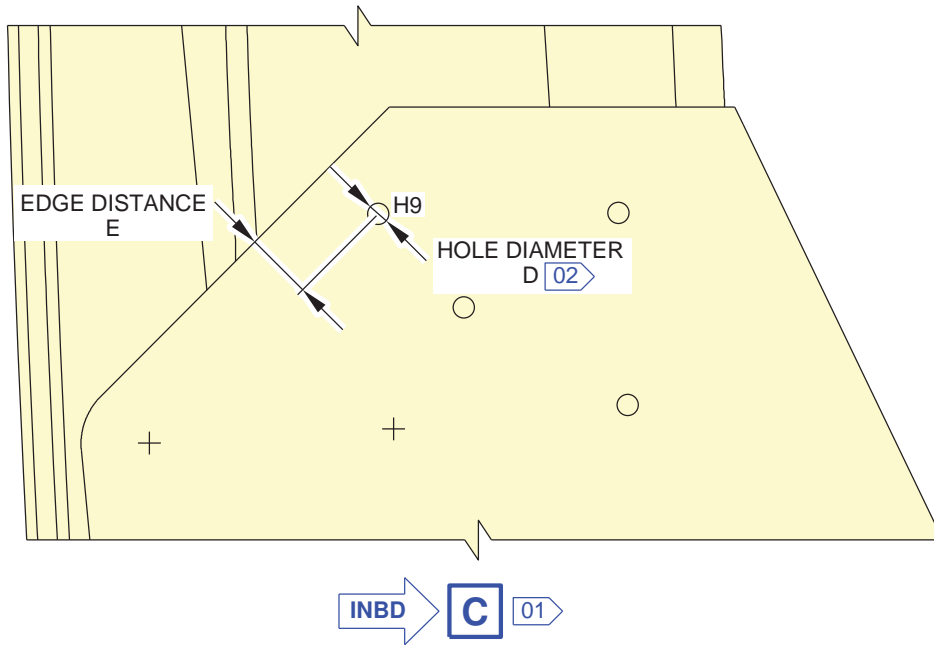
****CONF ALL**



D_SB_536178_5_EAAA_01_00

Figure A-FEAAA - Sheet 01
Inspection of the Holes on Frame 41

****CONF ALL**



NOTE:

+ FASTENER NOT AFFECTED.

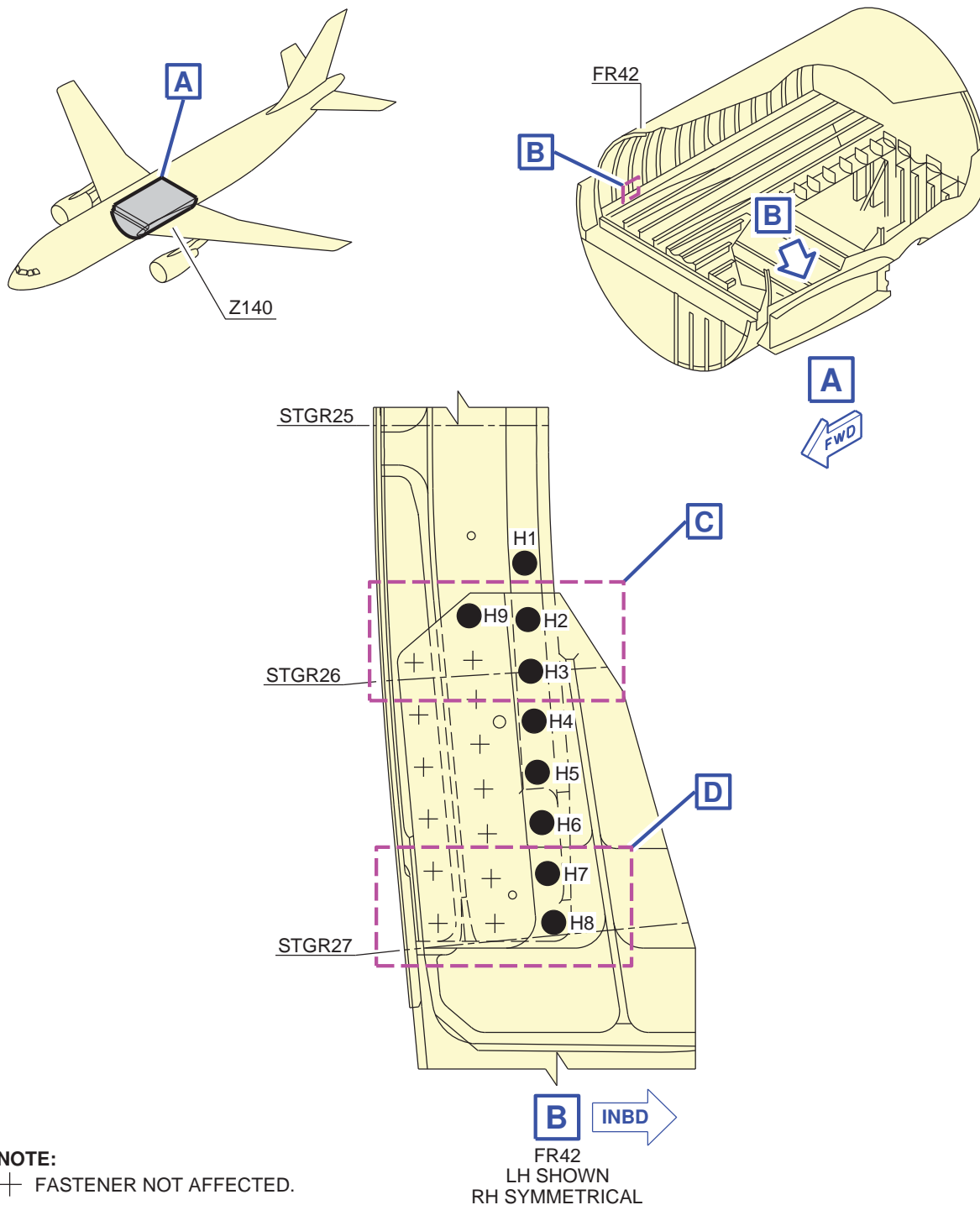
[01] IF $\frac{E}{(D+1.6)} < 1.30$, CONTACT AIRBUS.

[02] IF $D > 7.920 \text{ mm (0.3119 in)}$, CONTACT AIRBUS.

D_SB_536178_5_EAAA_02_02

Figure A-FEAAA - Sheet 02
Inspection of the Holes on Frame 41

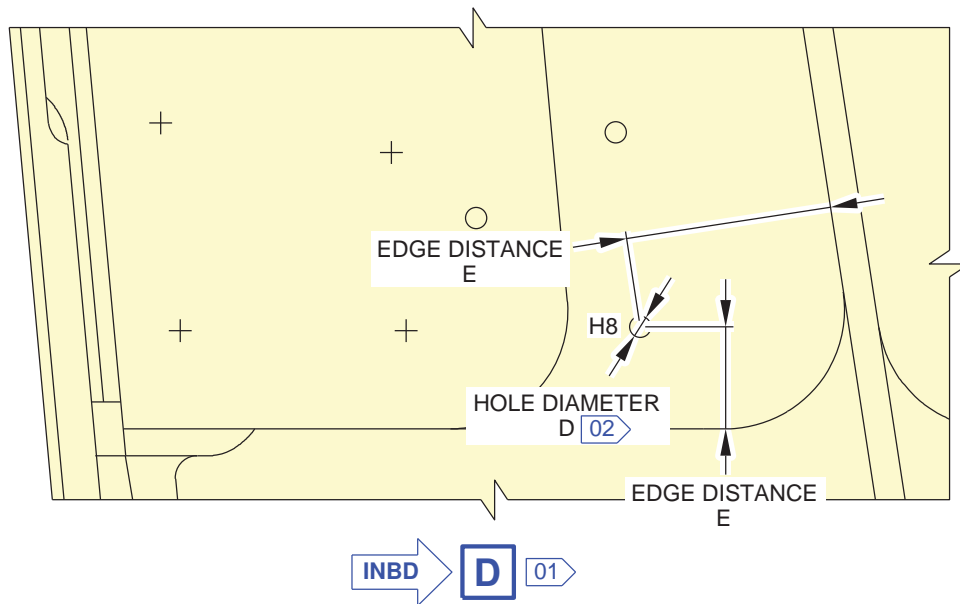
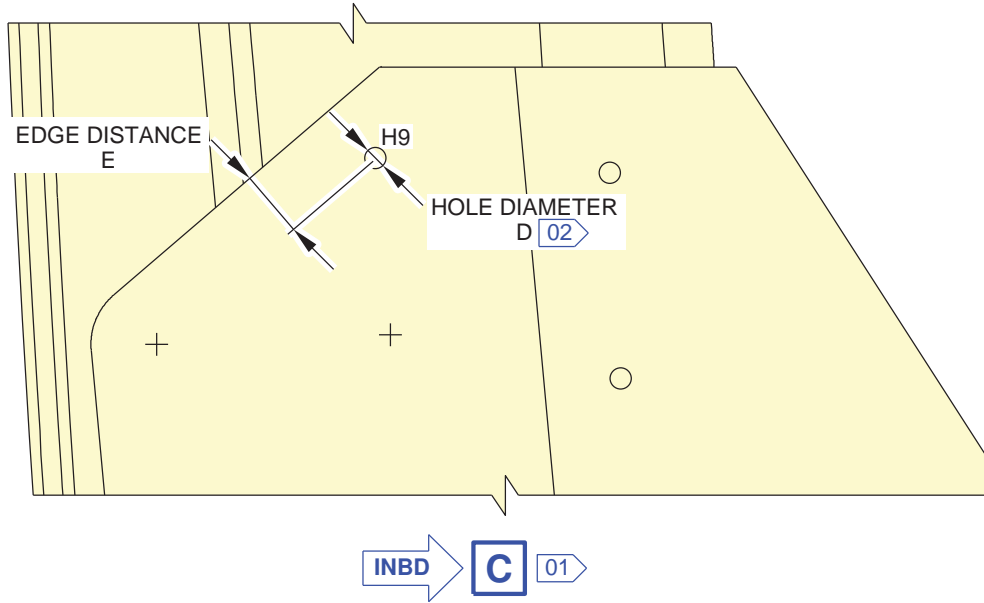
**CONF ALL



D_SB_536178_5_EBAA_01_00

Figure A-FEBAA - Sheet 01
Inspection of the Holes on Frame 42

****CONF ALL**



NOTE:

+ FASTENER NOT AFFECTED.

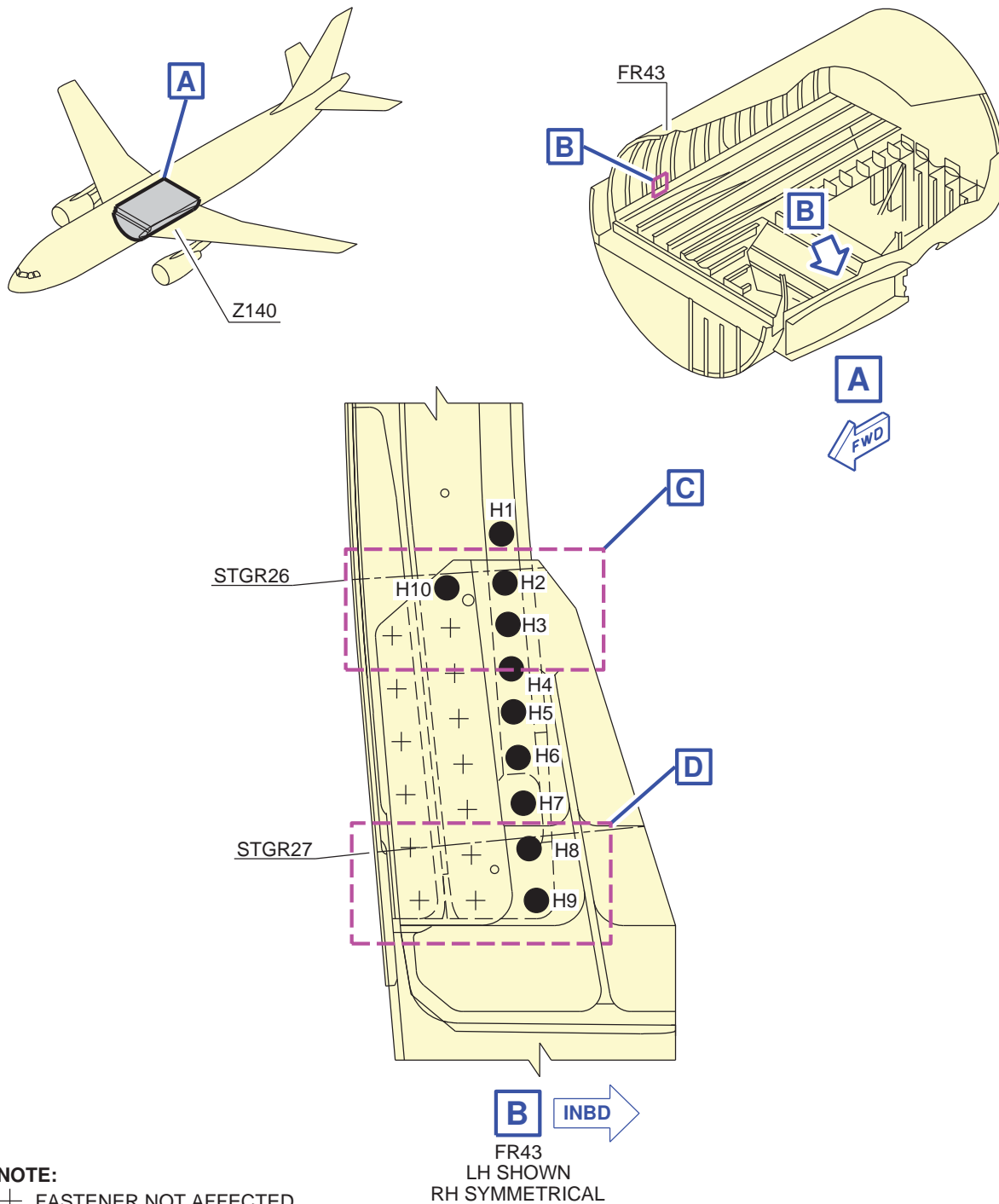
01 IF $\frac{E}{(D+1.6)} < 1.30$, CONTACT AIRBUS.

02 IF $D > 7.920$ mm (0.3119 in), CONTACT AIRBUS.

D_SB_536178_5_EBAA_02_02

Figure A-FEBAA - Sheet 02
Inspection of the Holes on Frame 42

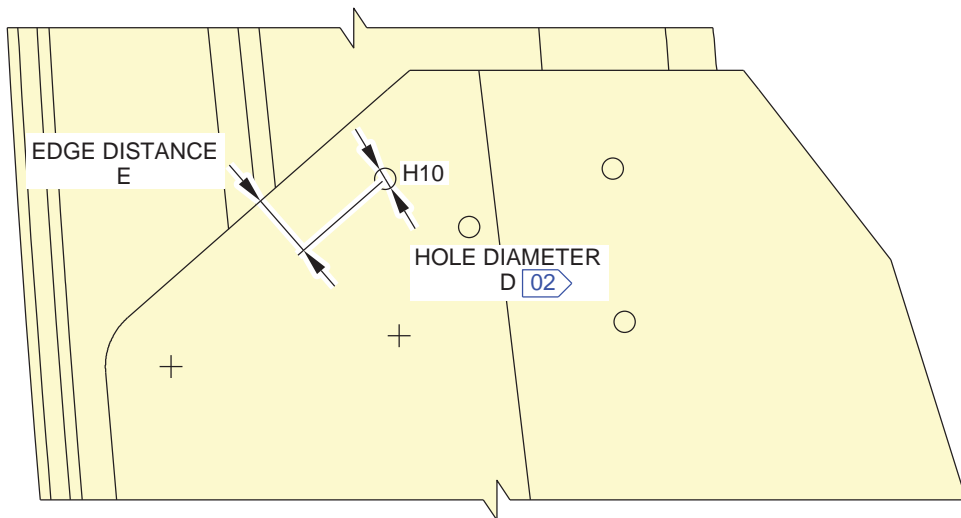
**CONF ALL



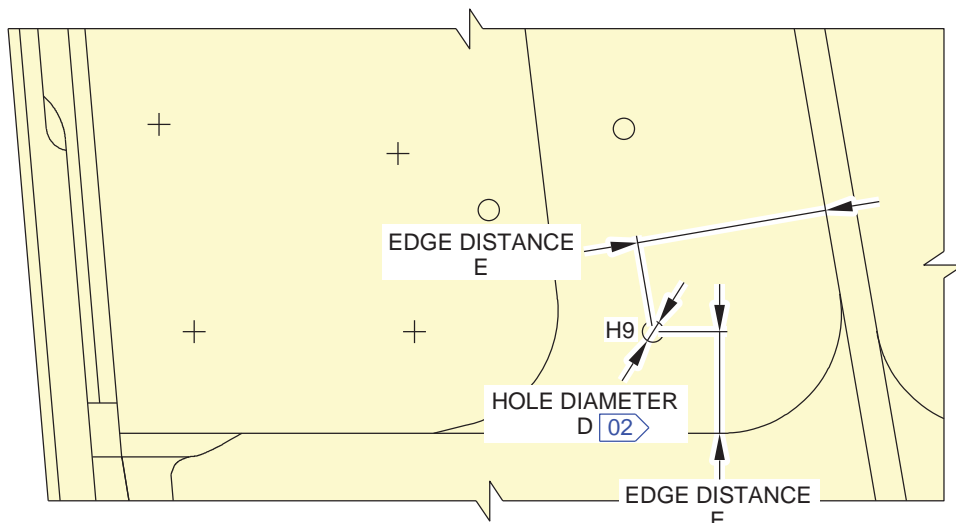
D_SB_536178_5_ECAA_01_00

Figure A-FECAA - Sheet 01
Inspection of the Holes on Frame 43

****CONF ALL**



INBD → **C** [01]



INBD → **D** [01]

NOTE:

+ FASTENER NOT AFFECTED.

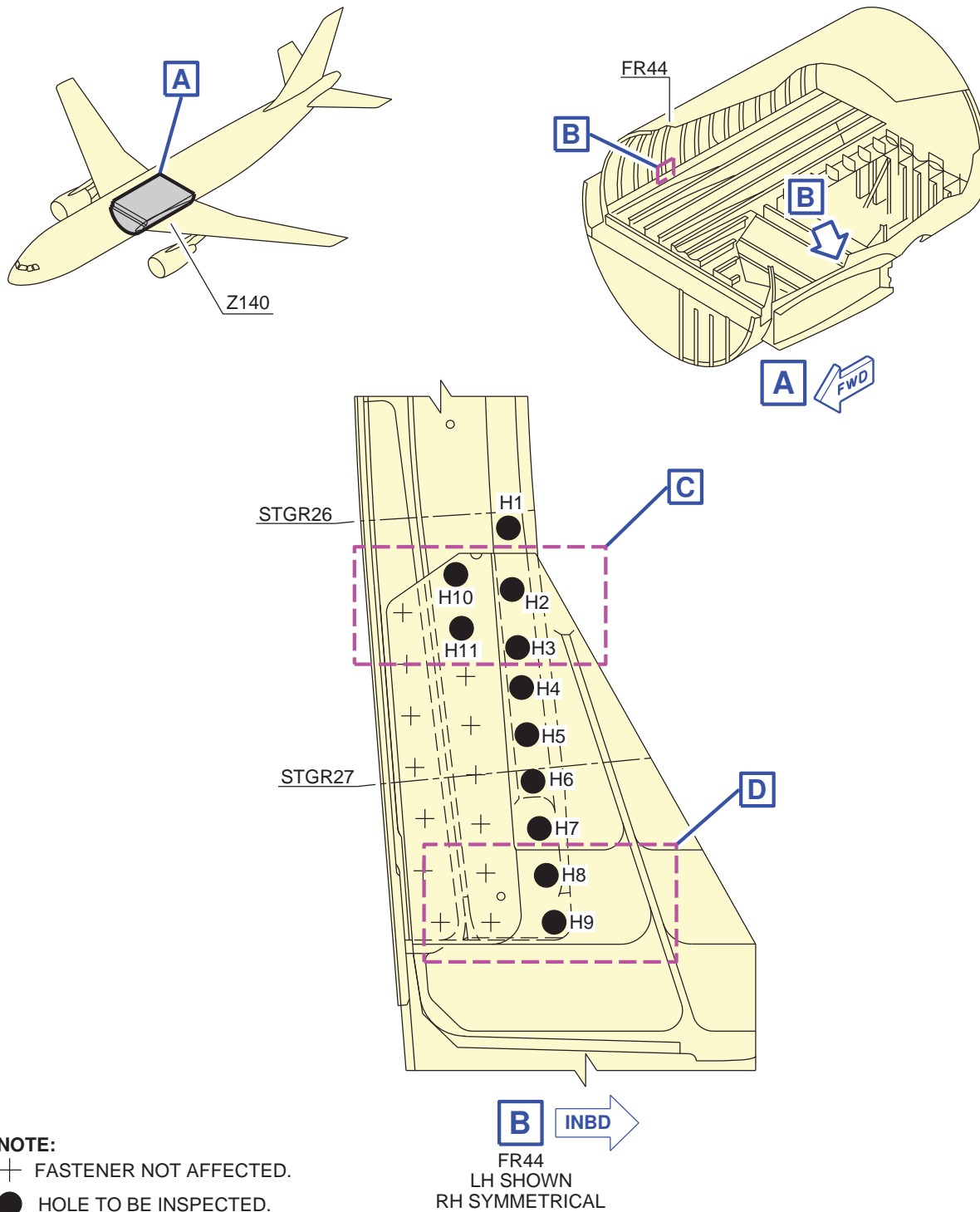
[01] IF $\frac{E}{(D+1.6)} < 1.30$, CONTACT AIRBUS.

[02] IF $D > 7.920$ mm (0.3119 in), CONTACT AIRBUS.

D_SB_536178_5_ECAA_02_02

Figure A-FECAA - Sheet 02
Inspection of the Holes on Frame 43

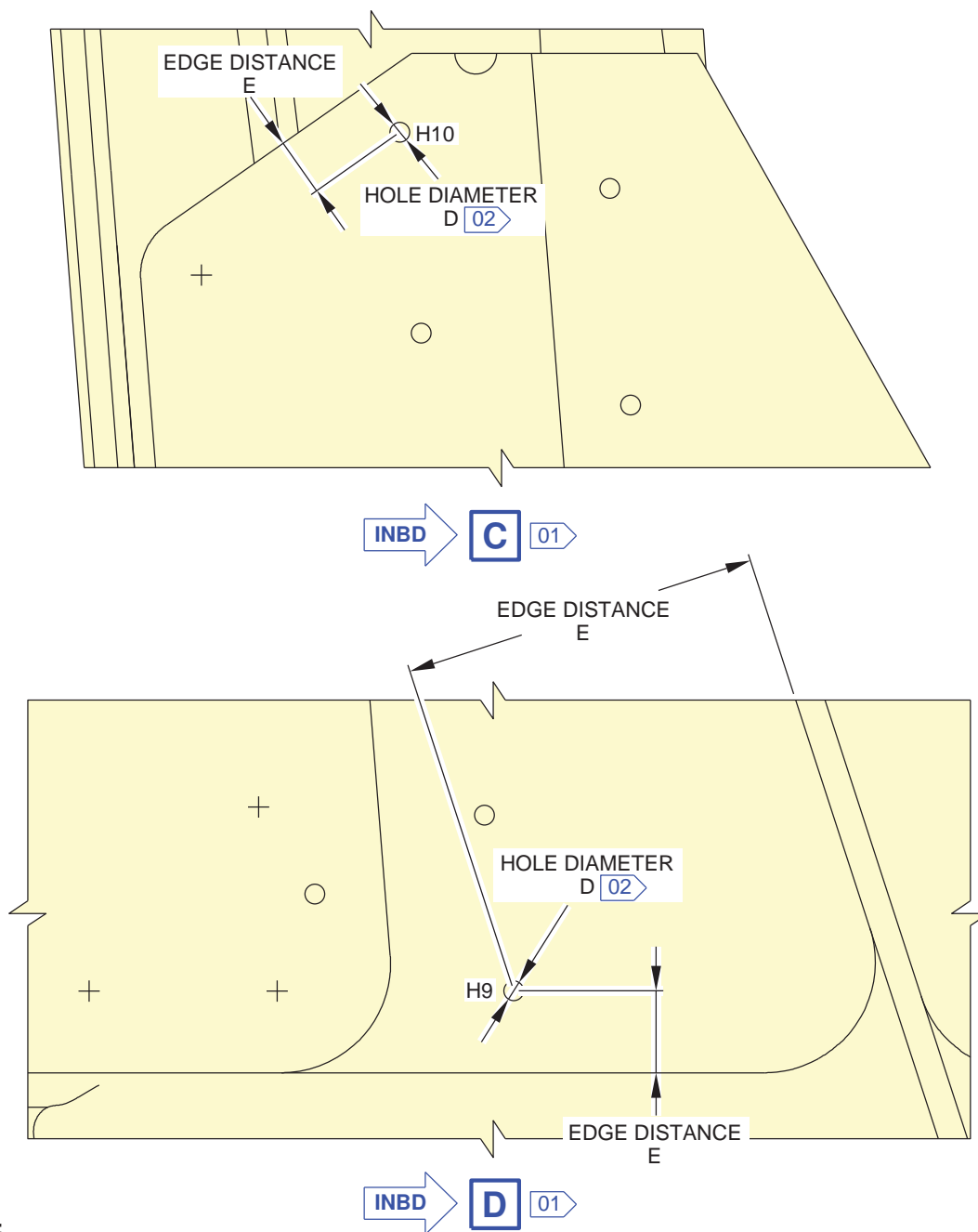
**CONF ALL



D_SB_536178_5_EDAA_01_00

Figure A-FEDAA - Sheet 01
Inspection of the Holes on Frame 44

****CONF ALL**



NOTE:

+ FASTENER NOT AFFECTED.

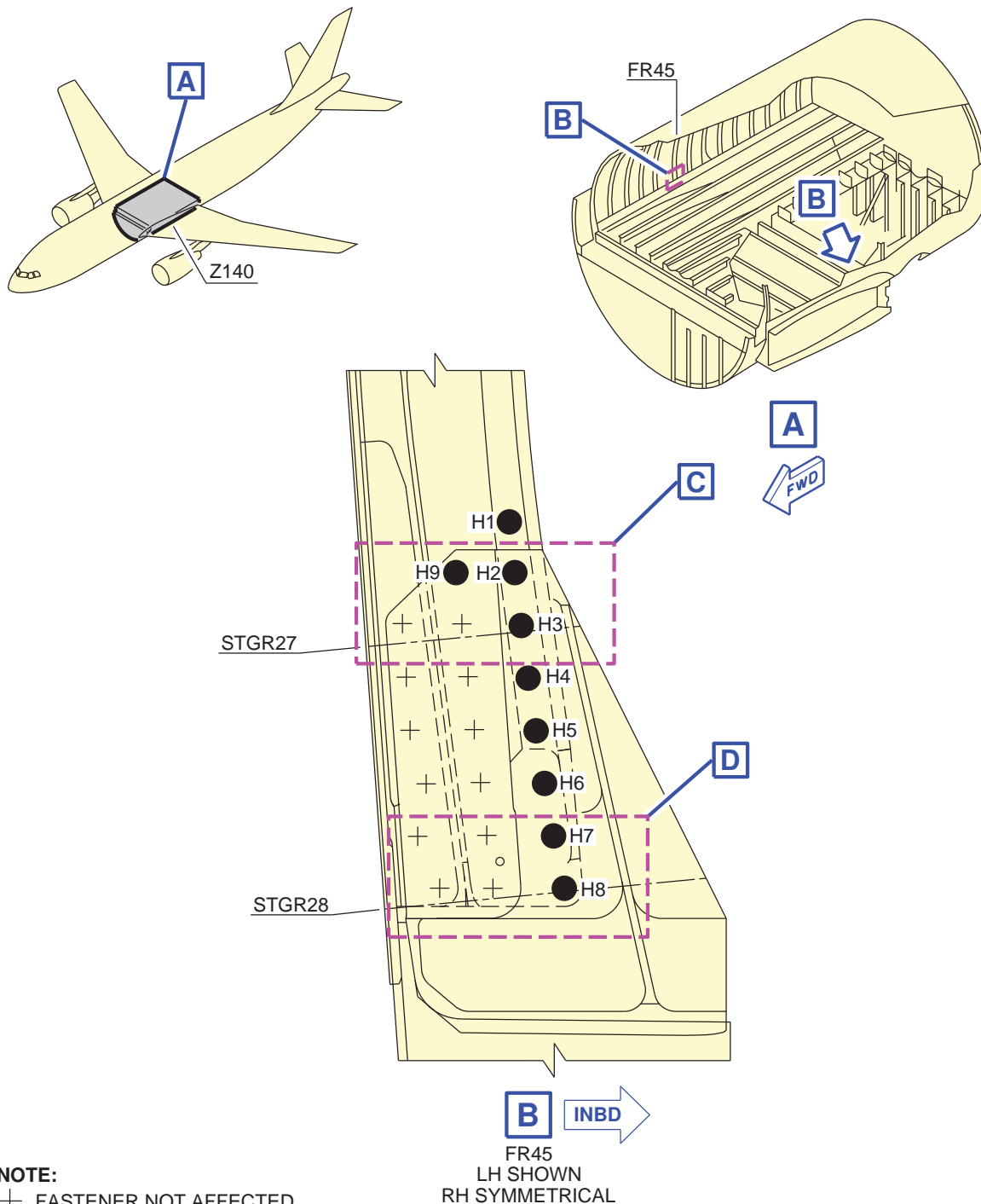
01 IF $\frac{E}{(D+1.6)} < 1.30$, CONTACT AIRBUS.

02 IF $D > 7.920\text{mm}$ (0.3119 in), CONTACT AIRBUS.

D_SB_536178_5_EDAA_02_02

Figure A-FEDAA - Sheet 02
Inspection of the Holes on Frame 44

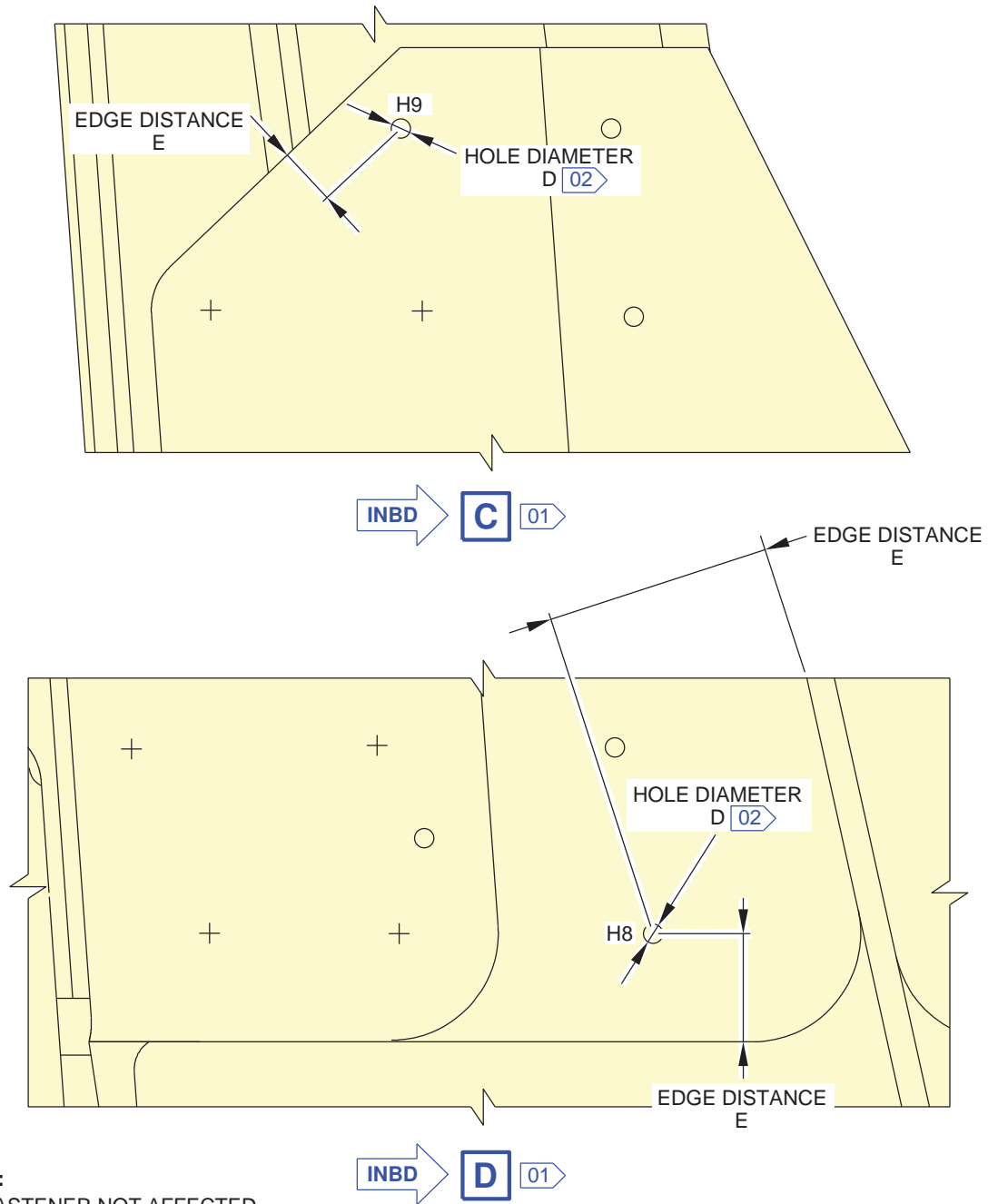
****CONF ALL**



D_SB_536178_5_EGAA_01_00

Figure A-FEGAA - Sheet 01
Inspection of the Holes on Frame 45

****CONF ALL**



NOTE:

+ FASTENER NOT AFFECTED.

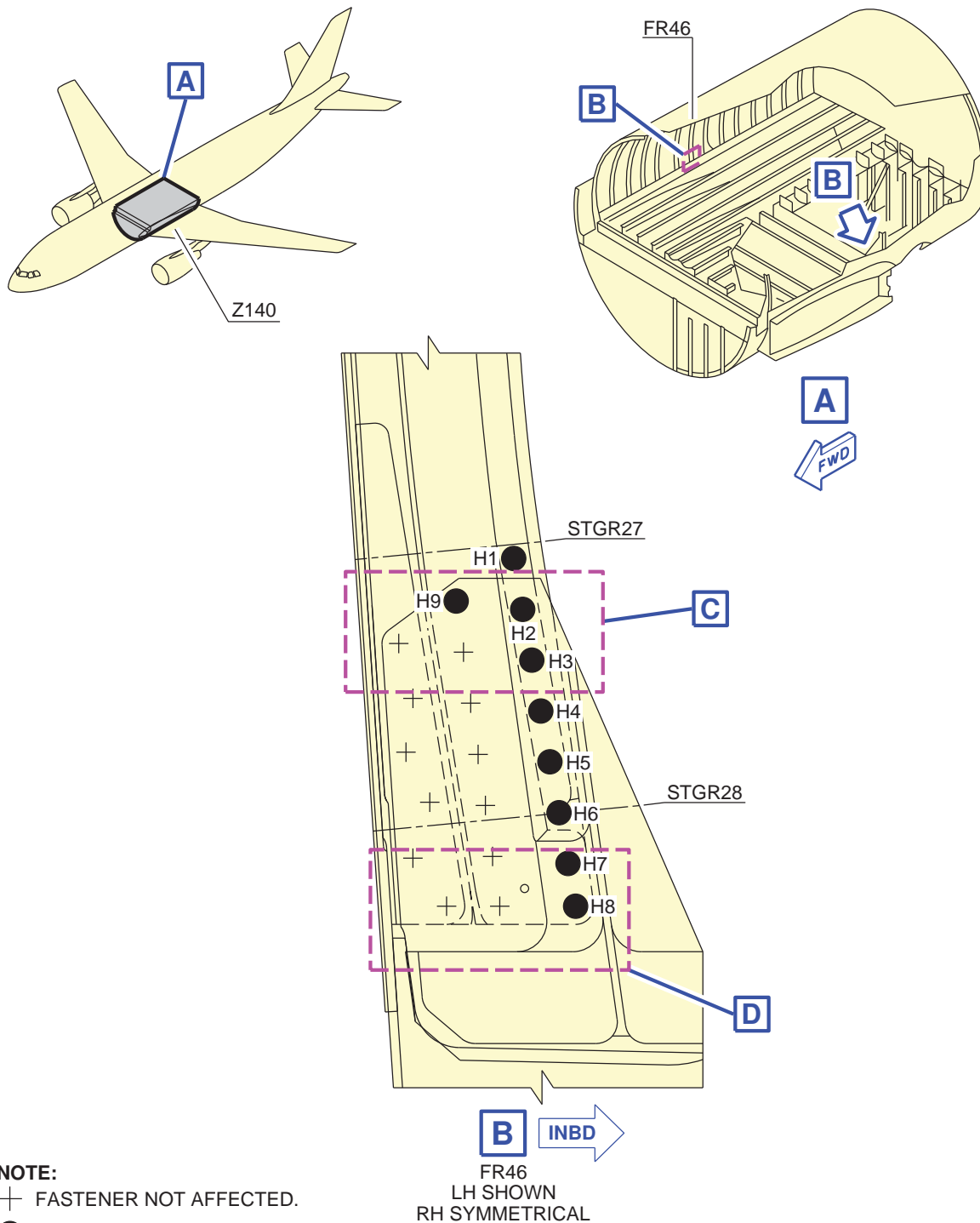
01 IF $\frac{E}{(D+1.6)} < 1.30$, CONTACT AIRBUS.

02 IF $D > 7.920$ mm (0.3119 in), CONTACT AIRBUS.

D_SB_536178_5_EGAA_02_02

Figure A-FEGAA - Sheet 02
Inspection of the Holes on Frame 45

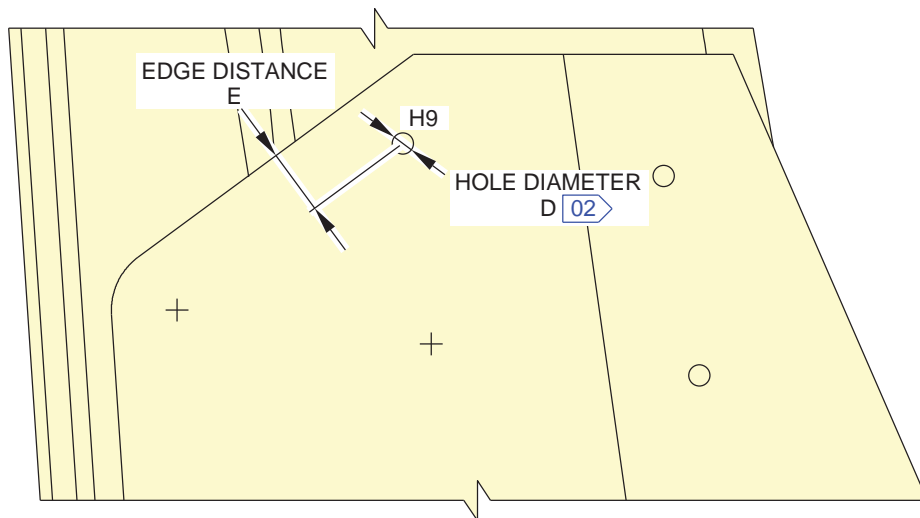
****CONF ALL**



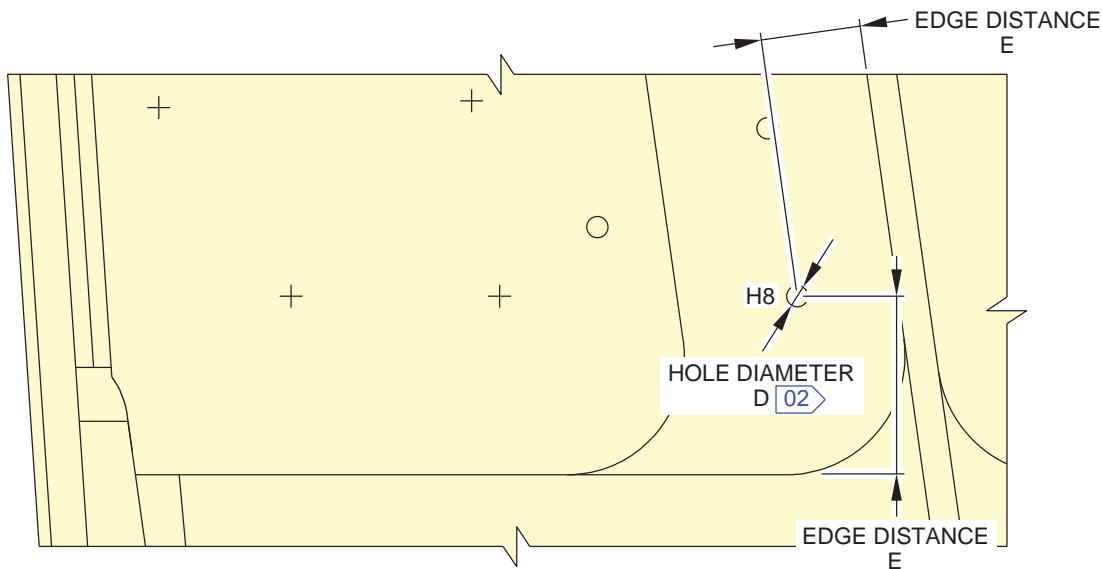
D_SB_536178_5_EFAA_01_00

Figure A-FEFAA - Sheet 01
 Inspection of the Holes on Frame 46

****CONF ALL**



INBD → **C** 01



INBD → **D** 01

NOTE:

+ FASTENER NOT AFFECTED.

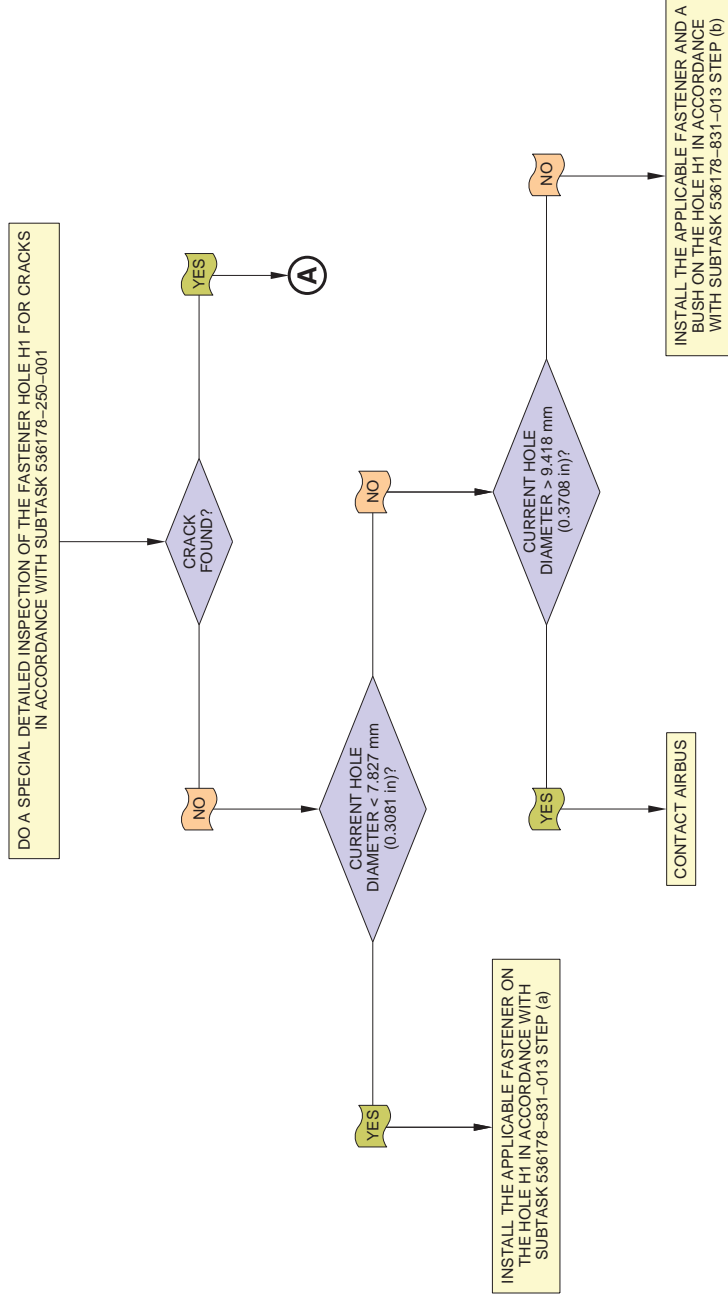
01 IF $\frac{E}{(D+1.6)} < 1.30$, CONTACT AIRBUS.

02 IF $D > 7.920$ mm (0.3119 in), CONTACT AIRBUS.

D_SB_536178_5_EFAA_02_02

Figure A-FEFAA - Sheet 02
Inspection of the Holes on Frame 46

**CONF ALL

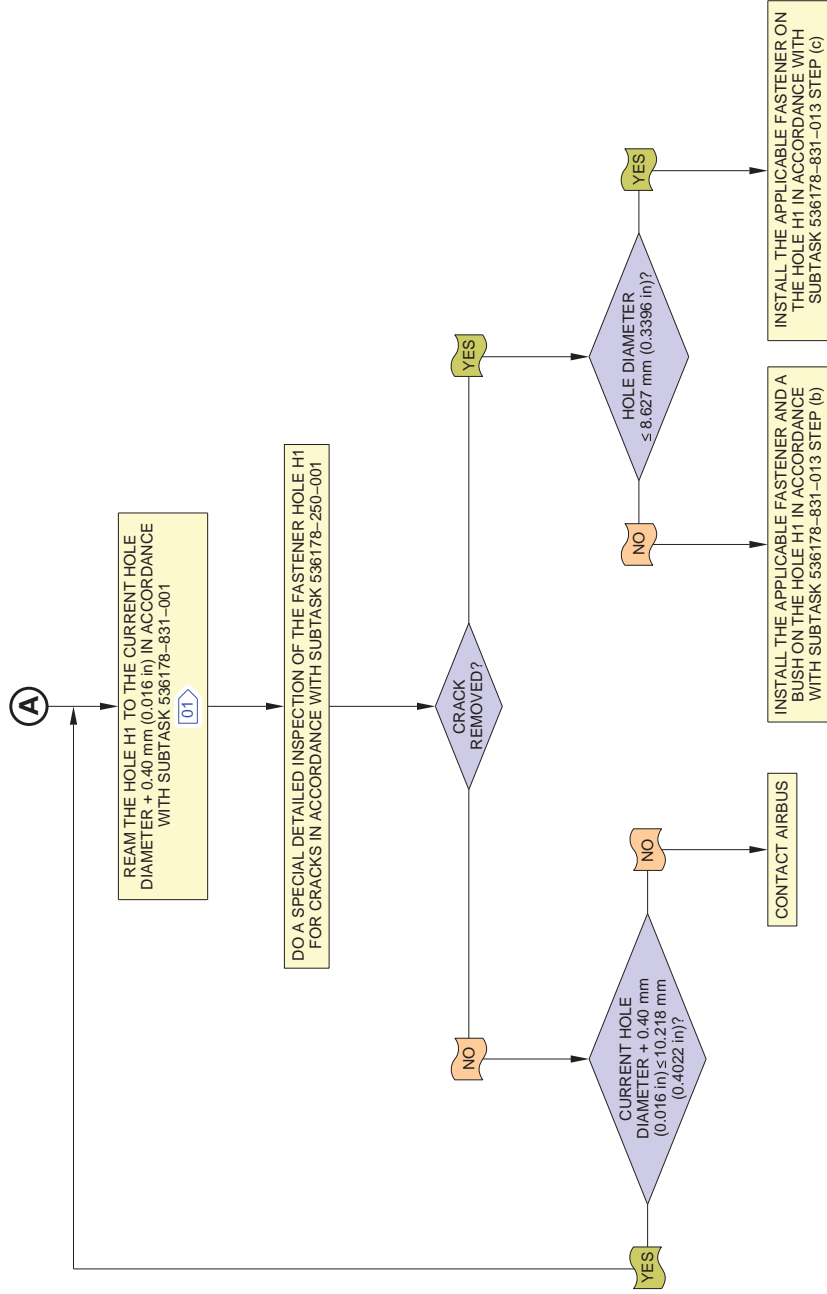


NOTE:
THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FAAA_01_00

Figure A-FFAAA - Sheet 01
Flowchart for the Hole H1 of Frame 41, LH side

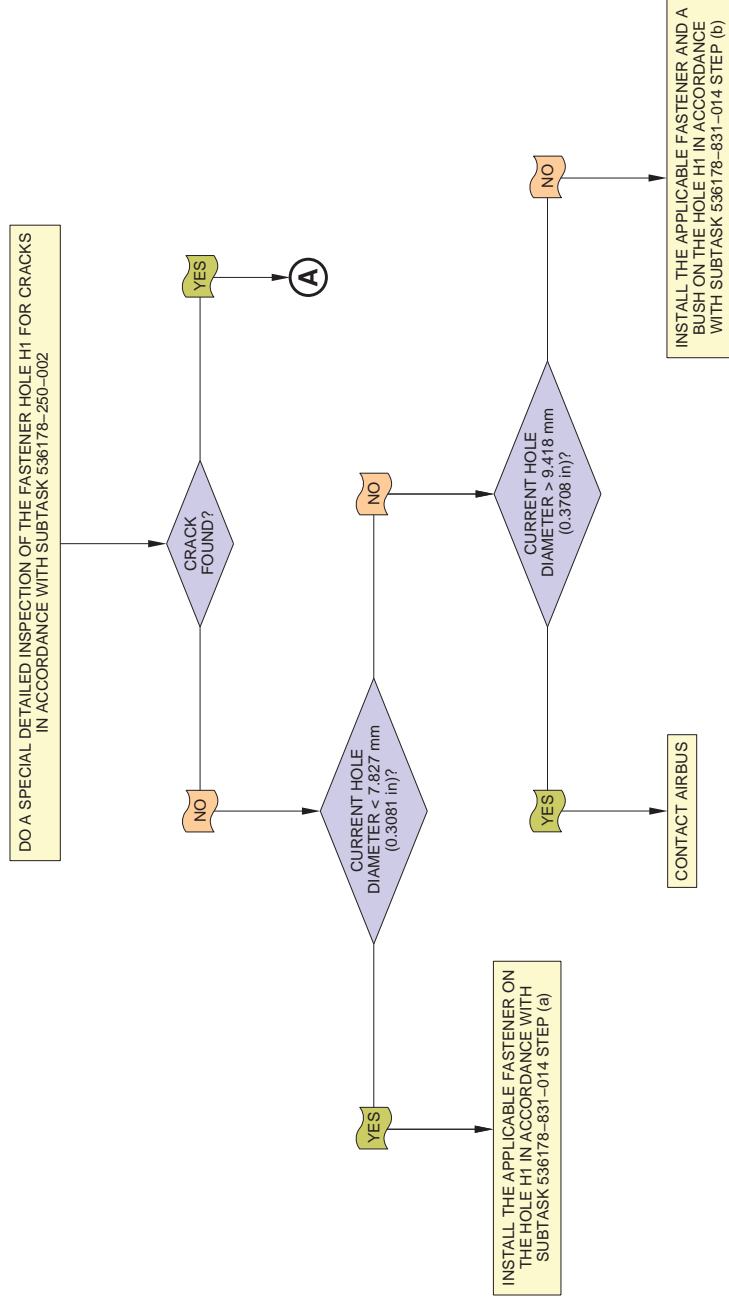
**CONF ALL



NOTE:
 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 10.218 mm (0.4022 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

Figure A-FFAAA - Sheet 02
Flowchart for the Hole H1 of Frame 41, LH side

**CONF ALL

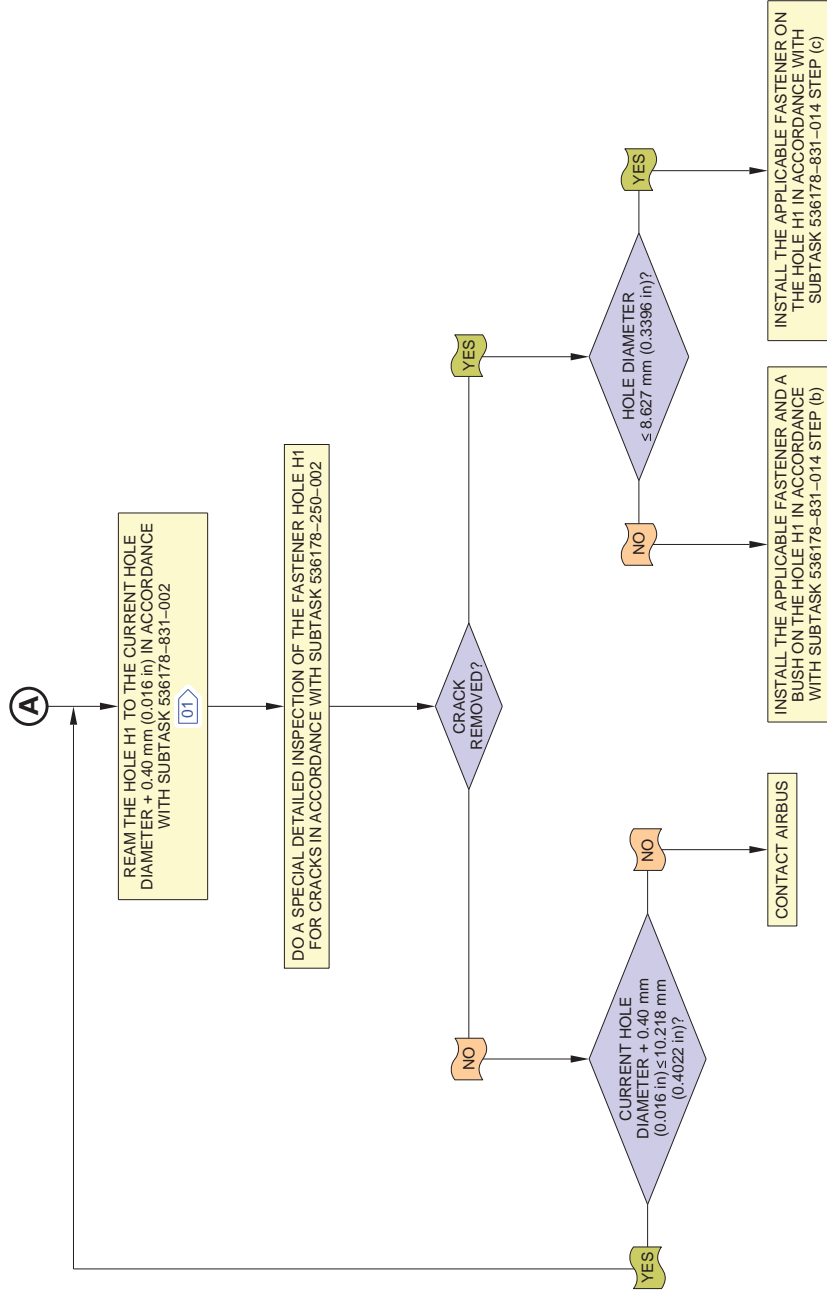


NOTE:
THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FBAA_01_00

Figure A-FFBAA - Sheet 01
Flowchart for the Hole H1 of Frame 42, LH side

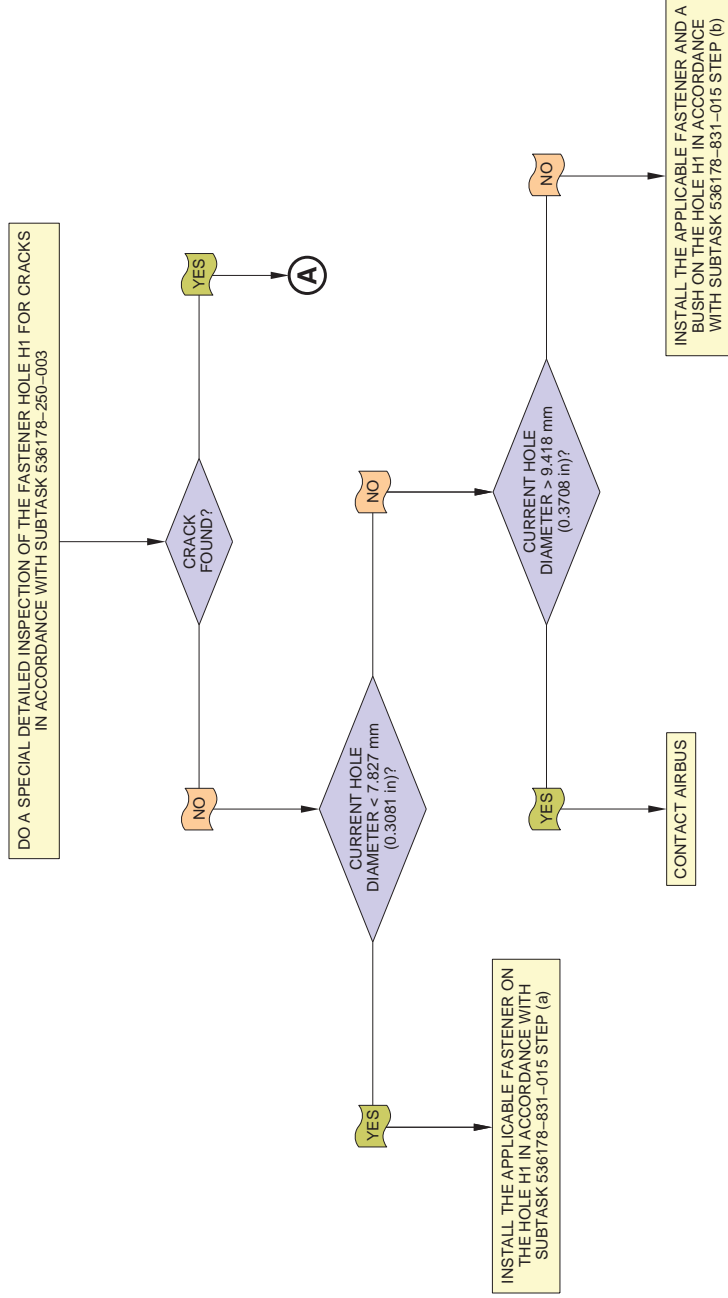
**CONF ALL



NOTE:
 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 10.218 mm (0.4022 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

Figure A-FFBAA - Sheet 02
Flowchart for the Hole H1 of Frame 42, LH side

**CONF ALL

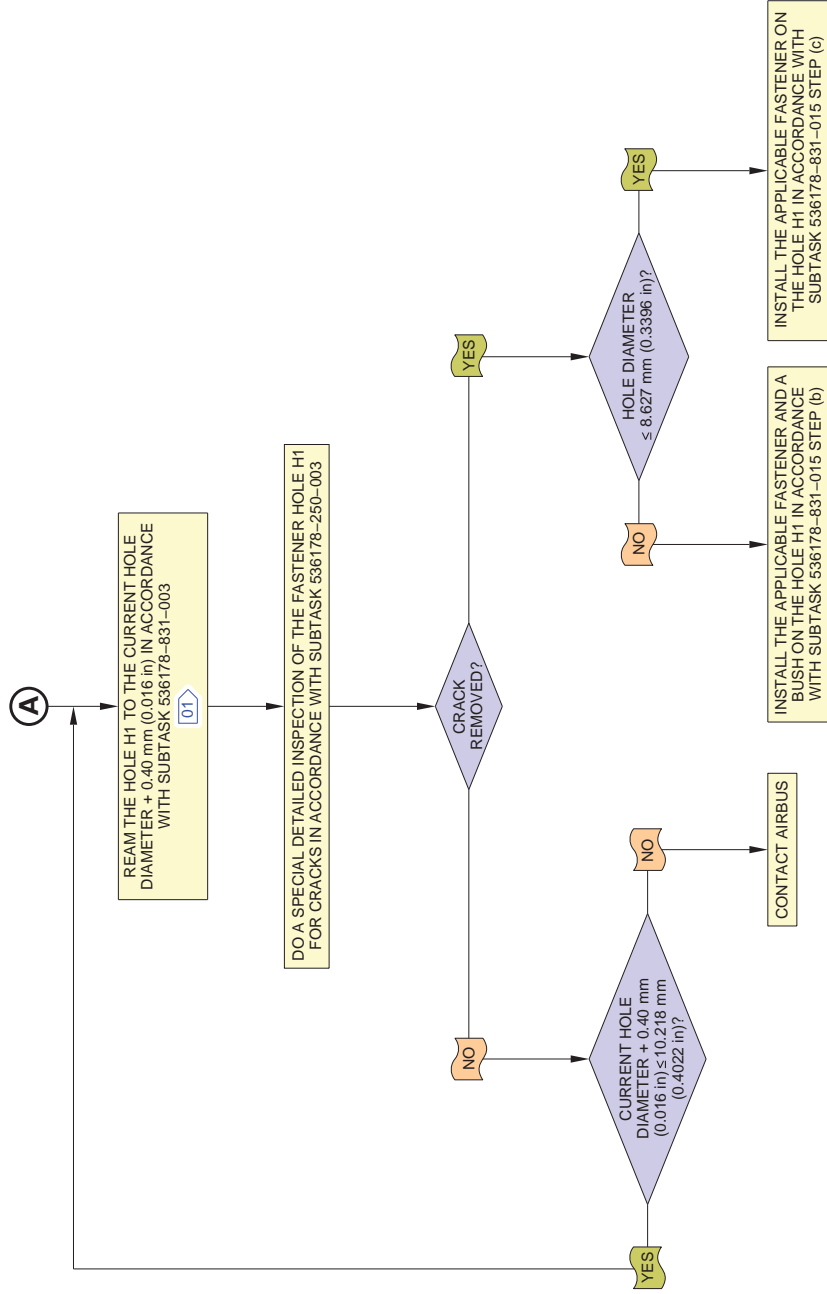


NOTE:
THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FCAA_01_00

Figure A-FFCAA - Sheet 01
Flowchart for the Hole H1 of Frame 43, LH side

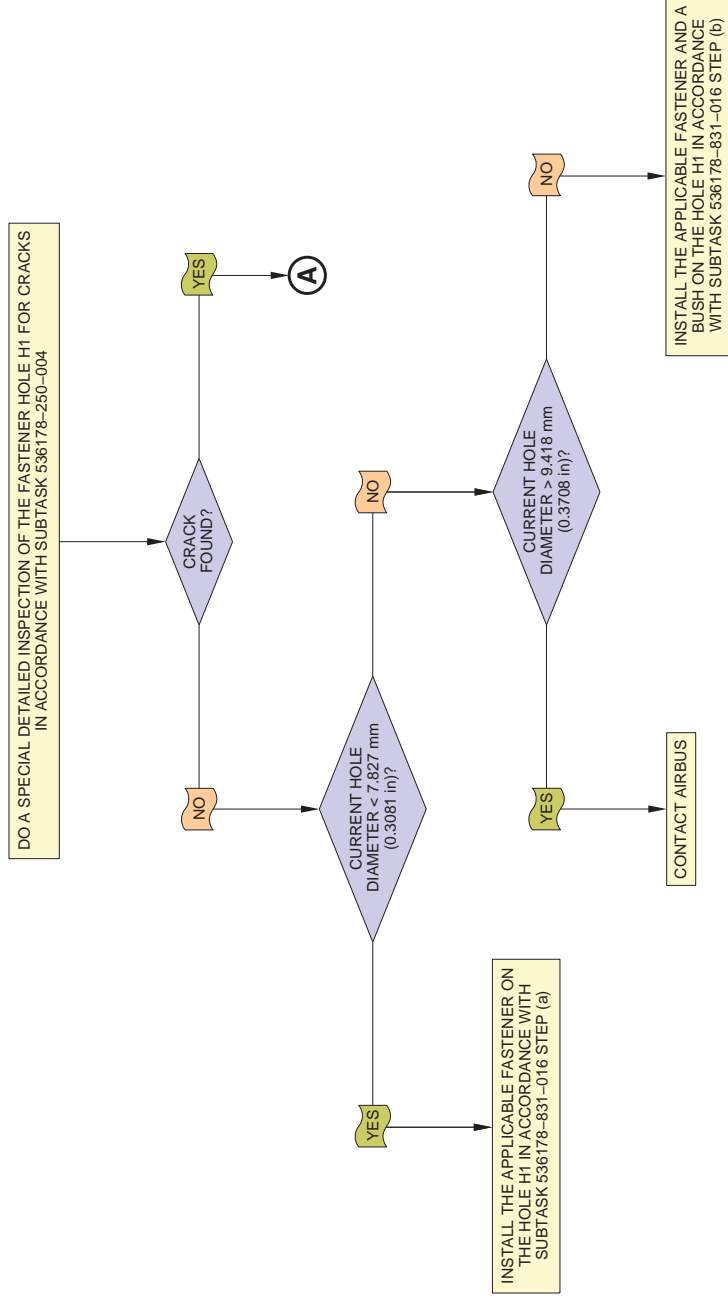
**CONF ALL



NOTE:
 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 10.218 mm (0.4022 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

Figure A-FFCAA - Sheet 02
Flowchart for the Hole H1 of Frame 43, LH side

**CONF ALL

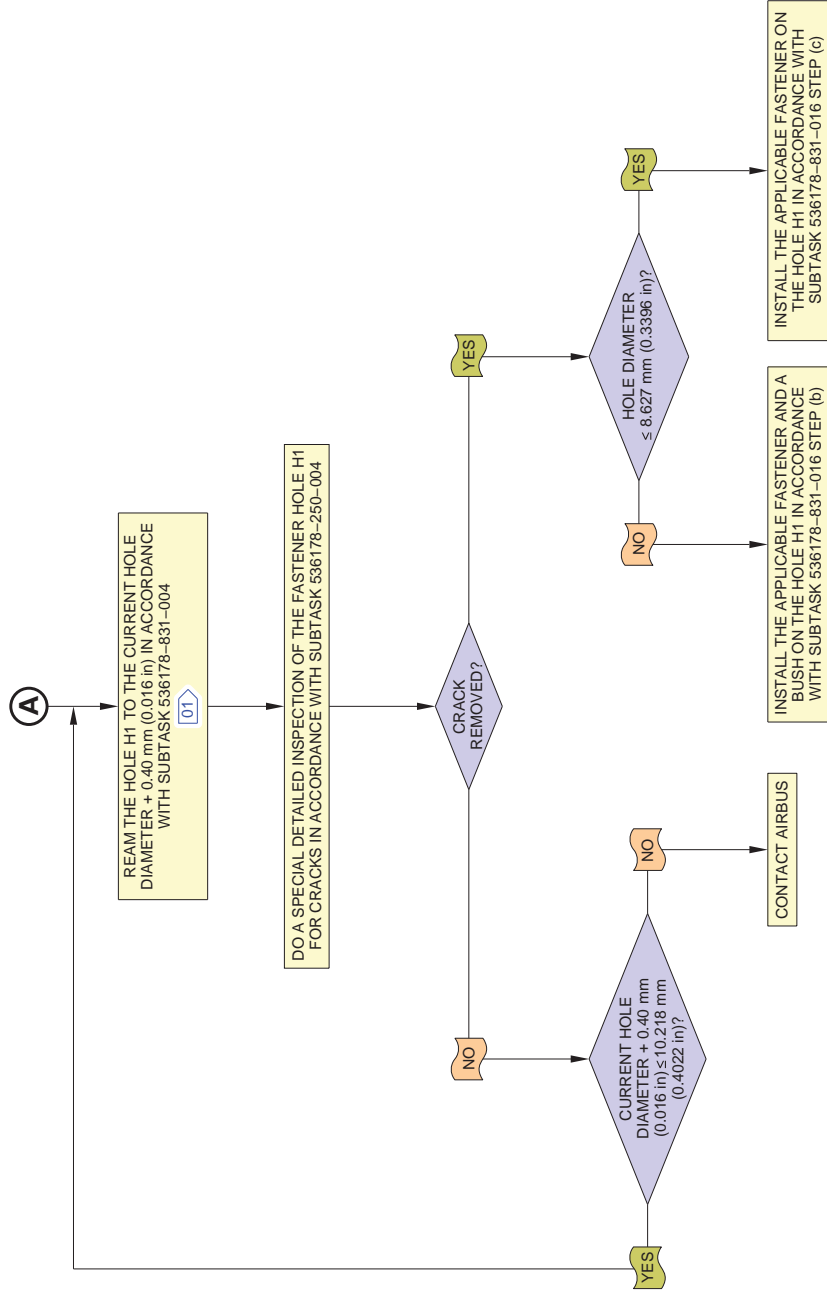


NOTE:
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D_SB_536178_5_FFDA0_01_00

Figure A-FFDAA - Sheet 01
Flowchart for the Hole H1 of Frame 44, LH side

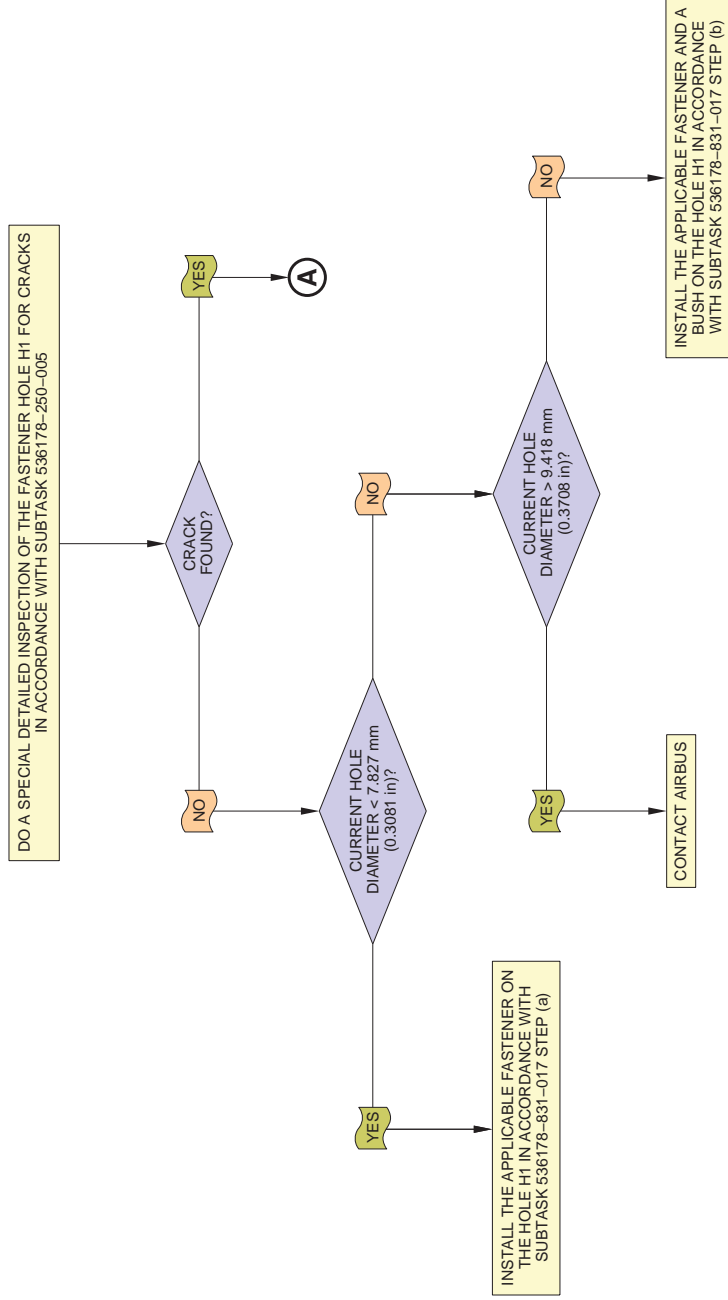
**CONF ALL



NOTE:
 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 10.218 mm (0.4022 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

Figure A-FFDAA - Sheet 02
Flowchart for the Hole H1 of Frame 44, LH side

**CONF ALL

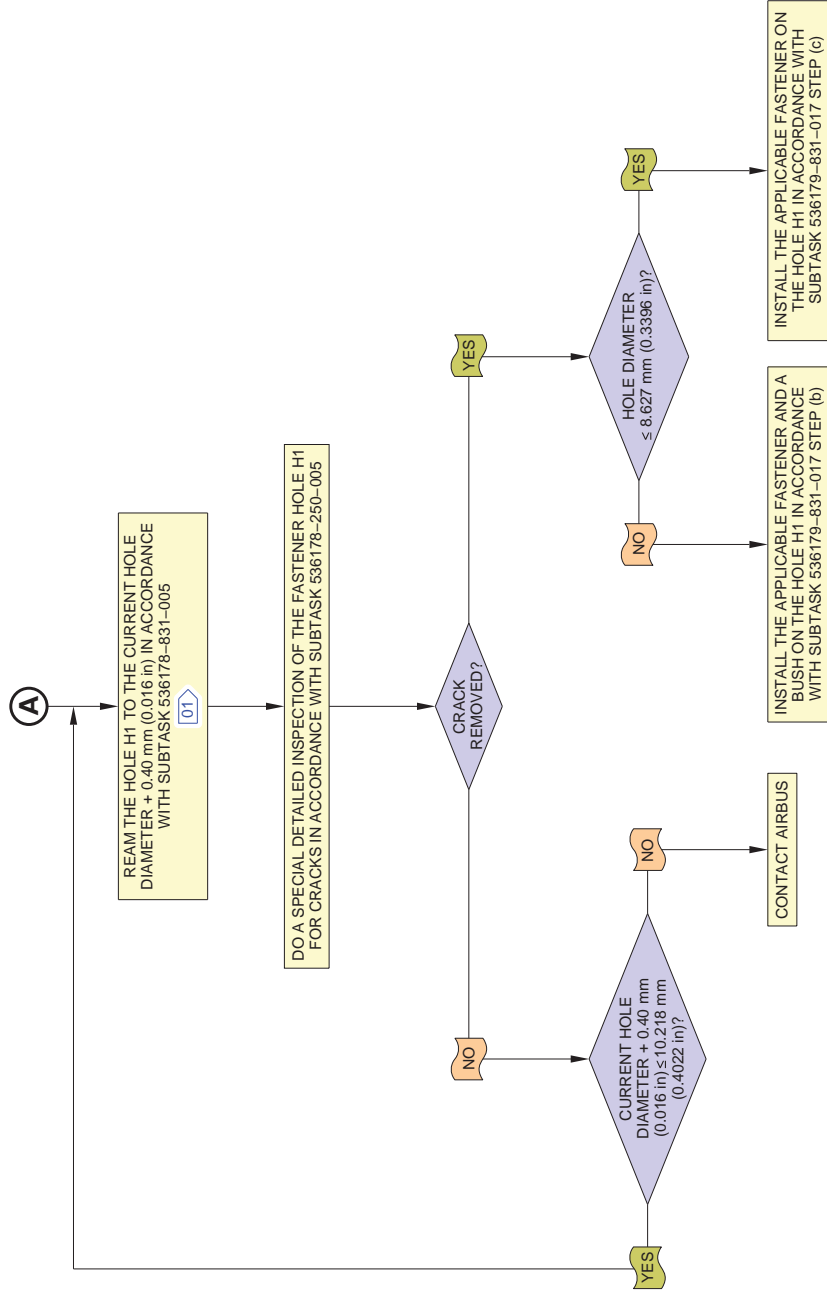


NOTE:
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D_SB_536178_5_FEEA_01_00

Figure A-FFEAA - Sheet 01
Flowchart for the Hole H1 of Frame 45, LH side

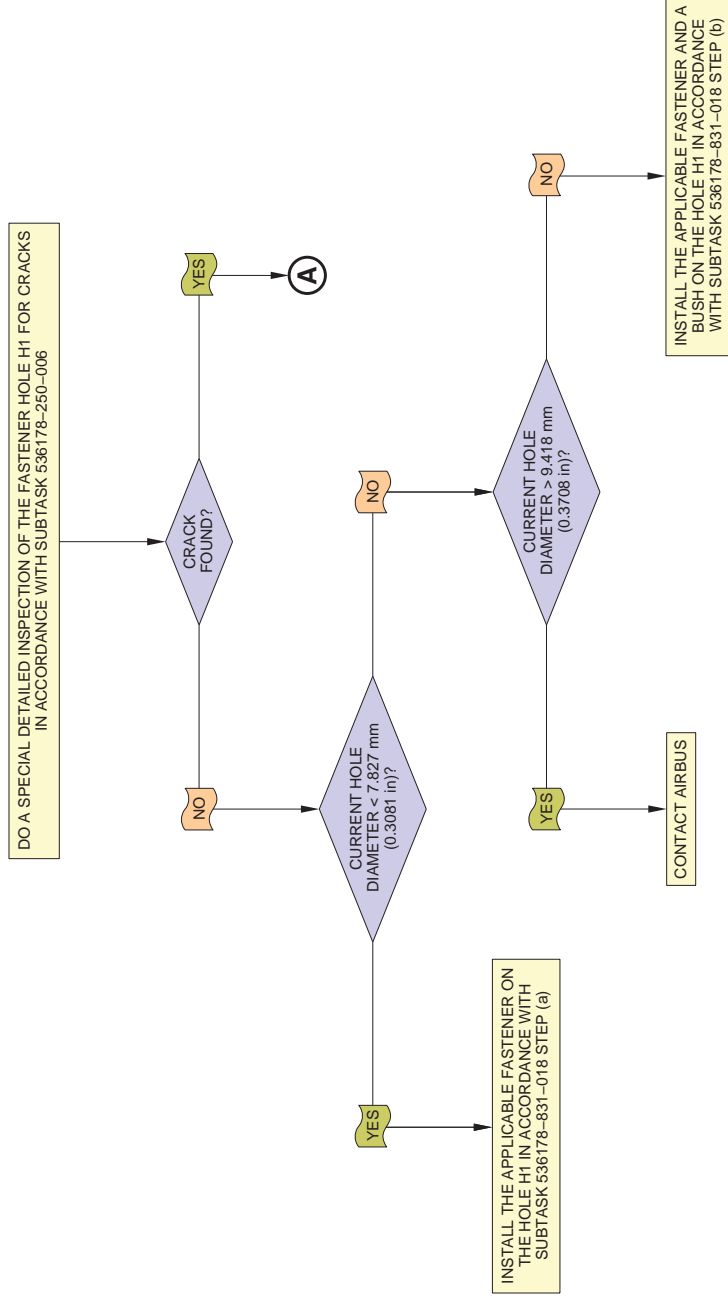
**CONF ALL



NOTE:
 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 10.218 mm (0.4022 in).
 THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

Figure A-FFEAA - Sheet 02
 Flowchart for the Hole H1 of Frame 45, LH side

**CONF ALL

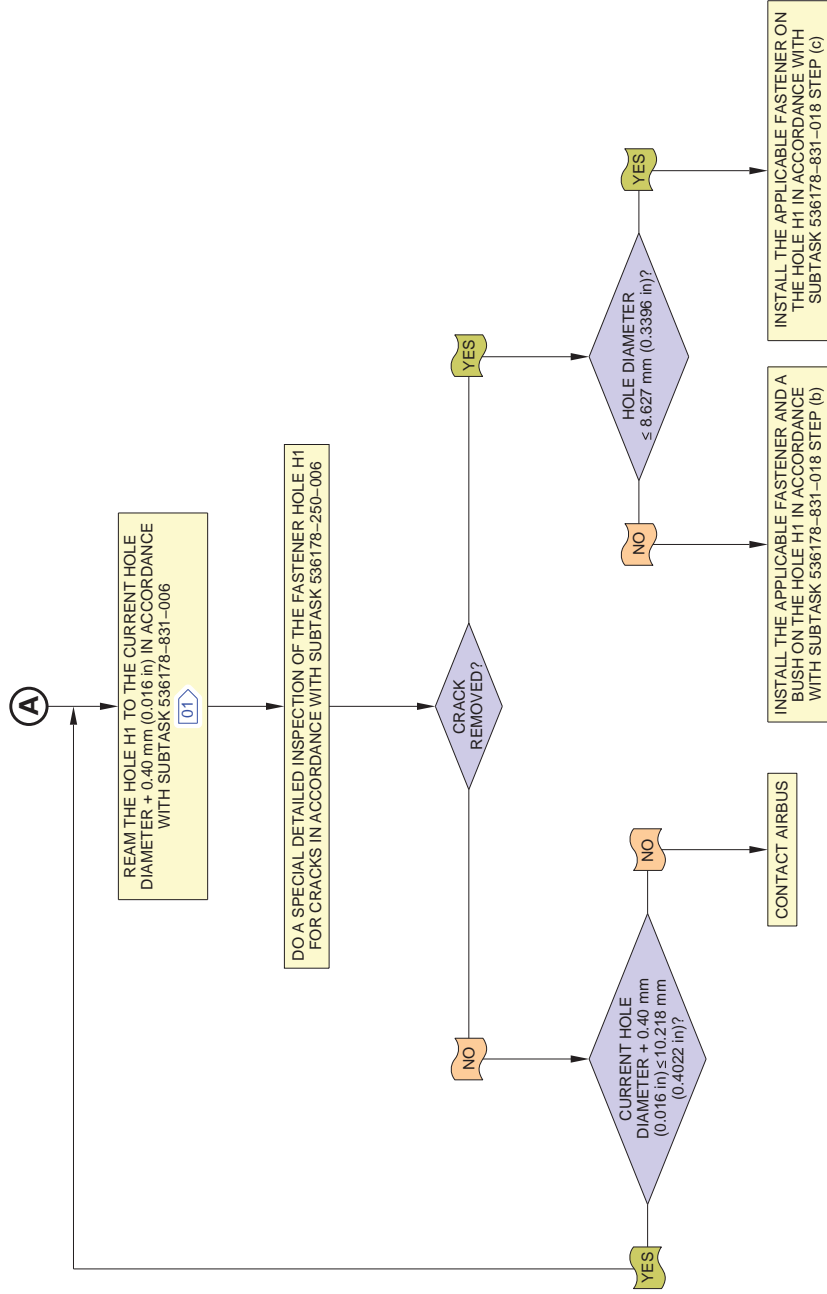


NOTE:
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D_SB_536178_5_FFAA_01_00

Figure A-FFFAA - Sheet 01
Flowchart for the Hole H1 of Frame 46, LH side

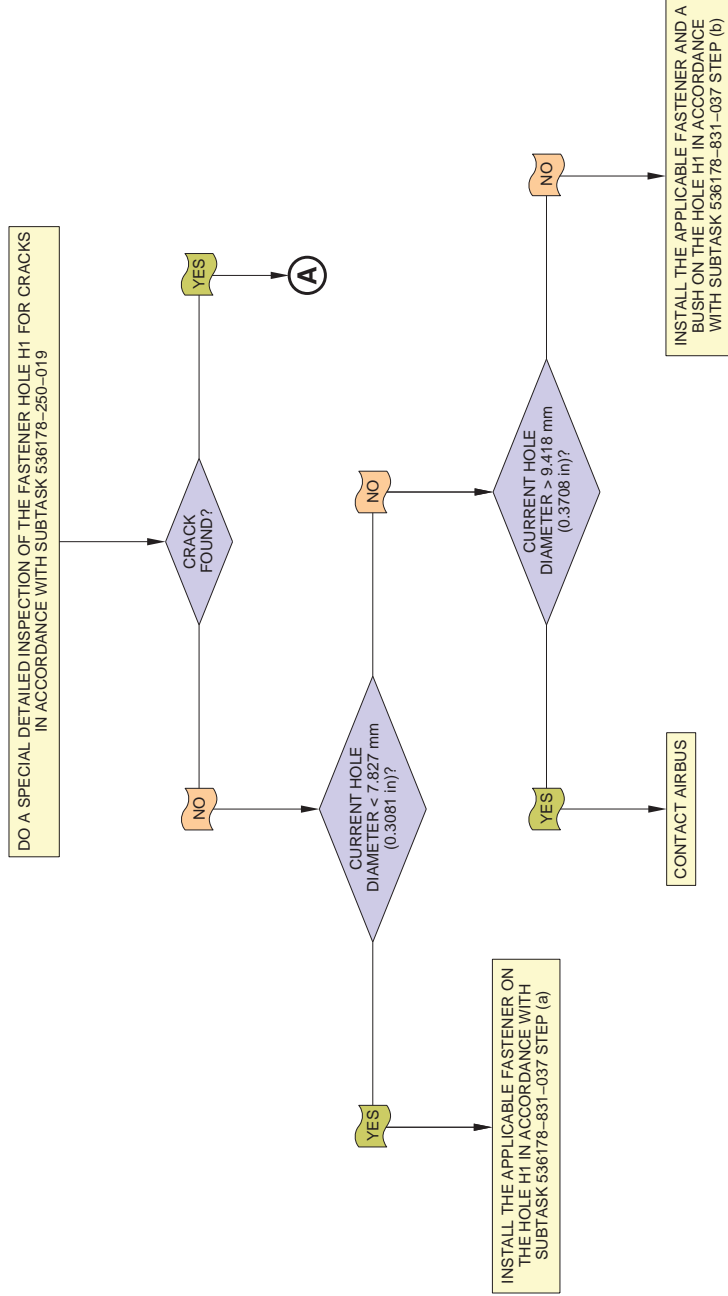
**CONF ALL



NOTE:
 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 10.218 mm (0.4022 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

Figure A-FFFAA - Sheet 02
Flowchart for the Hole H1 of Frame 46, LH side

**CONF ALL

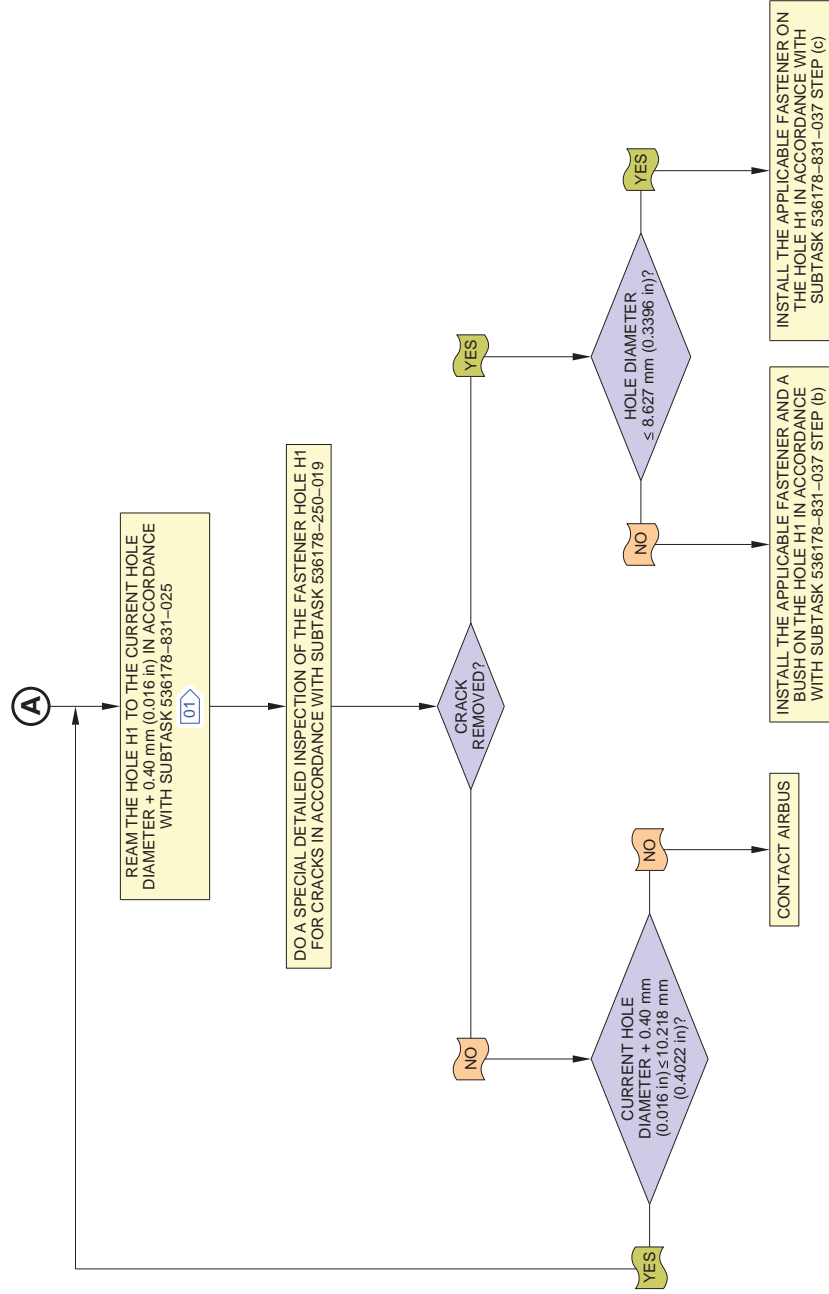


NOTE:
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D_SB_536178_5_FGAA_01_00

Figure A-FFGAA - Sheet 01
Flowchart for the Hole H1 of Frame 41, RH side

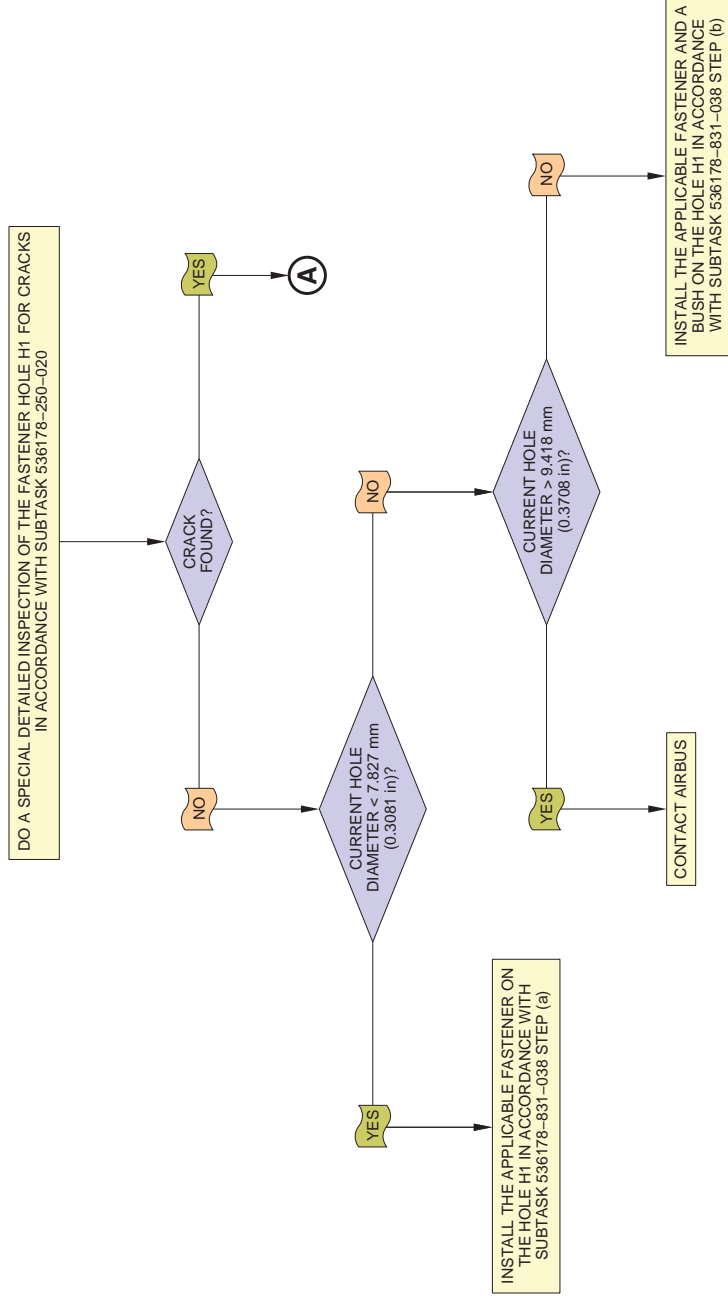
**CONF ALL



NOTE:
 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 10.218 mm (0.4022 in).
 THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

Figure A-FFGAA - Sheet 02
 Flowchart for the Hole H1 of Frame 41, RH side

**CONF ALL

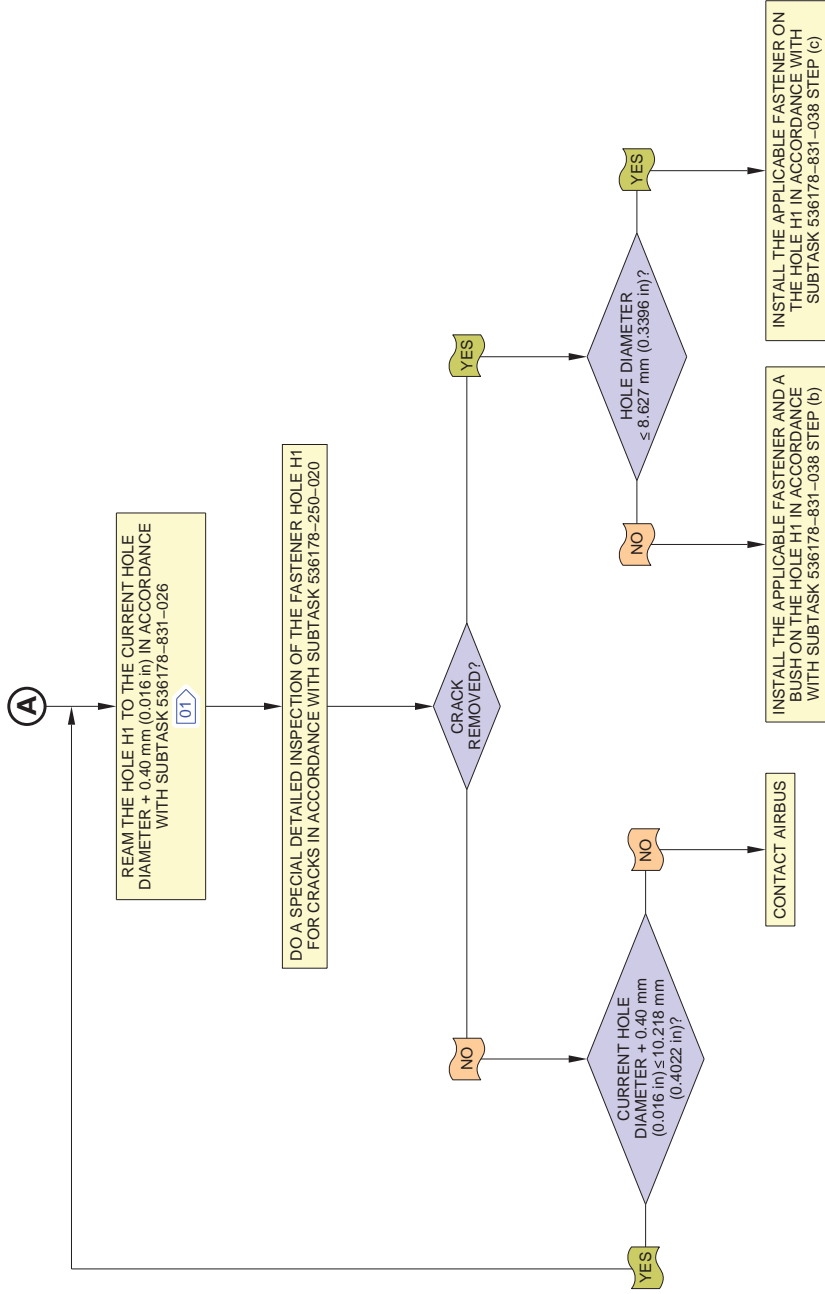


NOTE:
THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FHAA_01_00

Figure A-FFHAA - Sheet 01
Flowchart for the Hole H1 of Frame 42, RH side

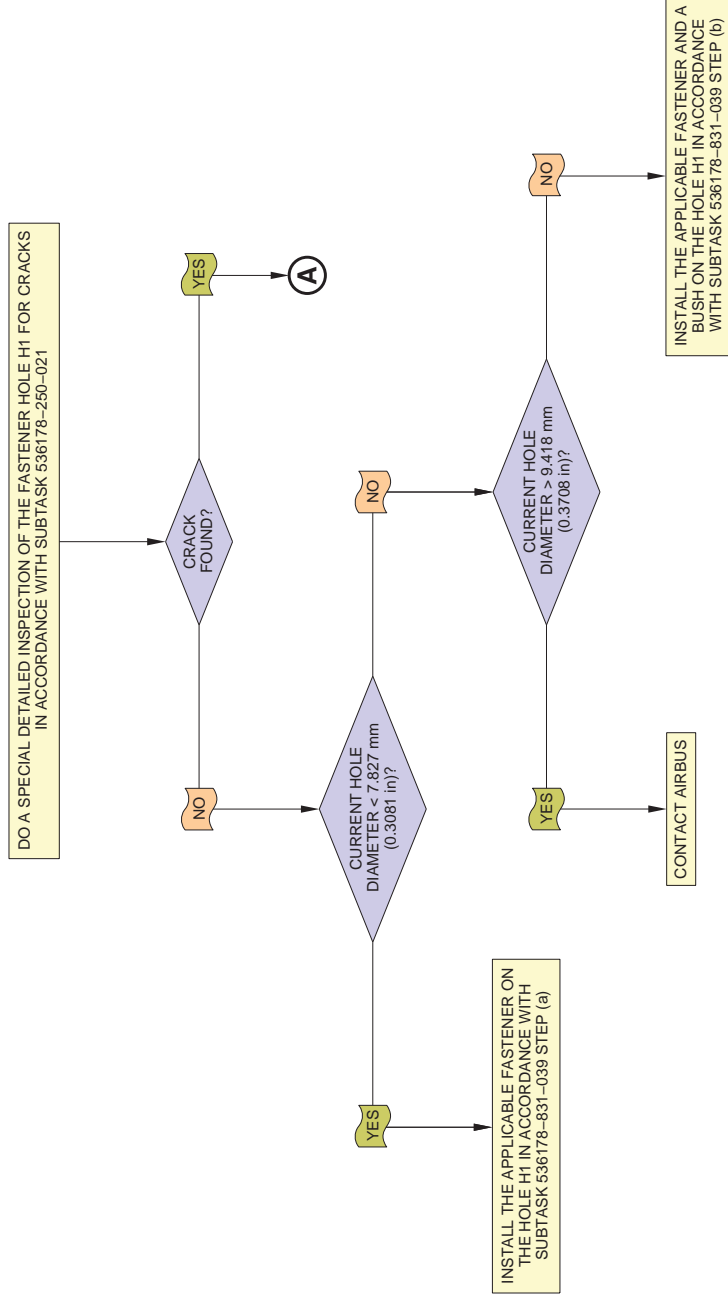
**CONF ALL



NOTE:
 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 10.218 mm (0.4022 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

Figure A-FFHAA - Sheet 02
Flowchart for the Hole H1 of Frame 42, RH side

**CONF ALL

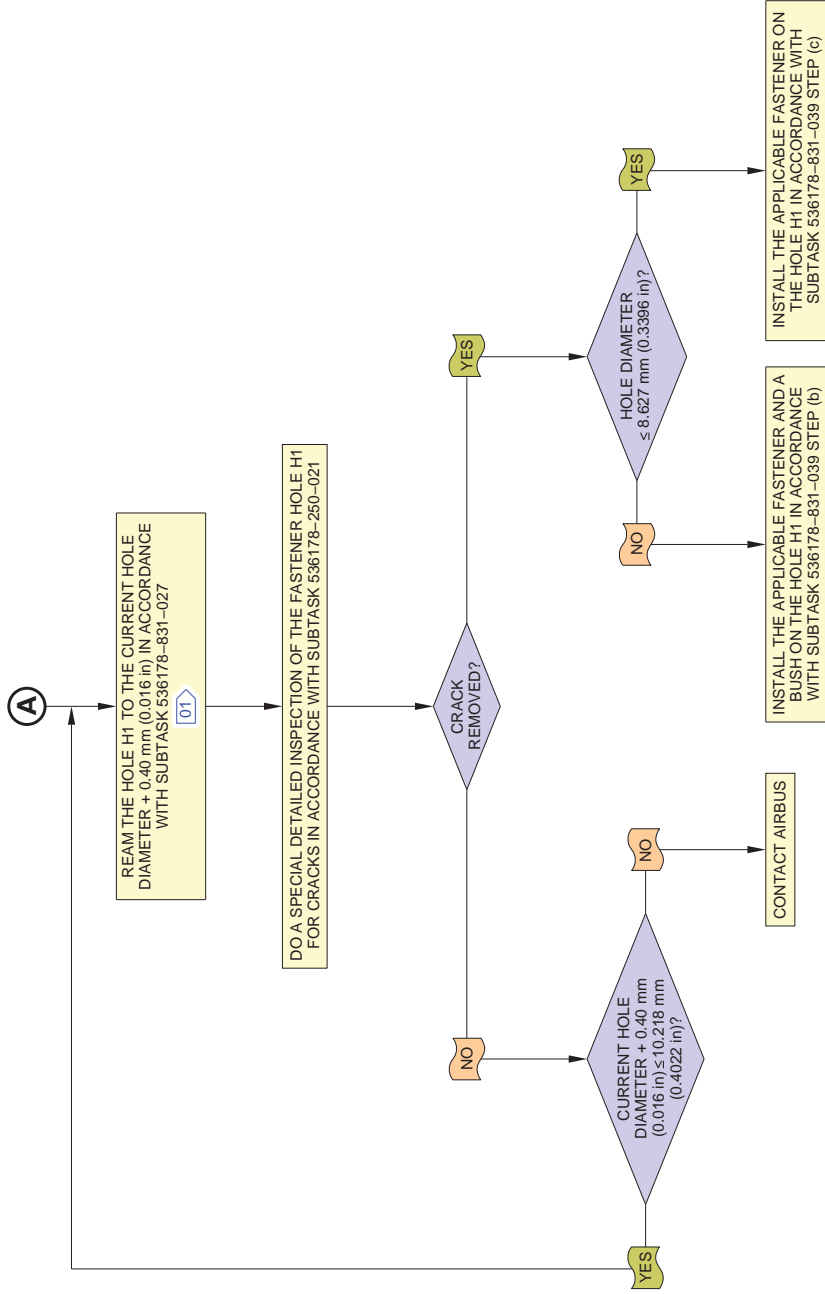


NOTE:
THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FIAA_01_00

Figure A-FF/AA - Sheet 01
Flowchart for the Hole H1 of Frame 43, RH side

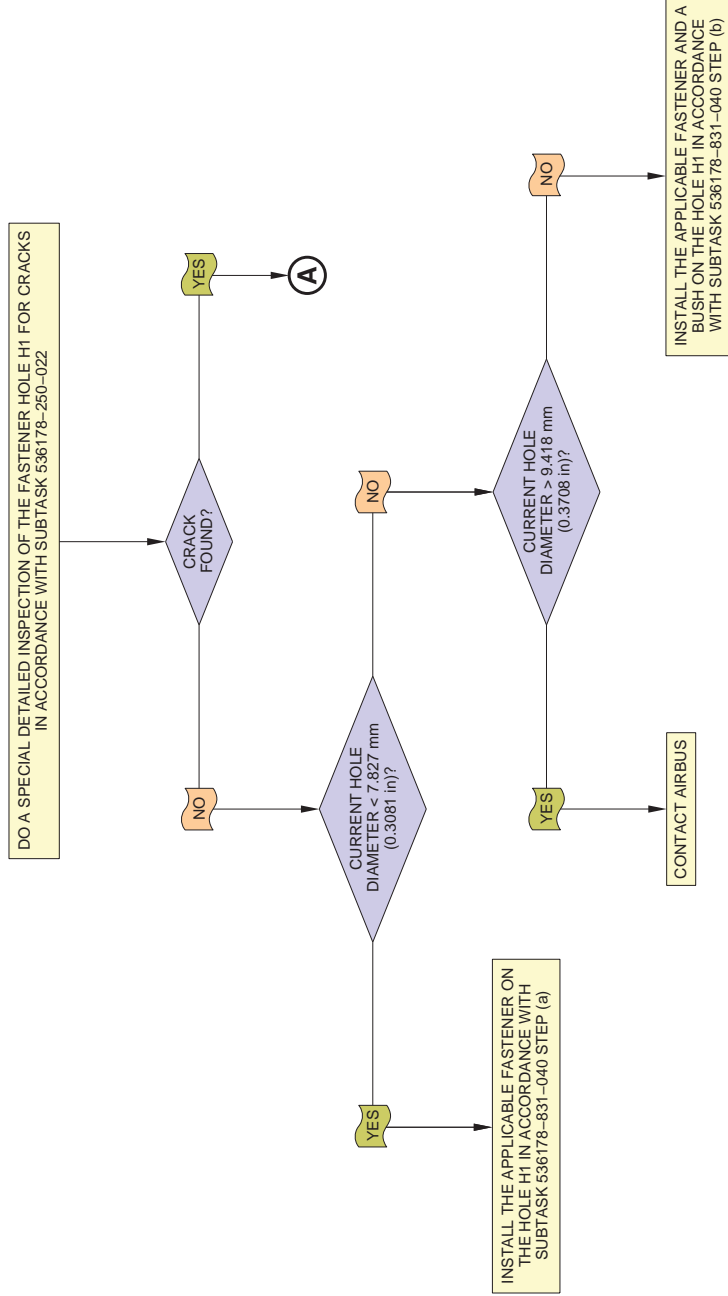
**CONF ALL



NOTE:
 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 10.218 mm (0.4022 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

Figure A-FF/AA - Sheet 02
 Flowchart for the Hole H1 of Frame 43, RH side

**CONF ALL

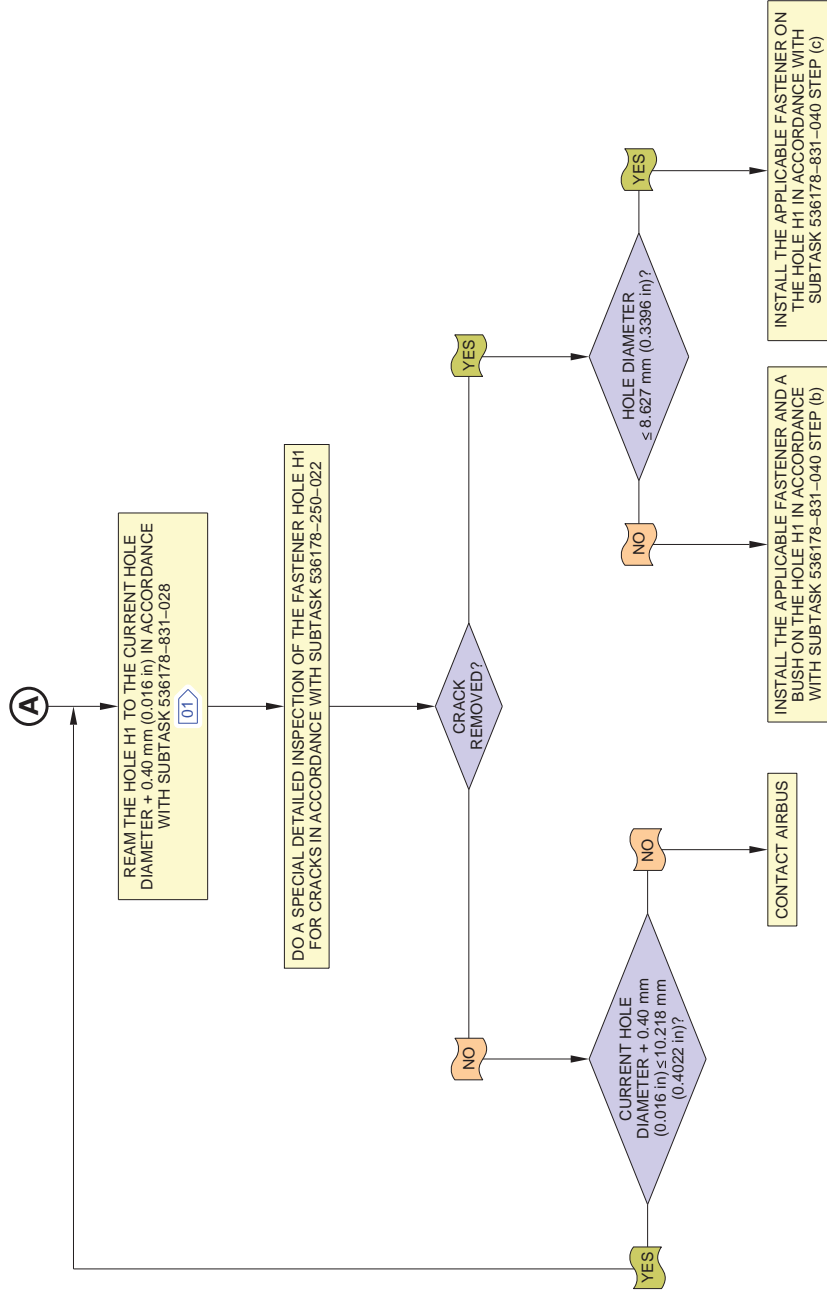


NOTE:
THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FFJAA_01_00

Figure A-FFJAA - Sheet 01
Flowchart for the Hole H1 of Frame 44, RH side

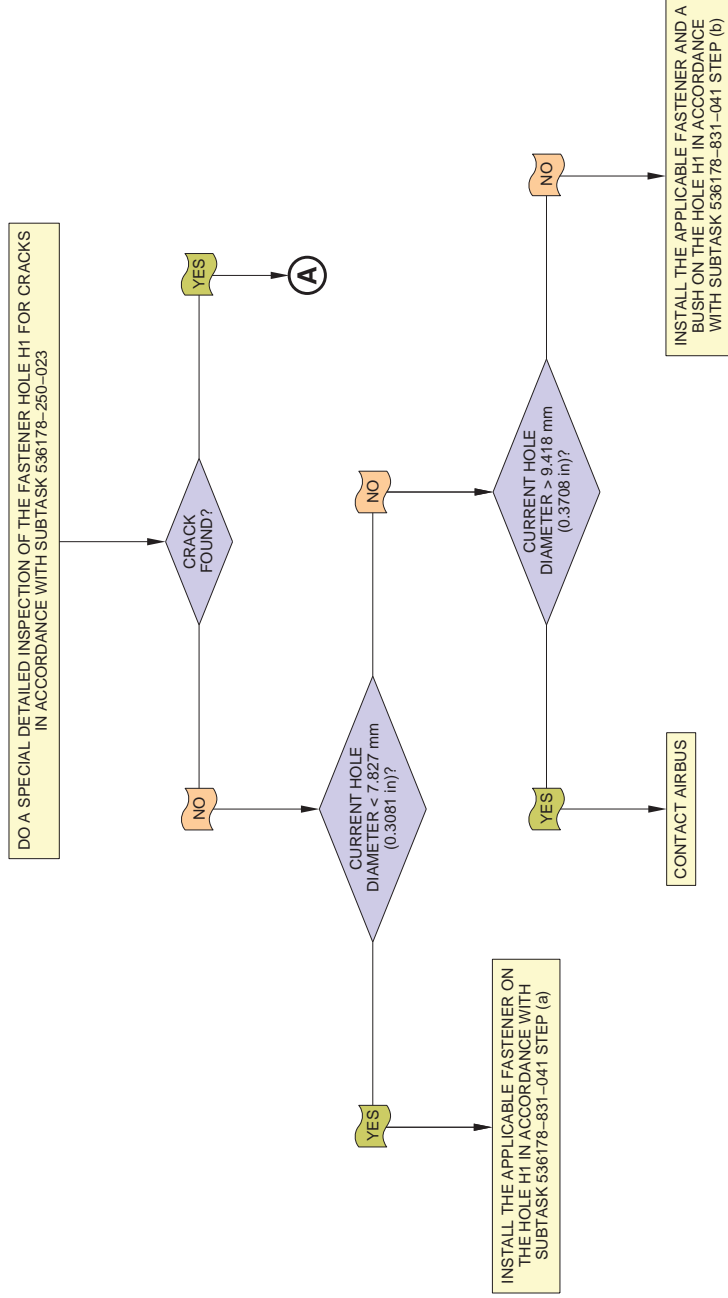
**CONF ALL



NOTE:
 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 10.218 mm (0.4022 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

Figure A-FFJAA - Sheet 02
Flowchart for the Hole H1 of Frame 44, RH side

**CONF ALL

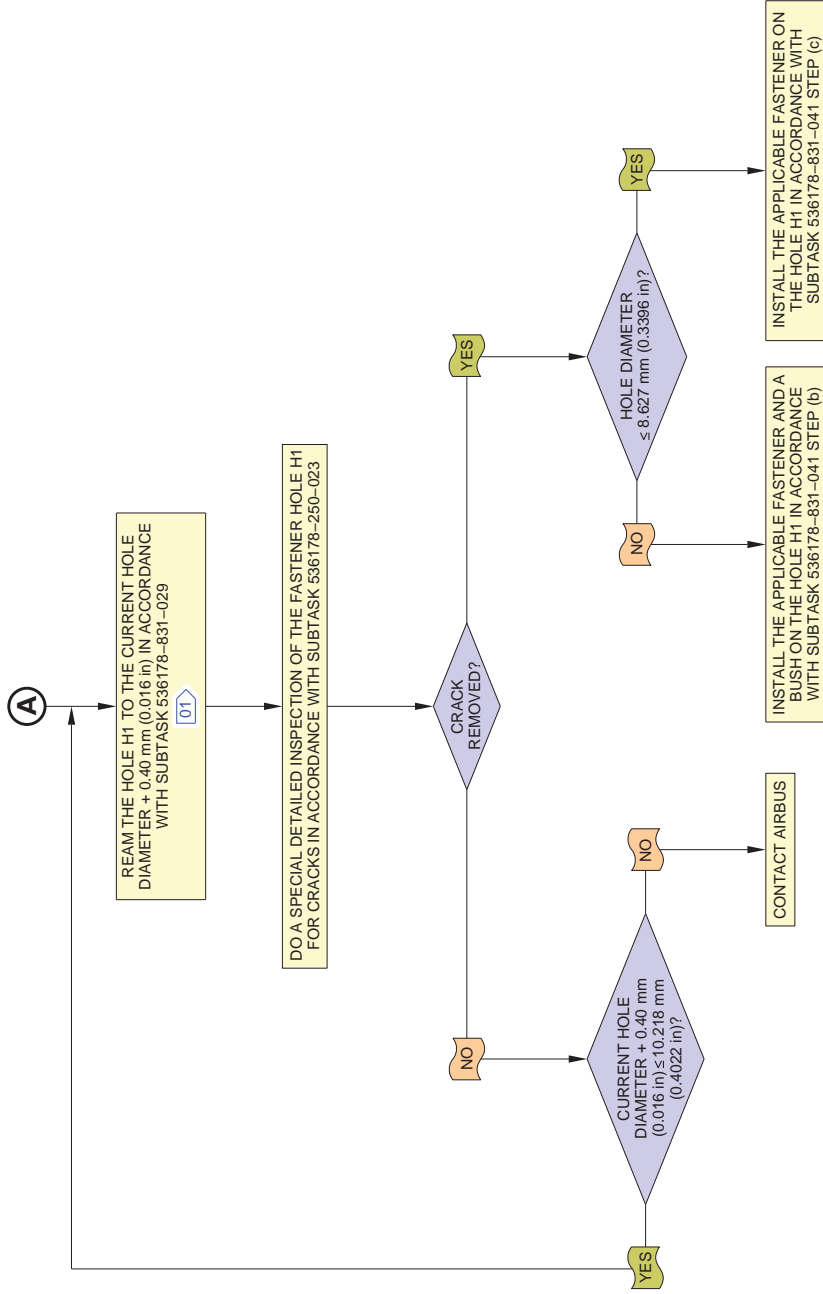


NOTE:
THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FKAA_01_00

Figure A-FFKAA - Sheet 01
Flowchart for the Hole H1 of Frame 45, RH side

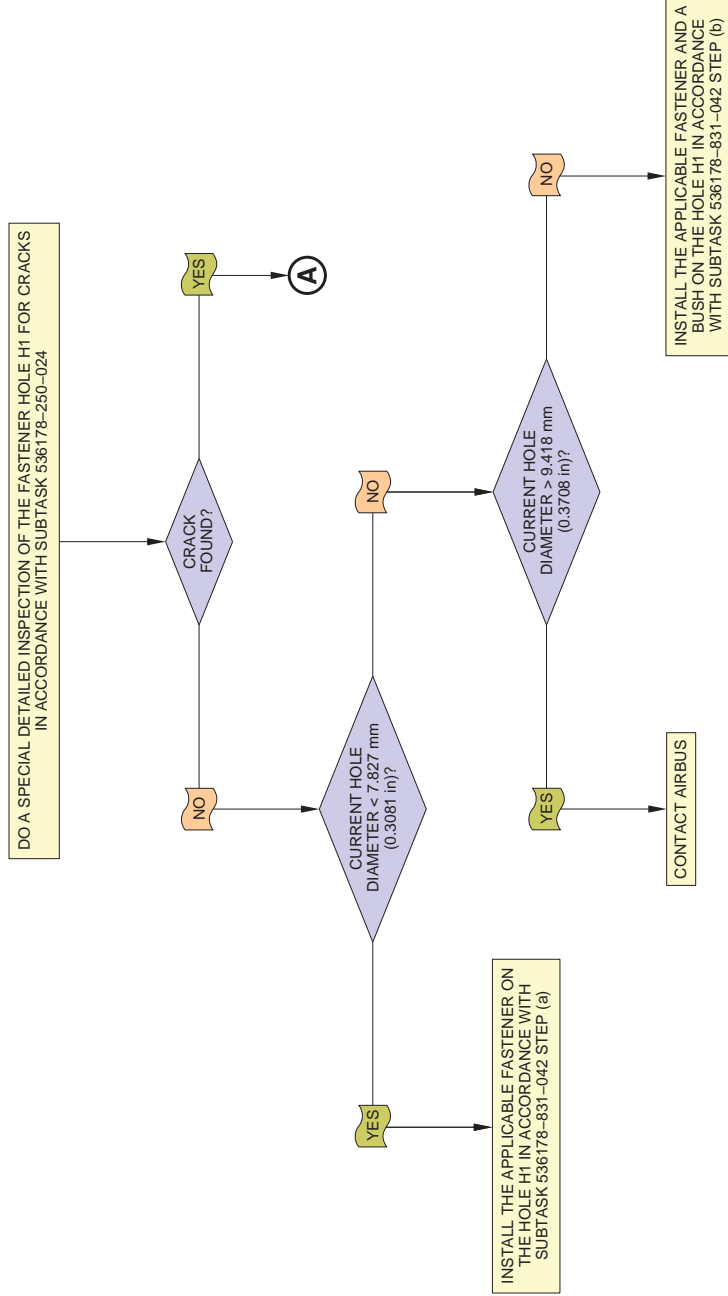
**CONF ALL



NOTE:
 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 10.218 mm (0.4022 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

Figure A-FFKAA - Sheet 02
Flowchart for the Hole H1 of Frame 45, RH side

**CONF ALL

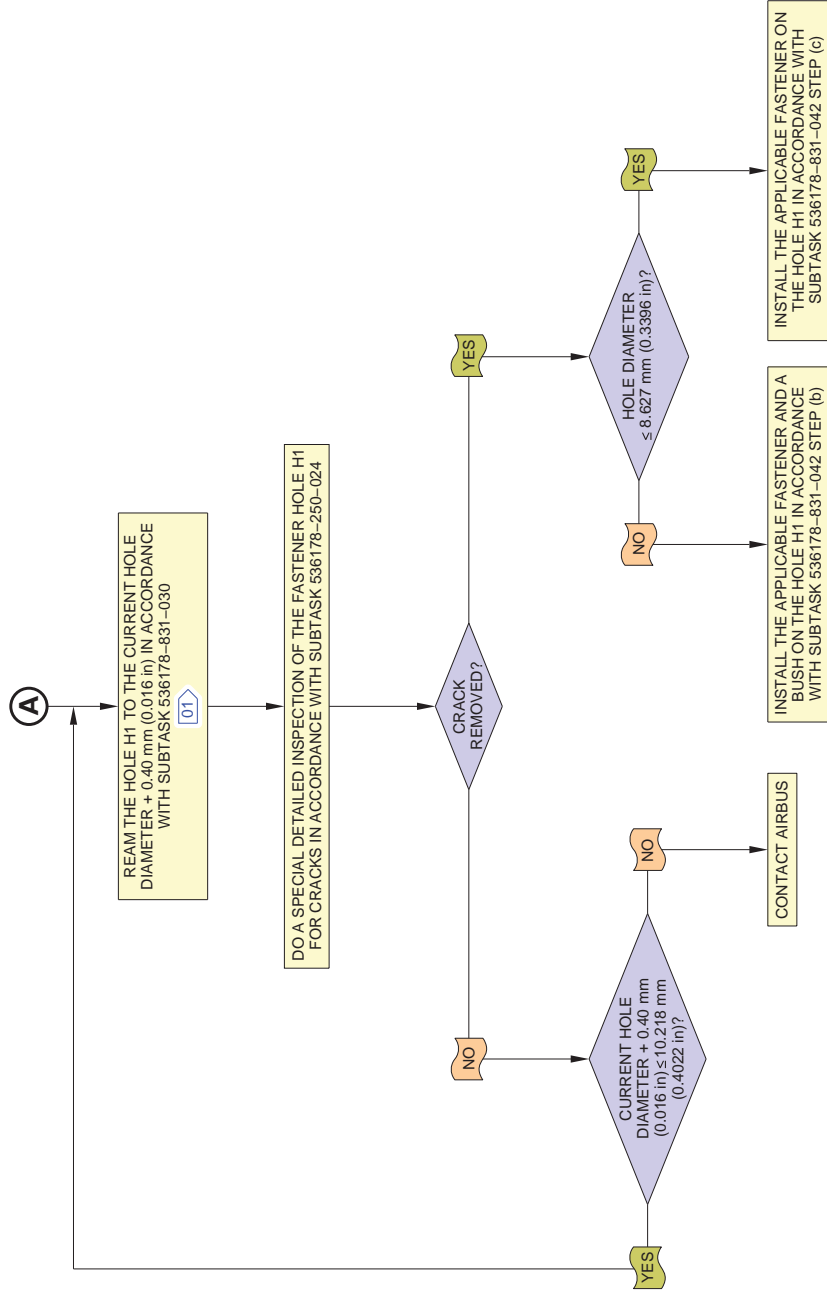


NOTE:
THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FFLAA_01_00

Figure A-FFLAA - Sheet 01
Flowchart for the Hole H1 of Frame 46, RH side

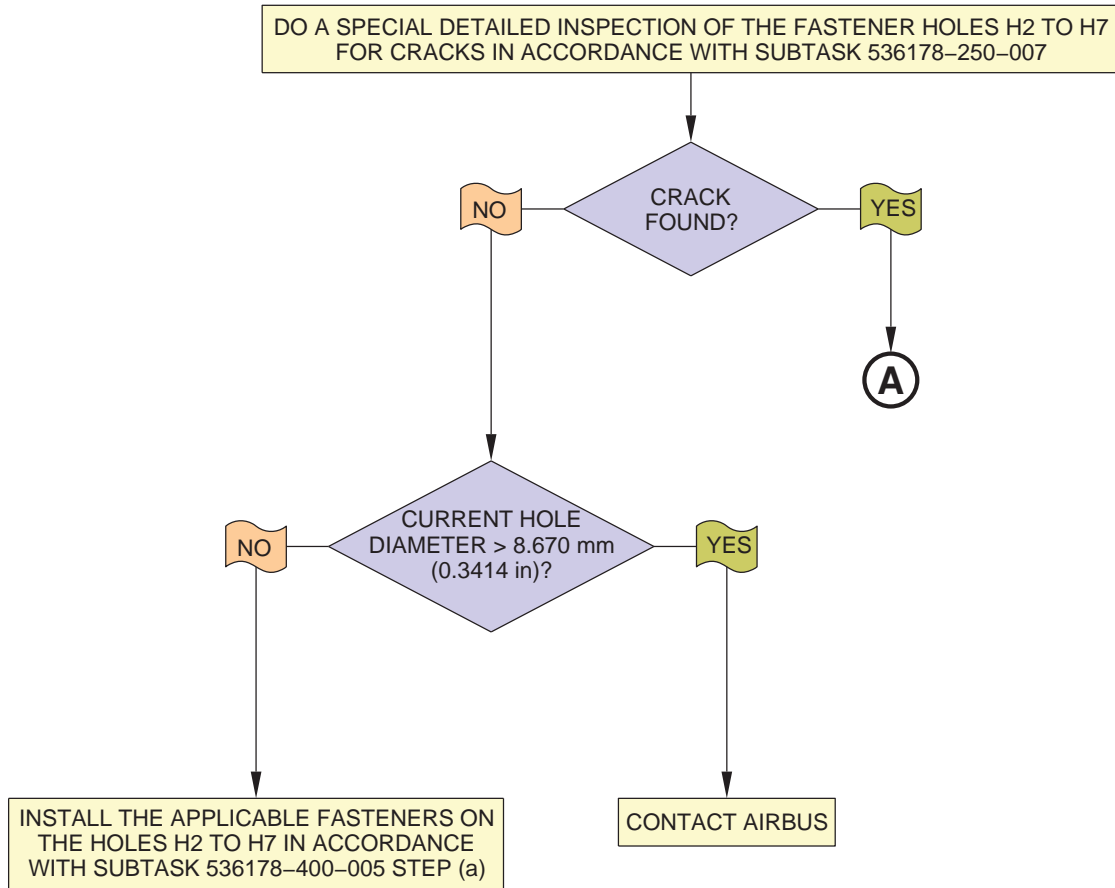
**CONF ALL



NOTE:
 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 10.218 mm (0.4022 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

Figure A-FFLAA - Sheet 02
Flowchart for the Hole H1 of Frame 46, RH side

****CONF ALL**



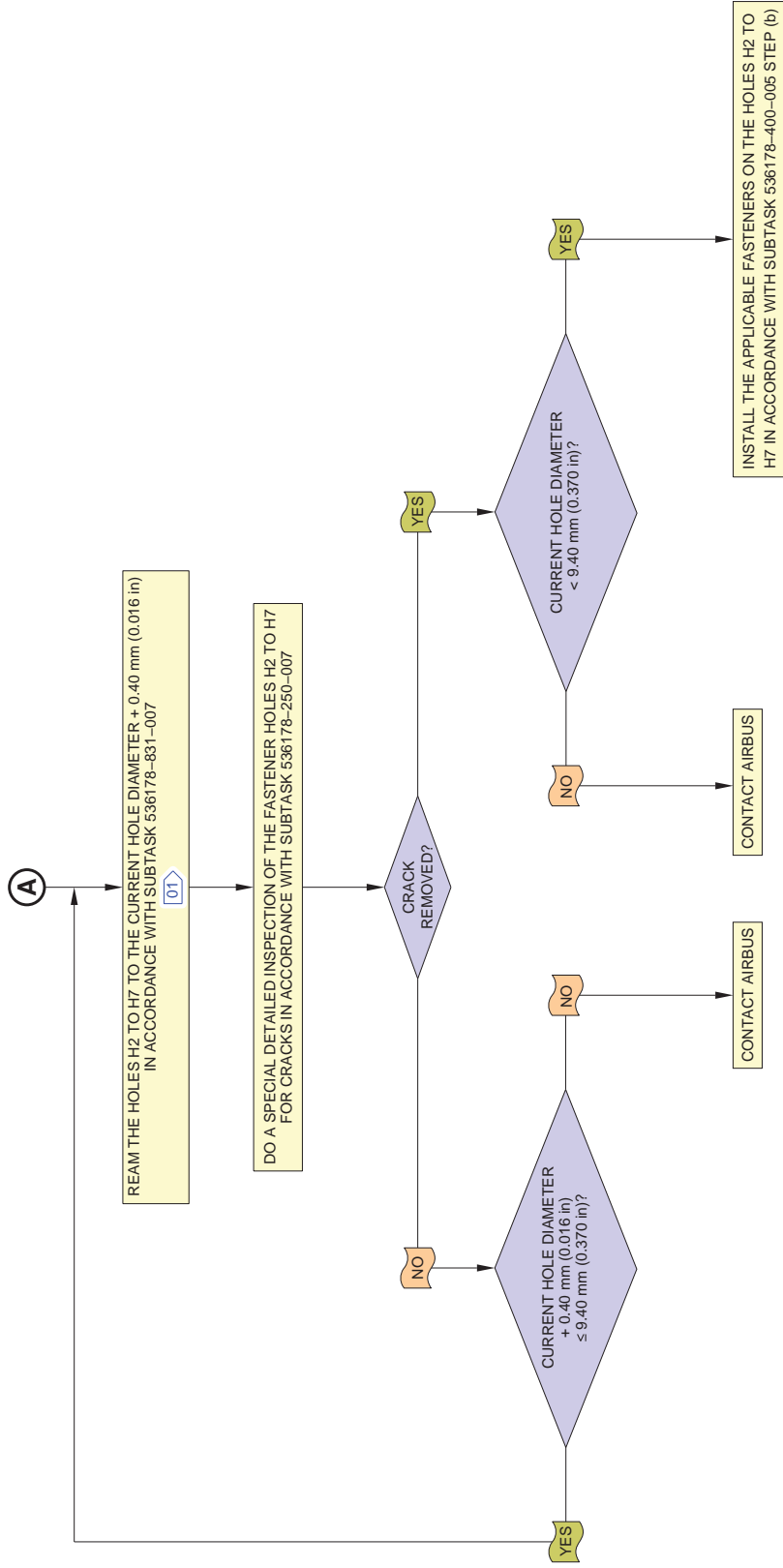
NOTE:

THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FMAA_01_00

Figure A-FFMAA - Sheet 01
Flowchart for the Hole H2 to H7 from Frame 41, LH side

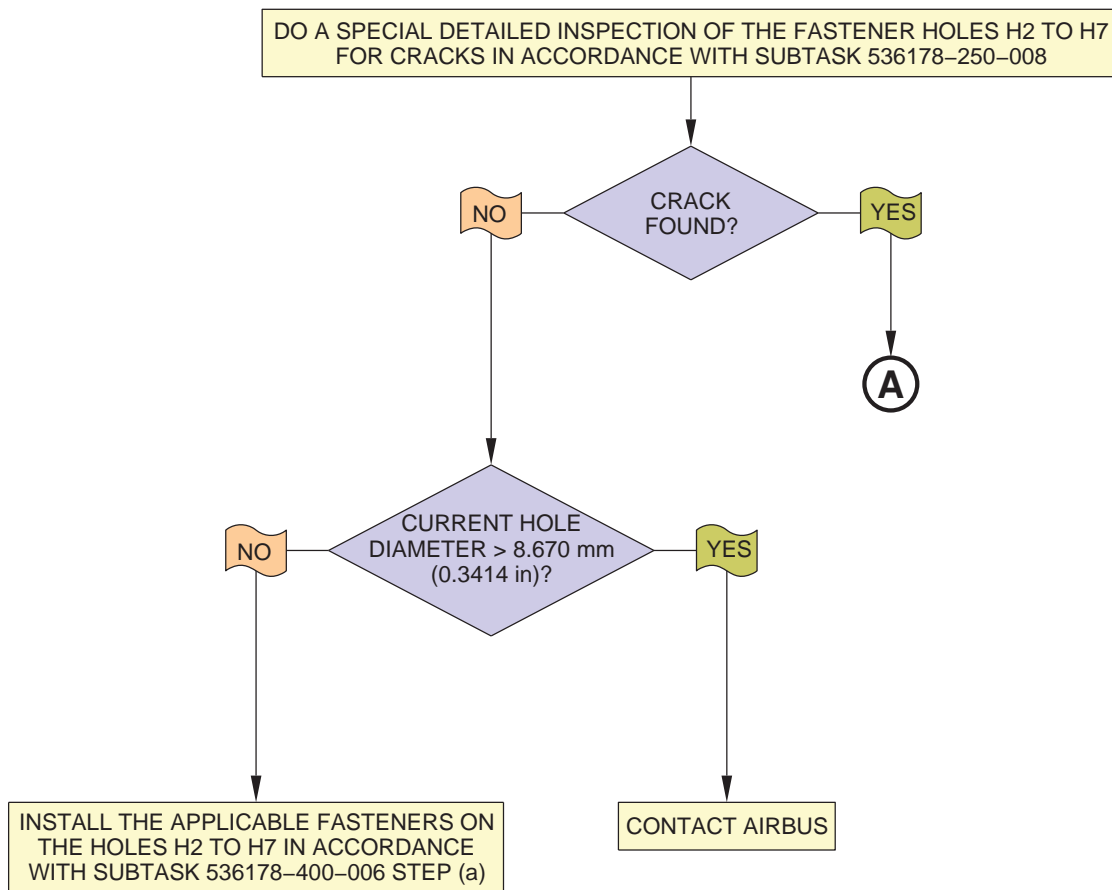
**CONF ALL



NOTE: 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 9.40 mm (0.370 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THE SERVICE BULLETIN.

Figure A-FFMAA - Sheet 02
Flowchart for the Hole H2 to H7 from Frame 41, LH side

**CONF ALL



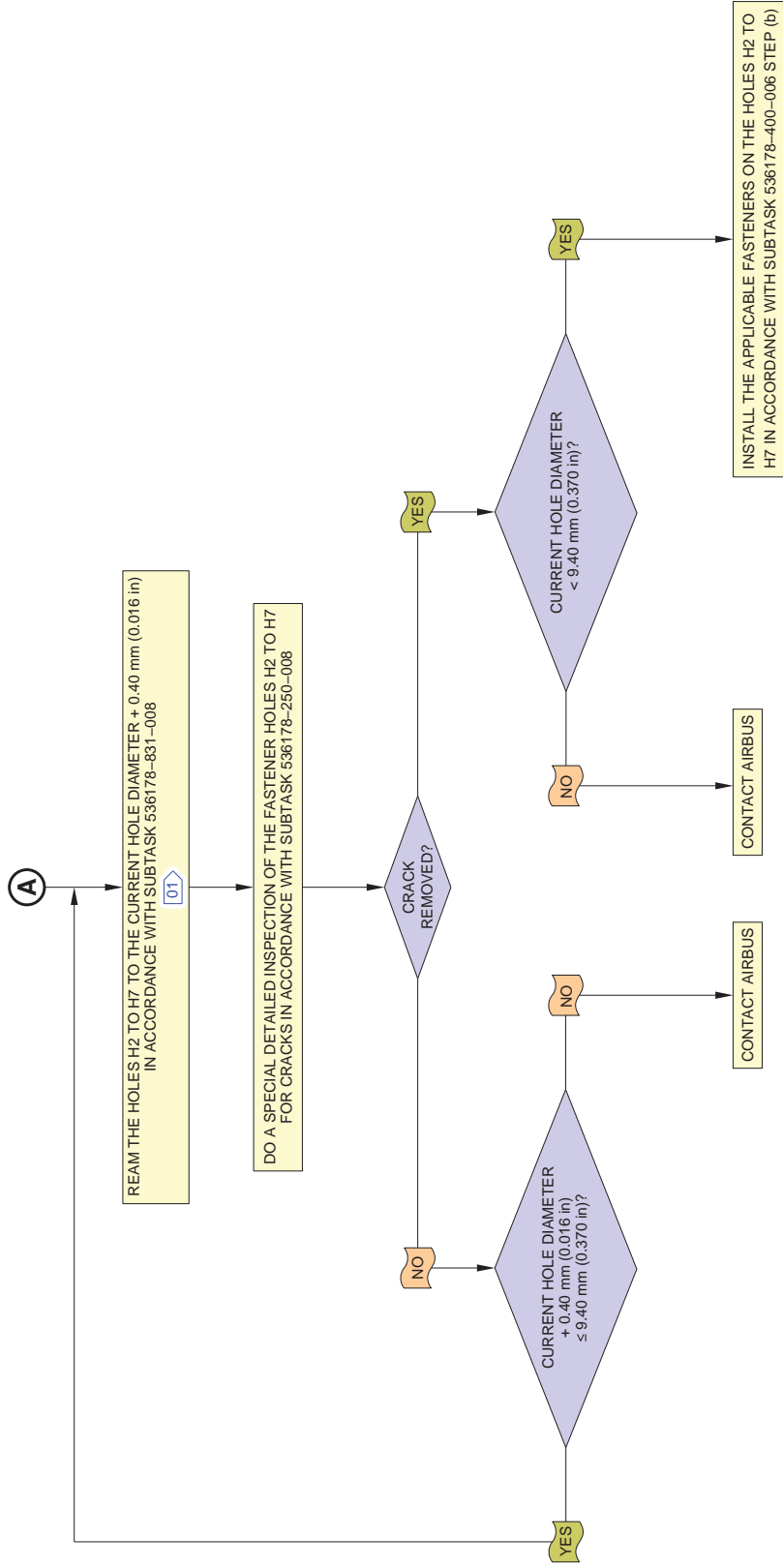
NOTE:

THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FFNA01_00

Figure A-FFNA01 - Sheet 01
Flowchart for the Hole H2 to H7 from Frame 42, LH side

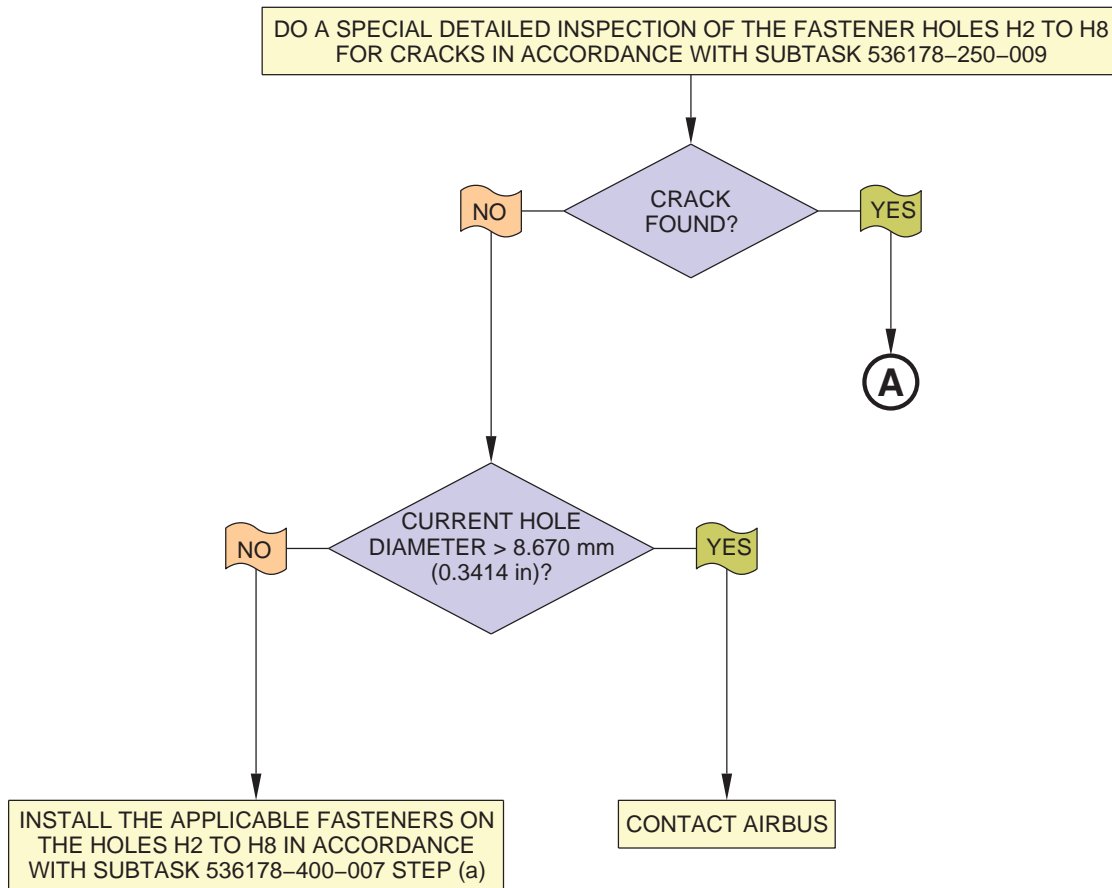
**CONF ALL



NOTE: **01** MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 9.40 mm (0.370 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THE SERVICE BULLETIN.

Figure A-FFNAA - Sheet 02
Flowchart for the Hole H2 to H7 from Frame 42, LH side

****CONF ALL**



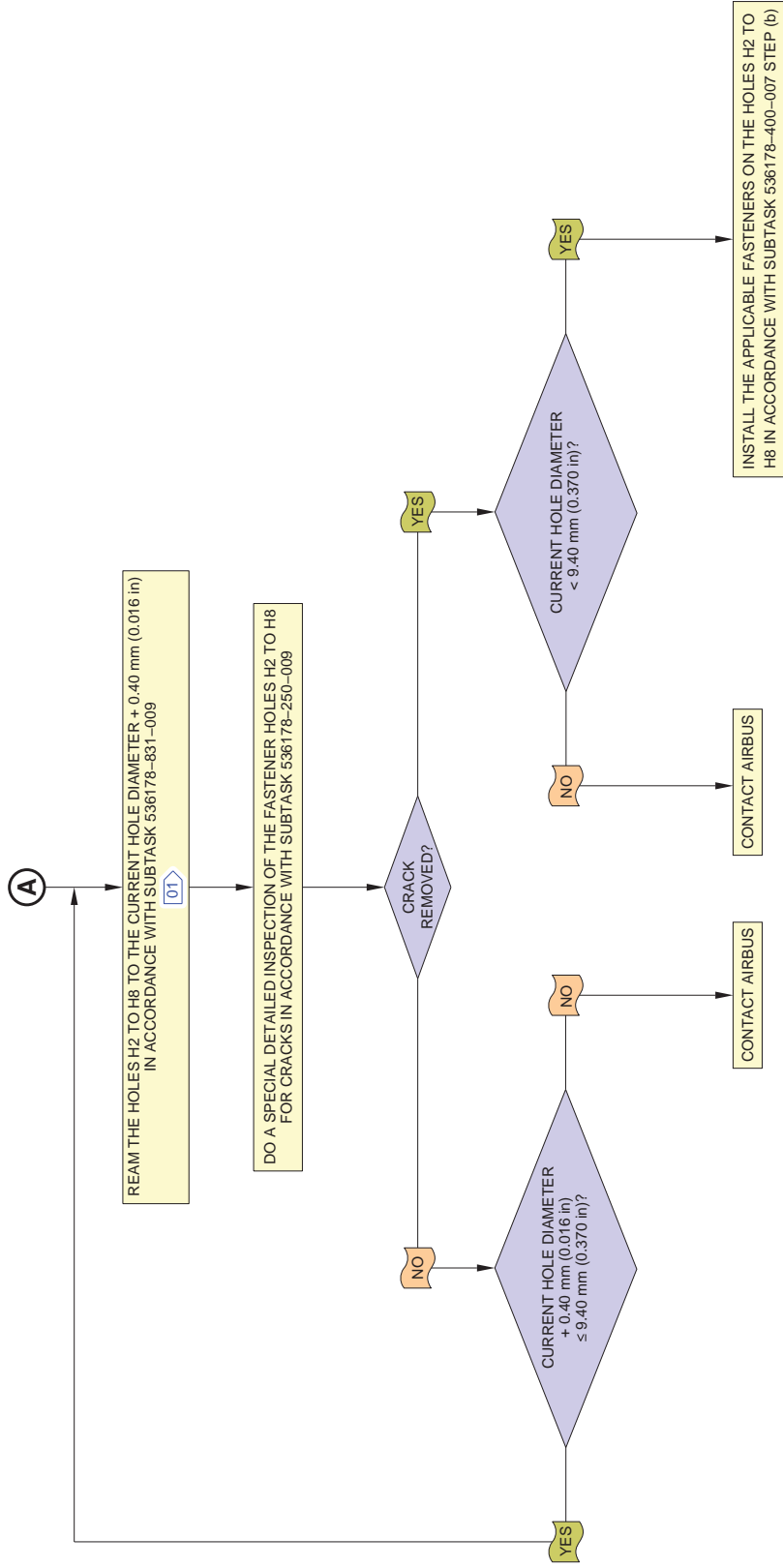
NOTE:

THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FOAA_01_00

Figure A-FFOAA - Sheet 01
Flowchart for the Hole H2 to H8 from Frame 43, LH side

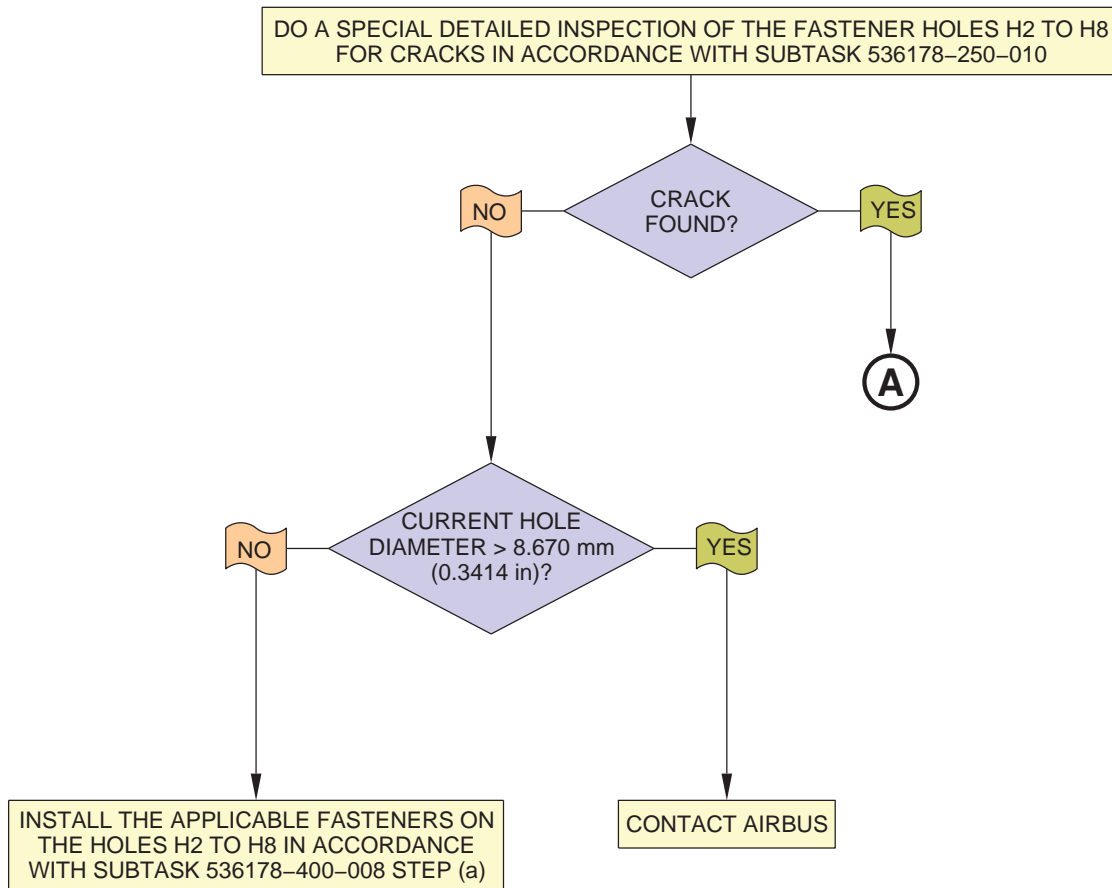
**CONF ALL



NOTE: 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 9.40 mm (0.370 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THE SERVICE BULLETIN.

Figure A-FFOAA - Sheet 02
Flowchart for the Hole H2 to H8 from Frame 43, LH side

****CONF ALL**



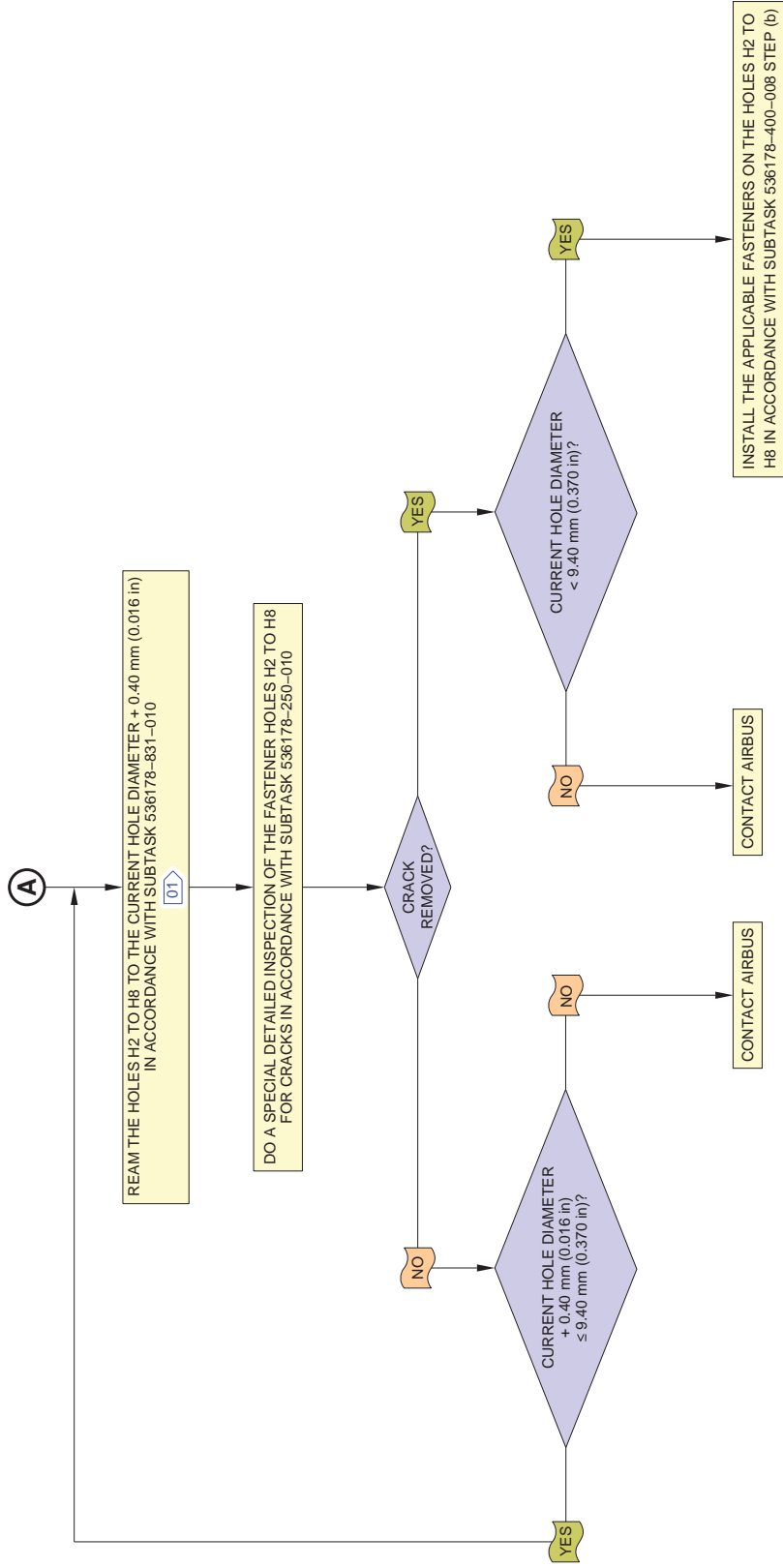
NOTE:

THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FPA01_01_00

Figure A-FFPAA - Sheet 01
Flowchart for the Hole H2 to H8 from Frame 44, LH side

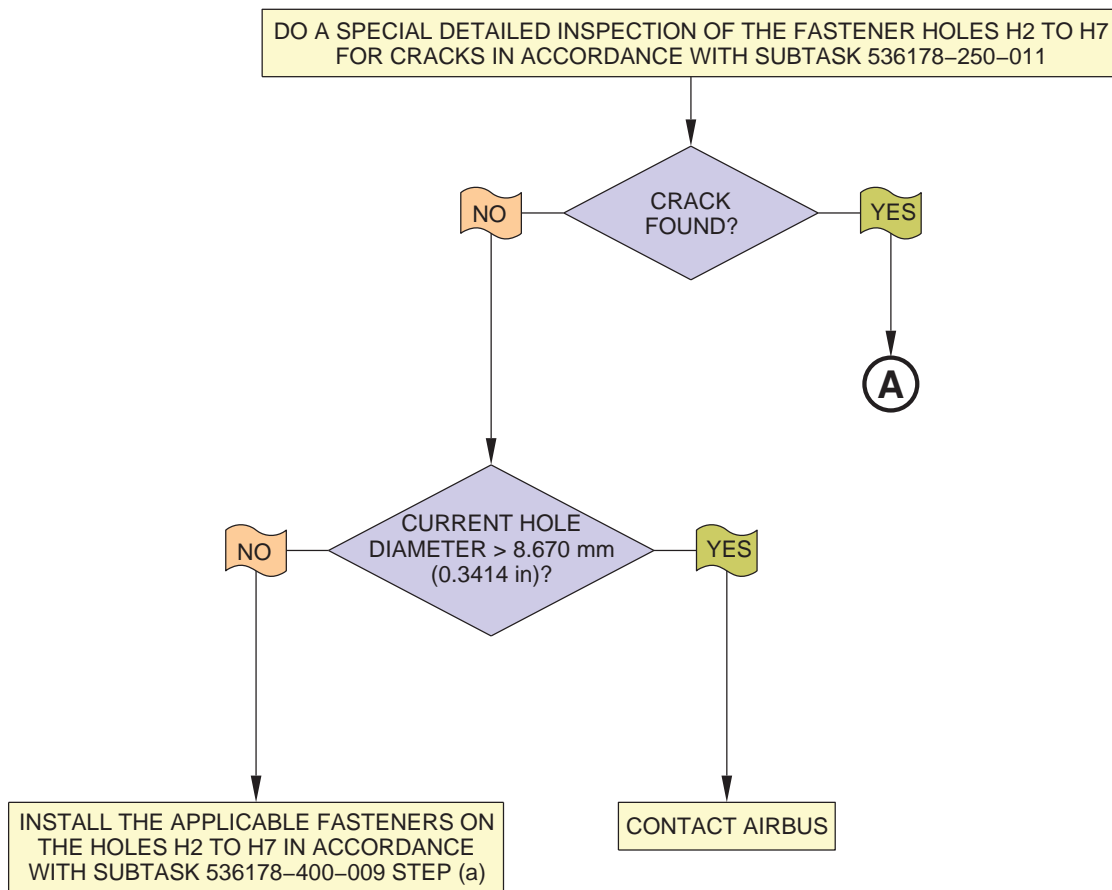
**CONF ALL



NOTE: 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 9.40 mm (0.370 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THE SERVICE BULLETIN.

Figure A-FFPAA - Sheet 02
Flowchart for the Hole H2 to H8 from Frame 44, LH side

**CONF ALL



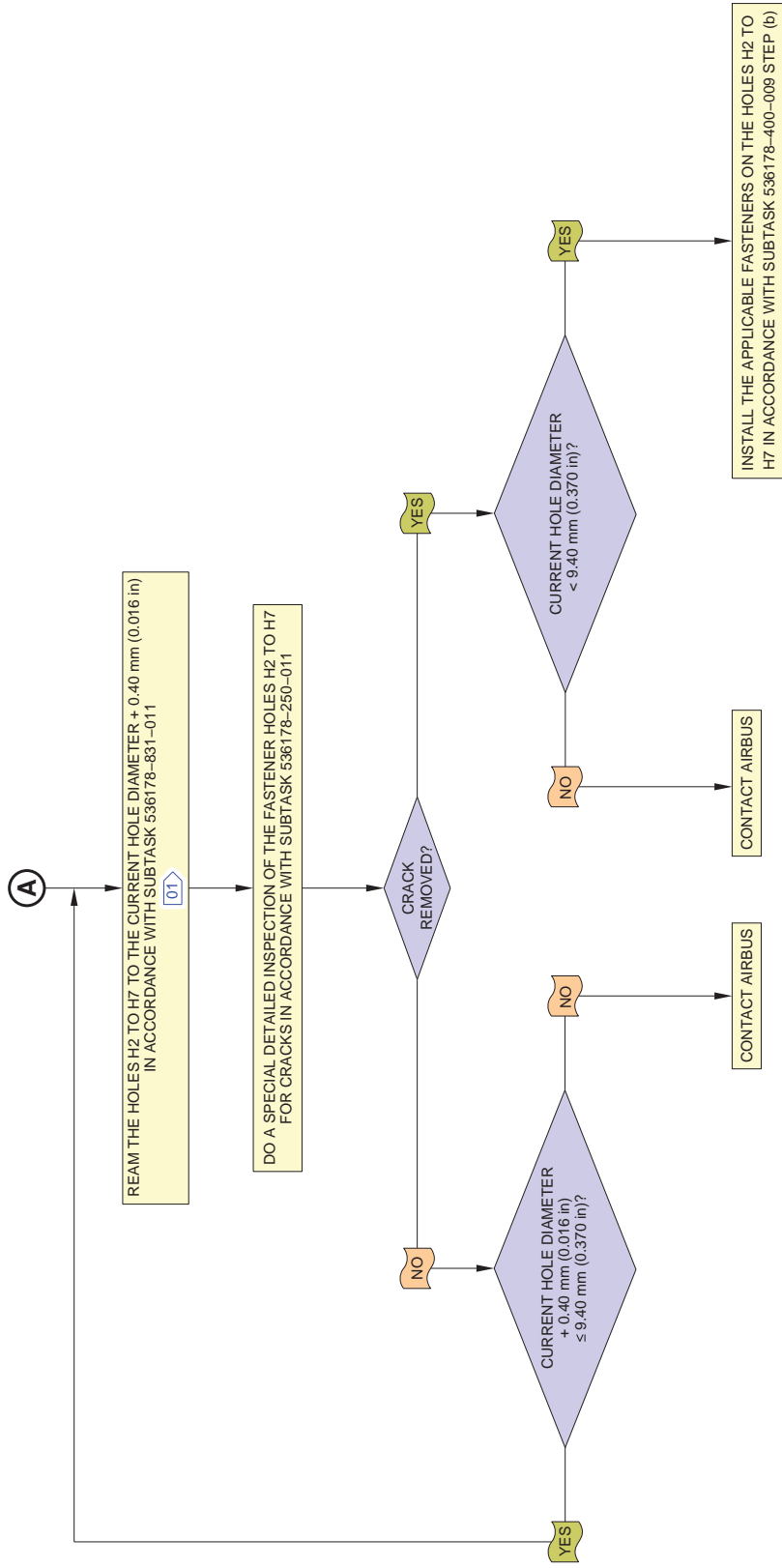
NOTE:

THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FQAA_01_00

Figure A-FFQAA - Sheet 01
Flowchart for the Hole H2 to H7 from Frame 45, LH side

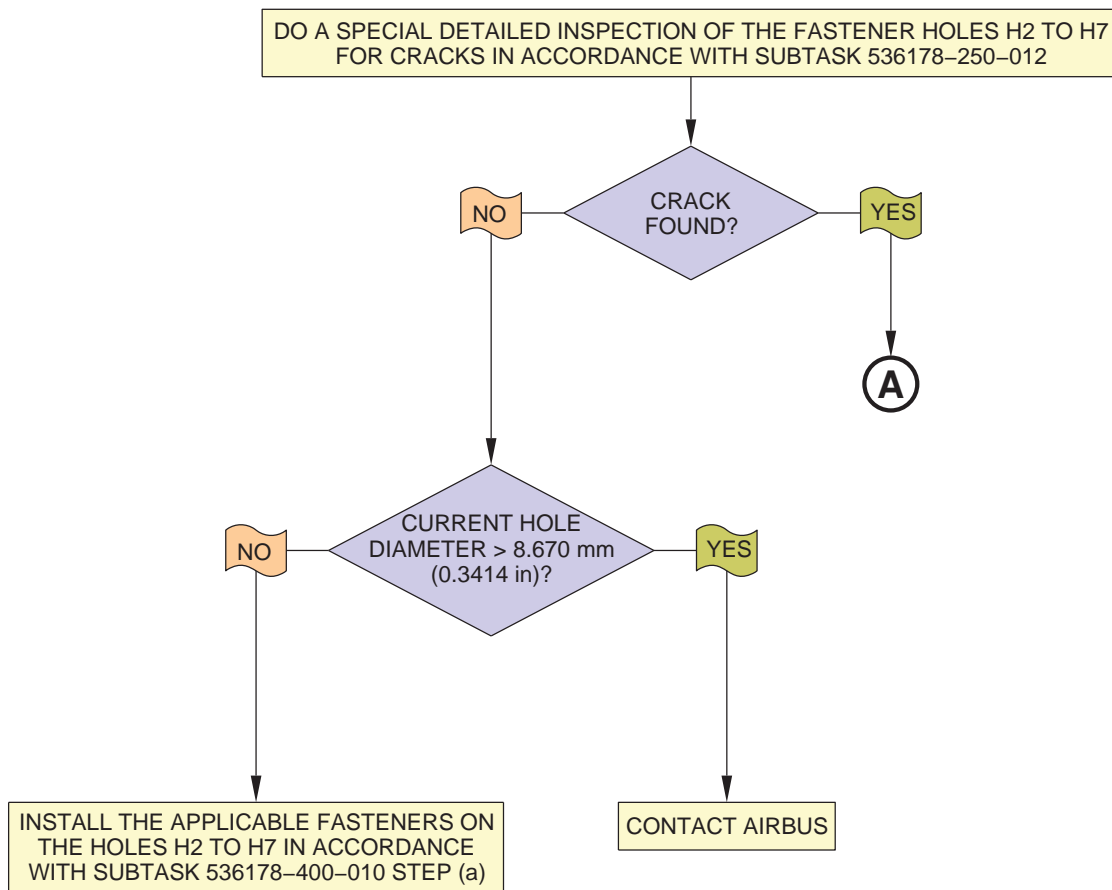
**CONF ALL



NOTE: 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 9.40 mm (0.370 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THE SERVICE BULLETIN.

Figure A-FFQAA - Sheet 02
Flowchart for the Hole H2 to H7 from Frame 45, LH side

****CONF ALL**



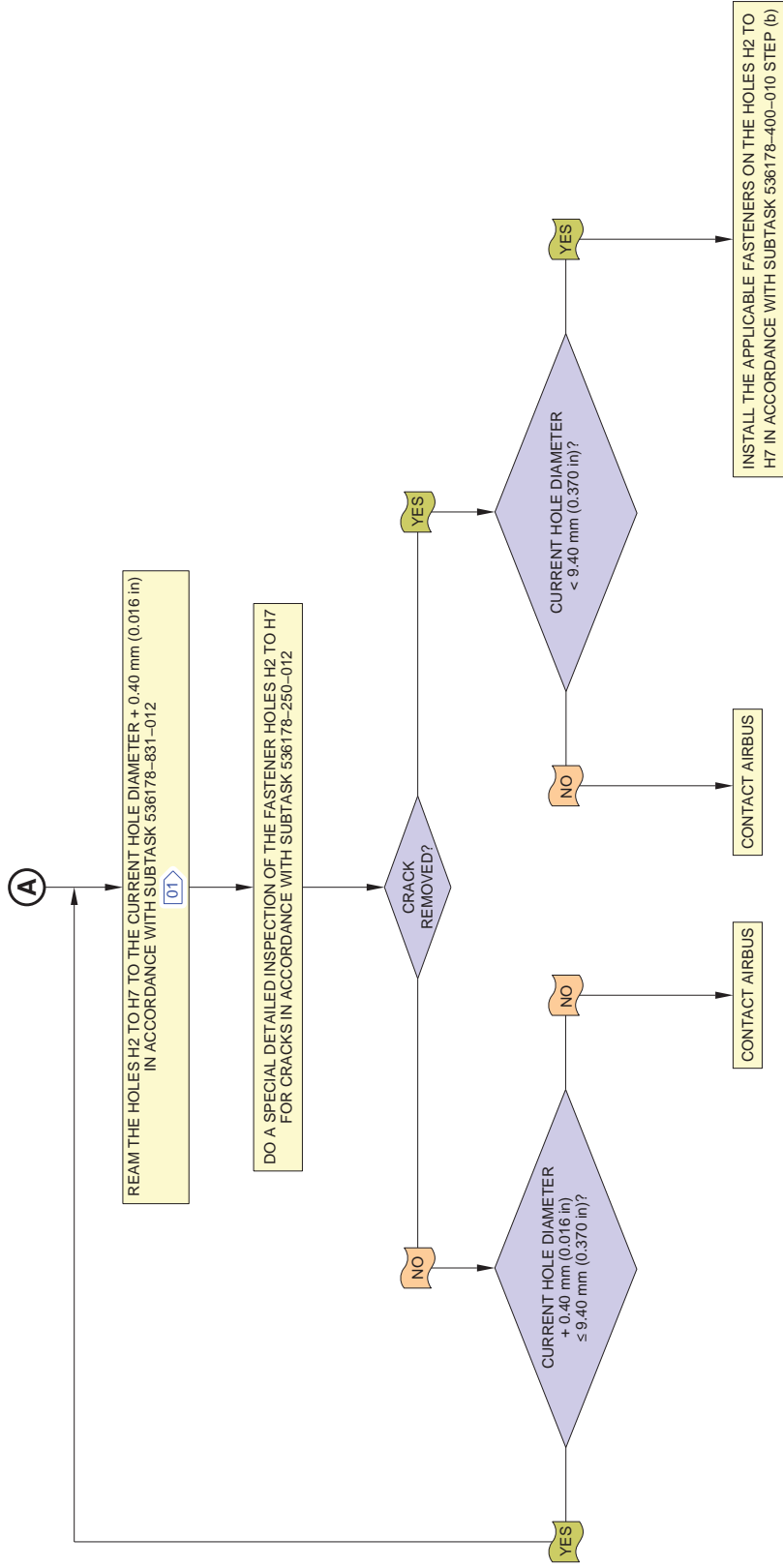
NOTE:

THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FFRAA_01_00

Figure A-FFRAA - Sheet 01
Flowchart for the Hole H2 to H7 from Frame 46, LH side

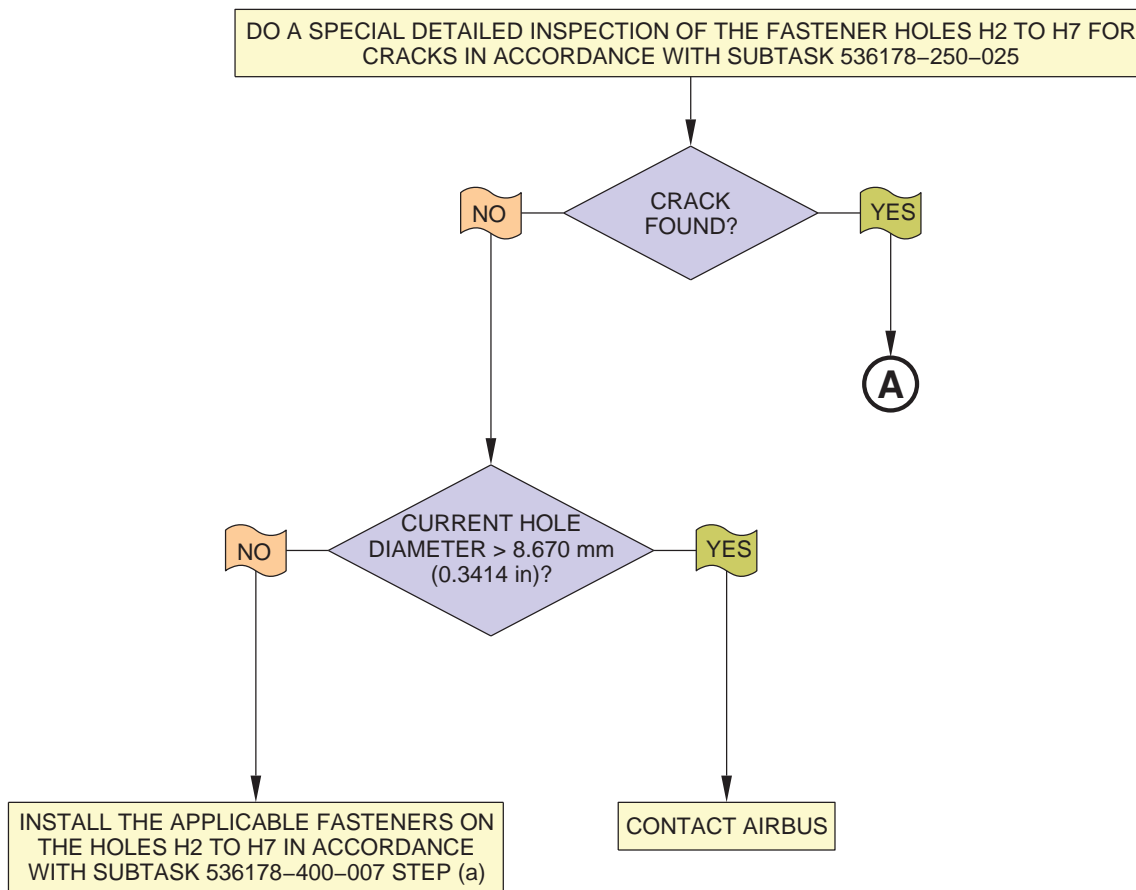
**CONF ALL



NOTE: **01** MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 9.40 mm (0.370 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THE SERVICE BULLETIN.

Figure A-FFRAA - Sheet 02
Flowchart for the Hole H2 to H7 from Frame 46, LH side

****CONF ALL**



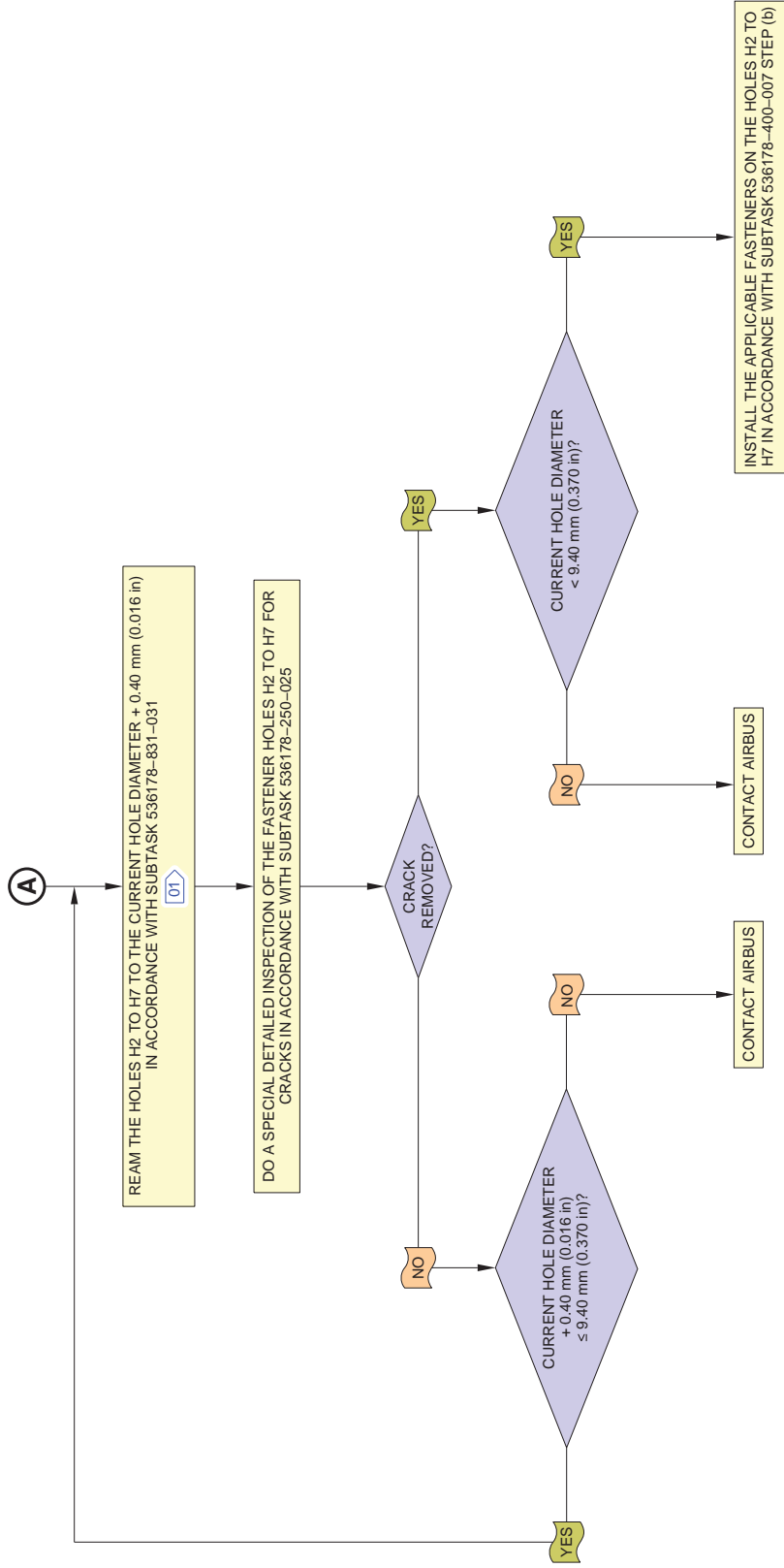
NOTE:

THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FSAA_01_00

Figure A-FFSAA - Sheet 01
Flowchart for the Hole H2 to H7 from Frame 41, RH side

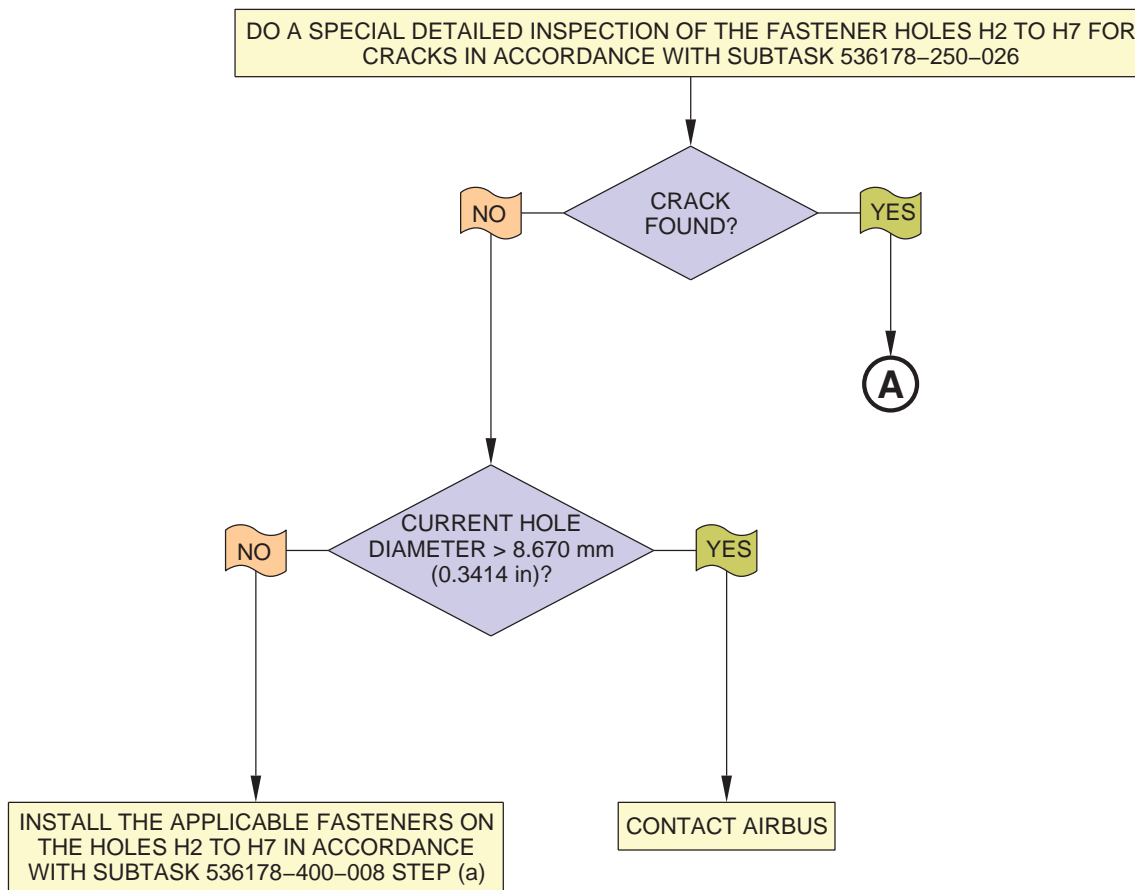
**CONF ALL



NOTE:
 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 9.40 mm (0.370 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

Figure A-FFSAA - Sheet 02
 Flowchart for the Hole H2 to H7 from Frame 41, RH side

****CONF ALL**



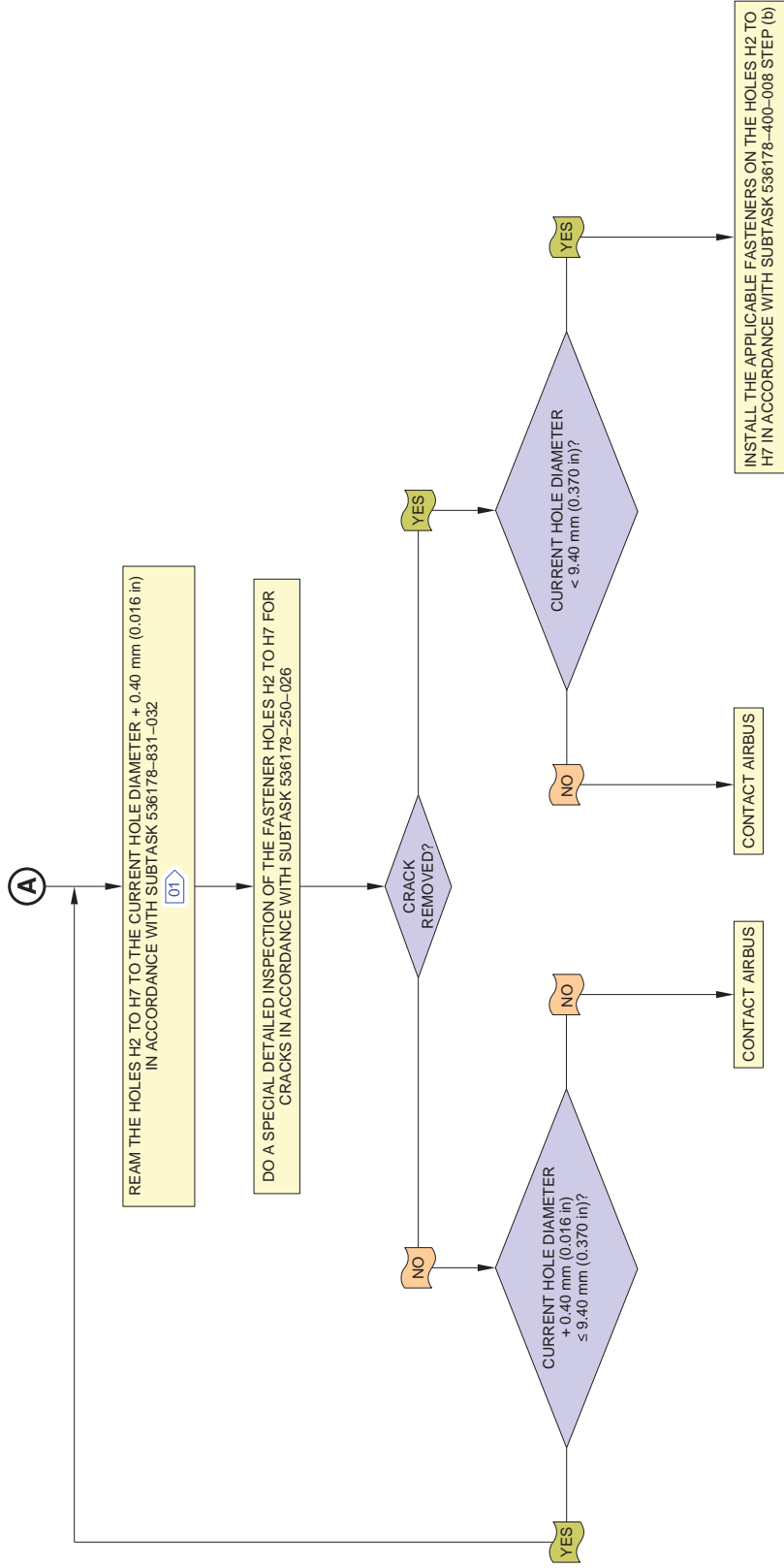
NOTE:

THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FTA01_01

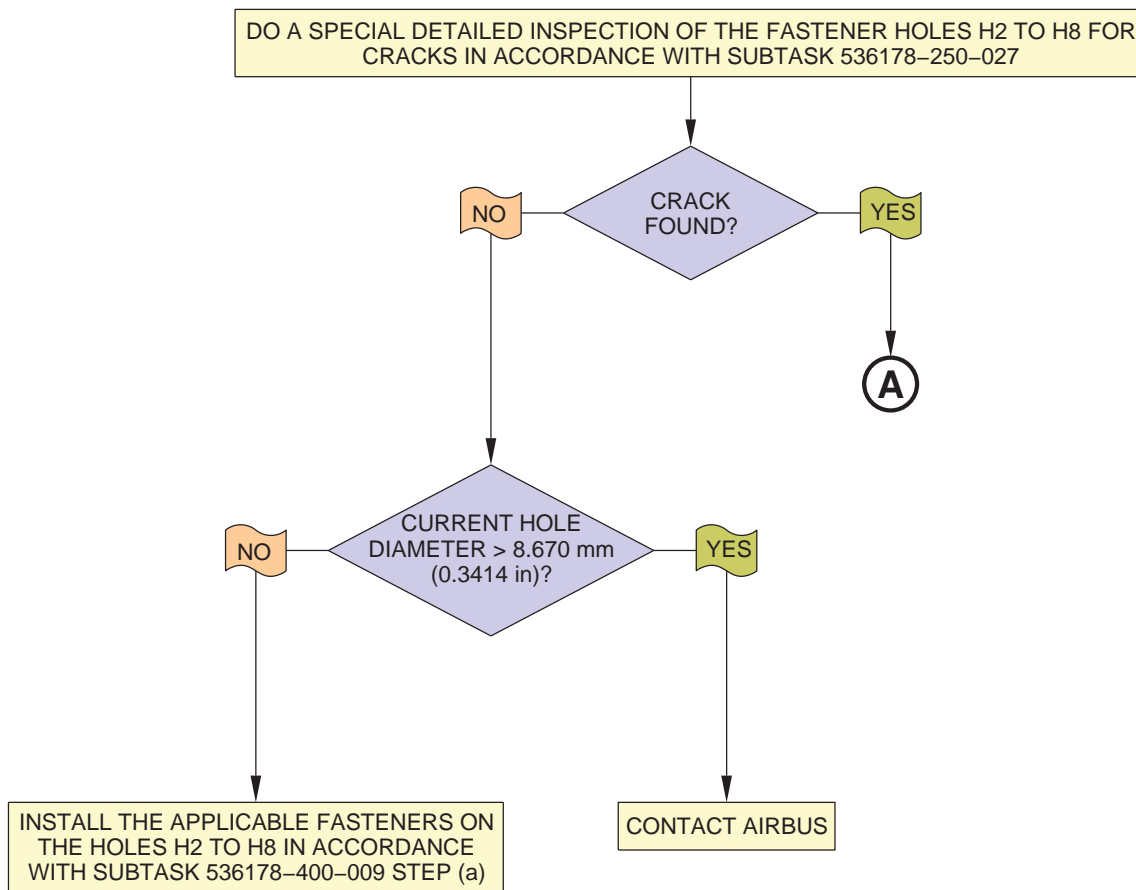
Figure A-FFTA01 - Sheet 01
Flowchart for the Hole H2 to H7 from Frame 42, RH side

**CONF ALL



NOTE:
01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 9.40 mm (0.370 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

****CONF ALL**



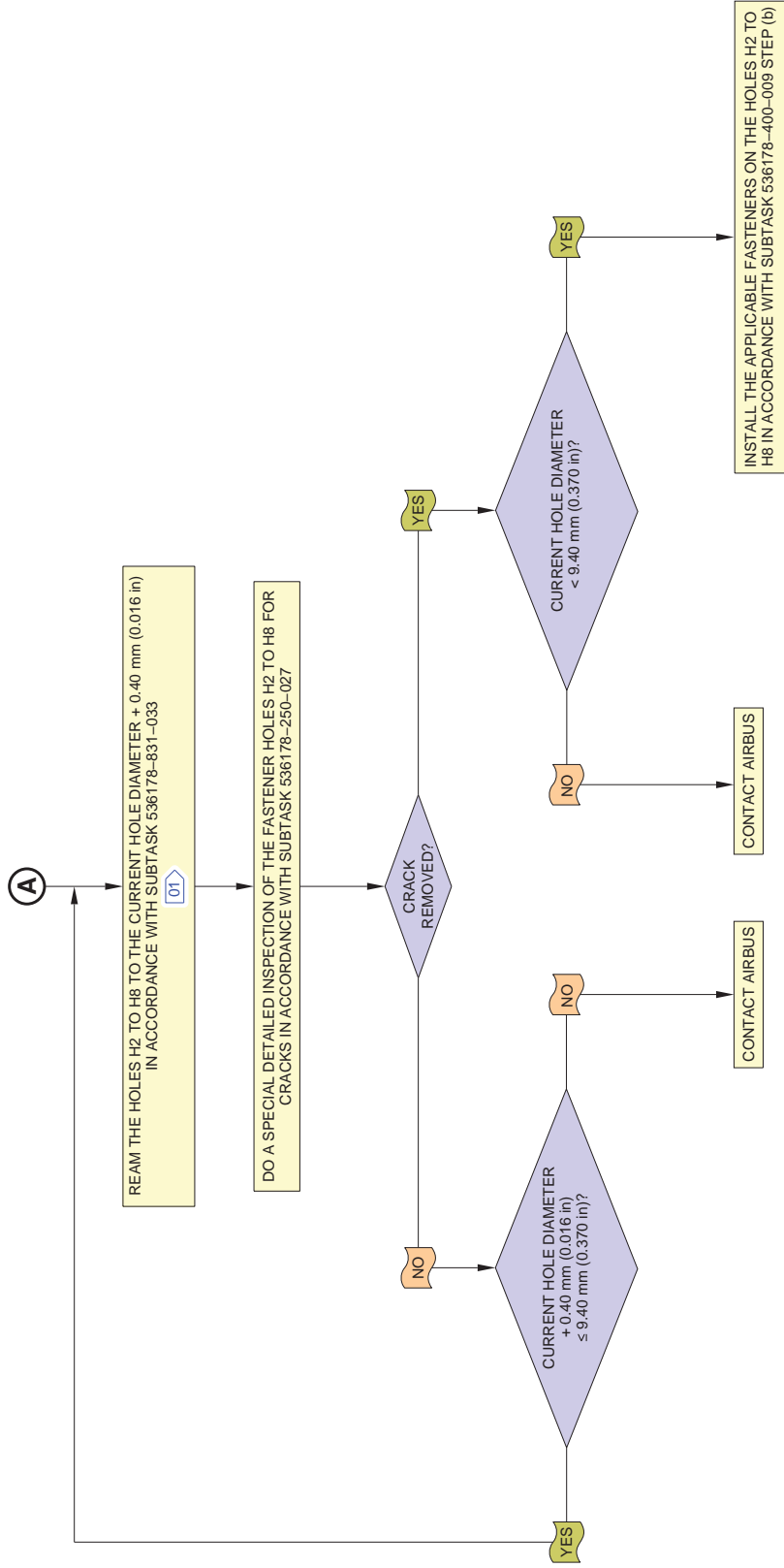
NOTE:

THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FUAA_01_00

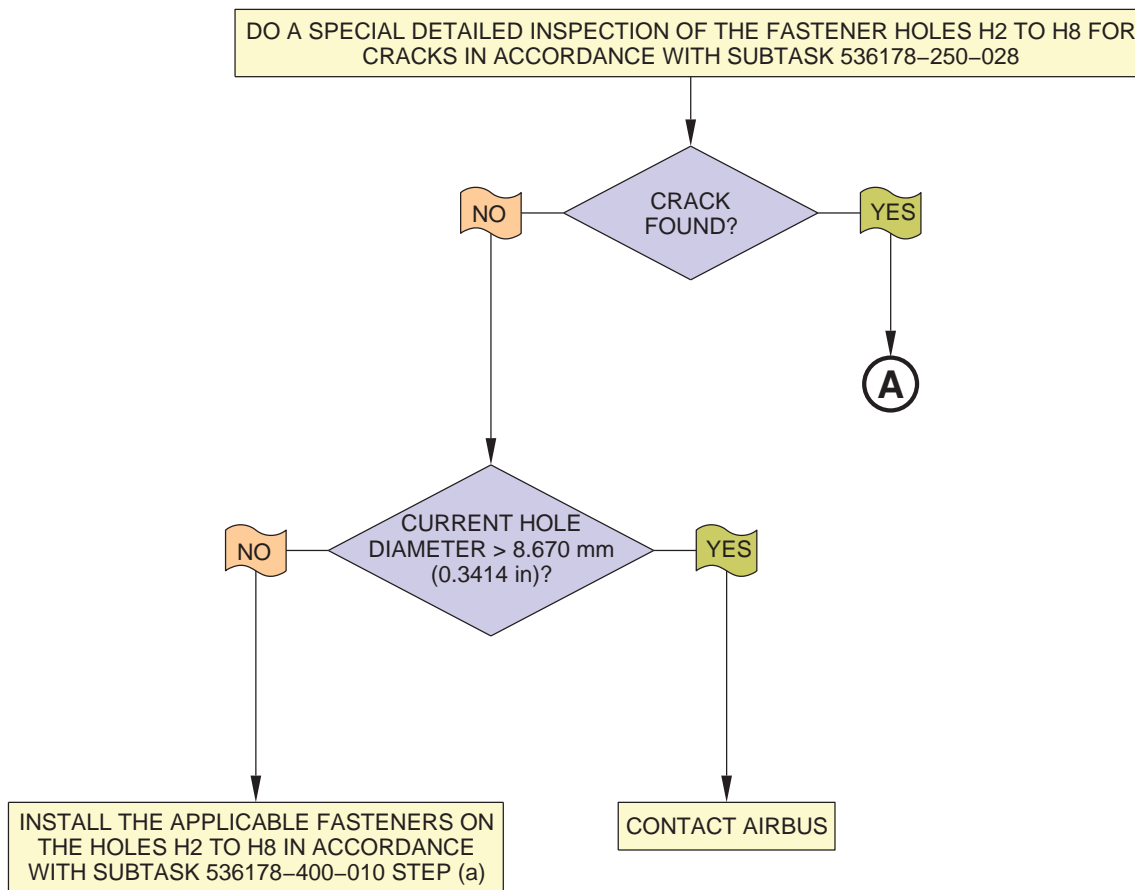
Figure A-FFUAA - Sheet 01
Flowchart for the Hole H2 to H8 from Frame 43, RH side

**CONF ALL



NOTE:
 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 9.40 mm (0.370 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

****CONF ALL**



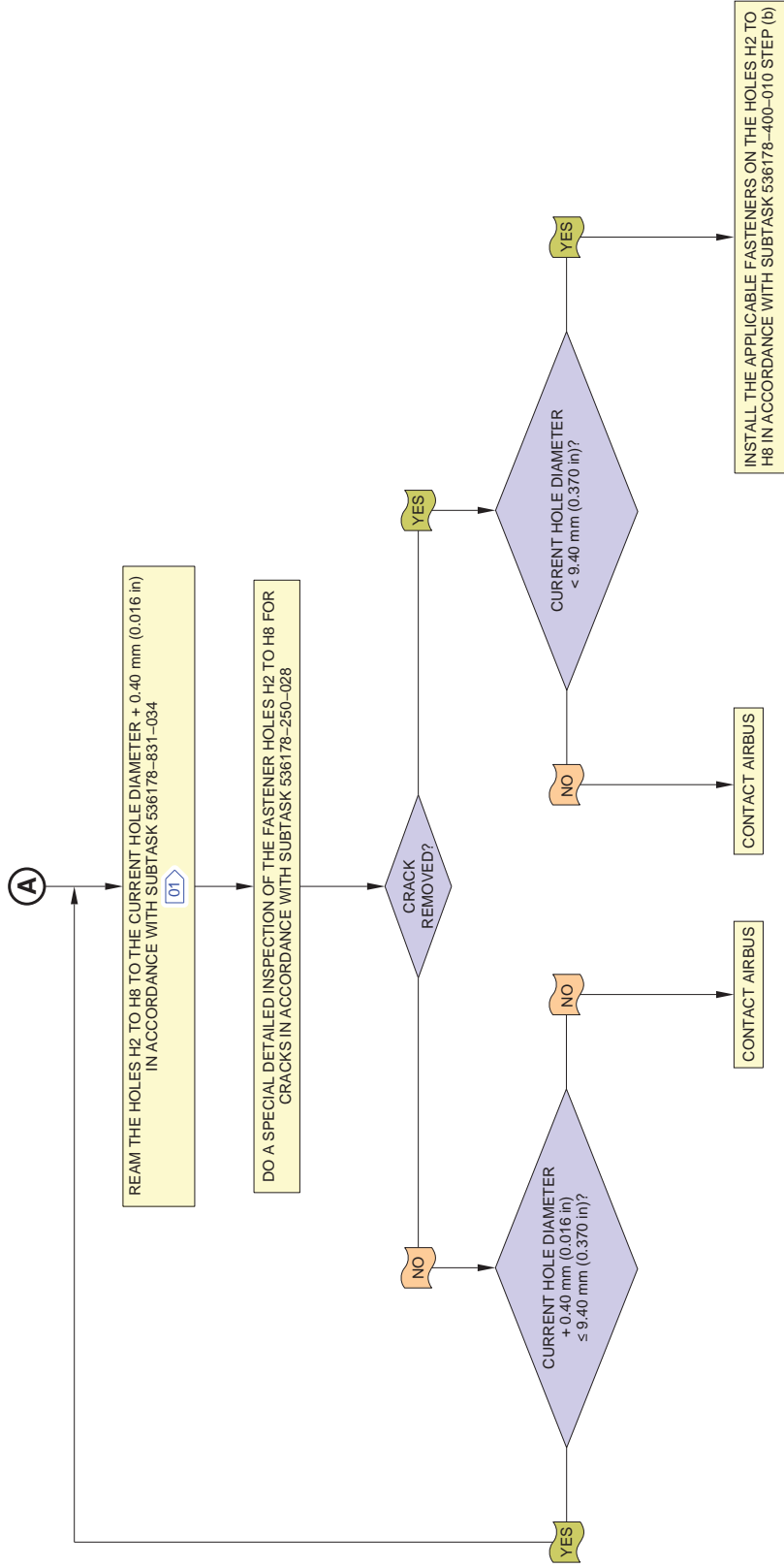
NOTE:

THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FVAA_01_00

Figure A-FFVAA - Sheet 01
Flowchart for the Hole H2 to H8 from Frame 44, RH side

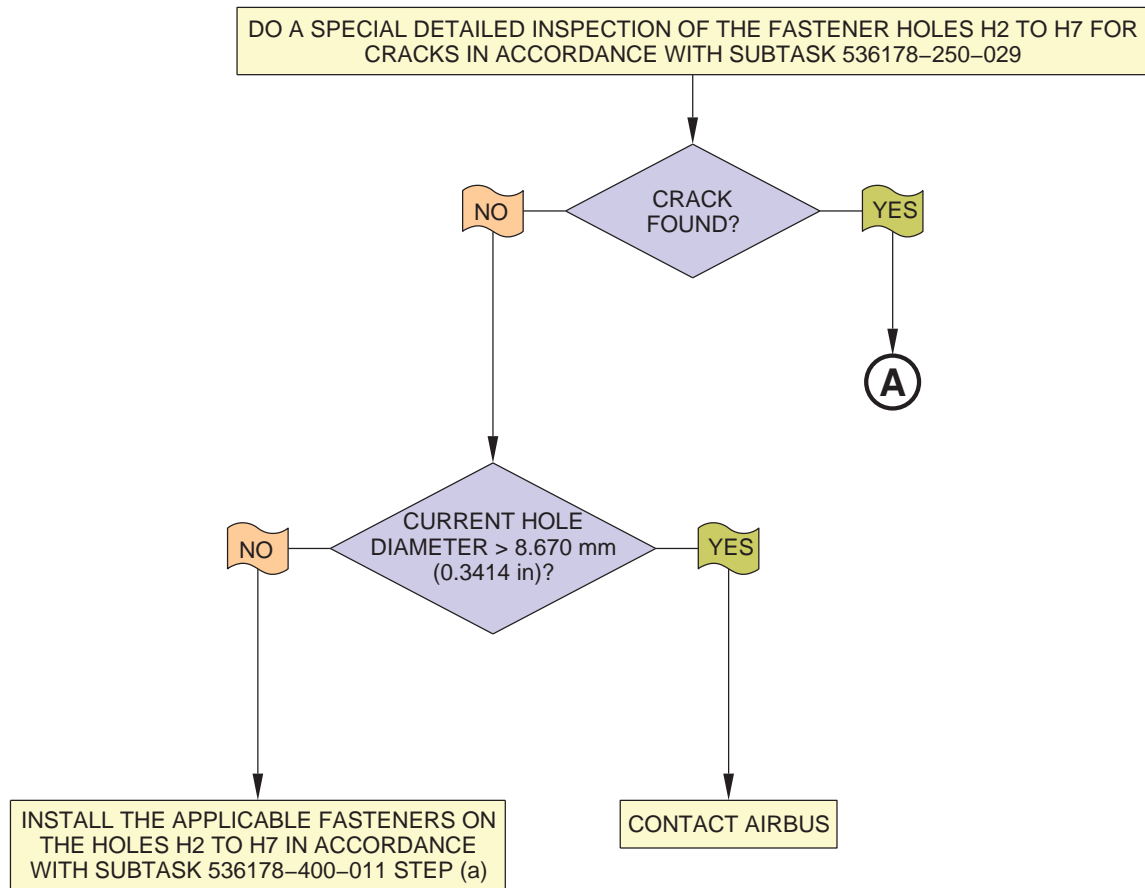
**CONF ALL



NOTE:
 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 9.40 mm (0.370 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

Figure A-FFVAA - Sheet 02
 Flowchart for the Hole H2 to H8 from Frame 44, RH side

****CONF ALL**



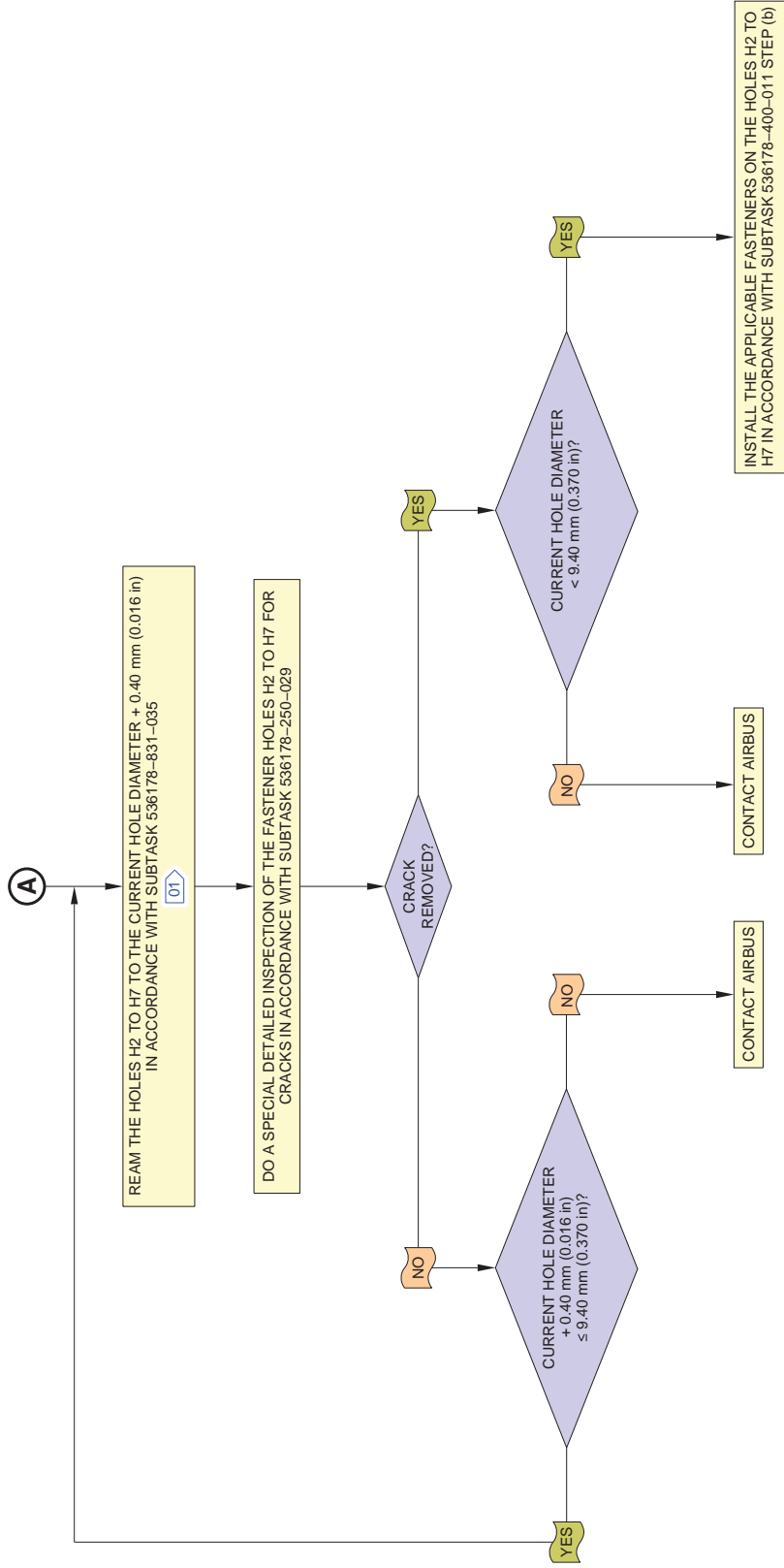
NOTE:

THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FWAA_01_00

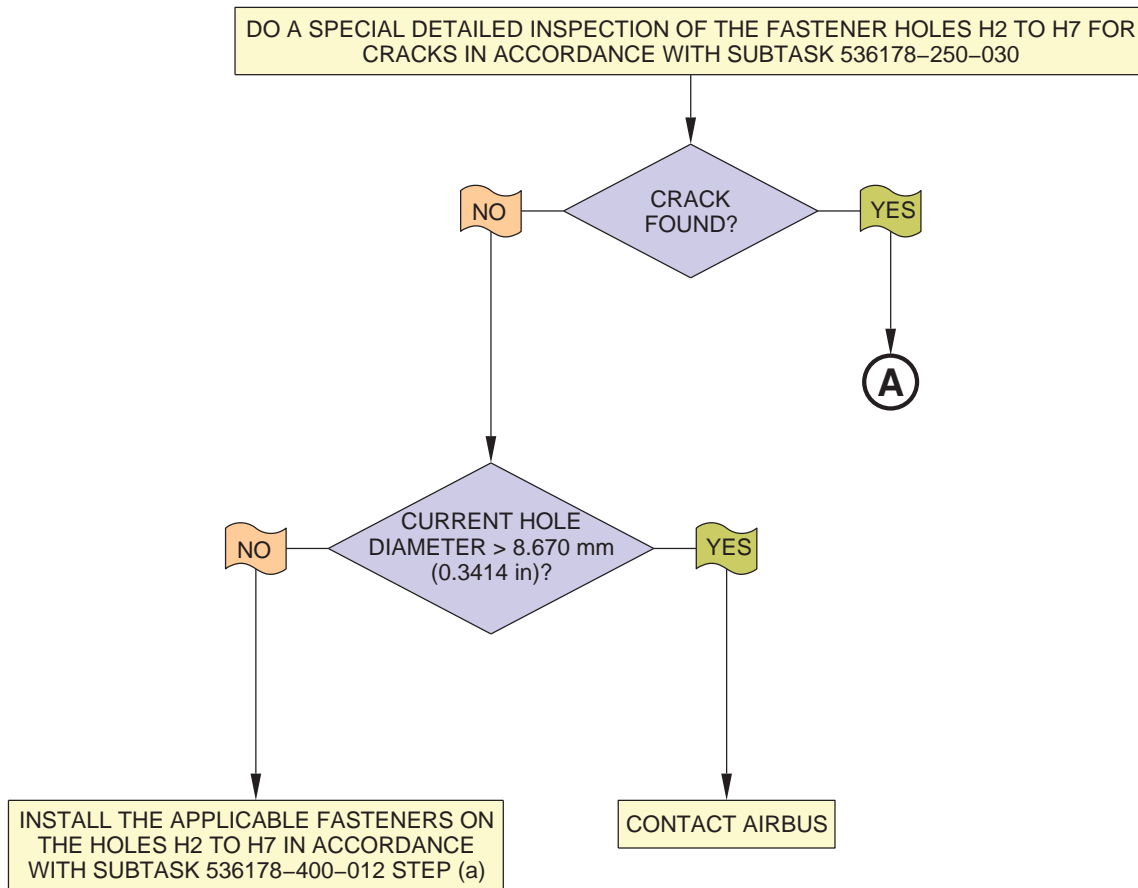
Figure A-FFWAA - Sheet 01
Flowchart for the Hole H2 to H7 from Frame 45, RH side

**CONF ALL



NOTE:
 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 9.40 mm (0.370 in).
 THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE
 AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR
 COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

****CONF ALL**



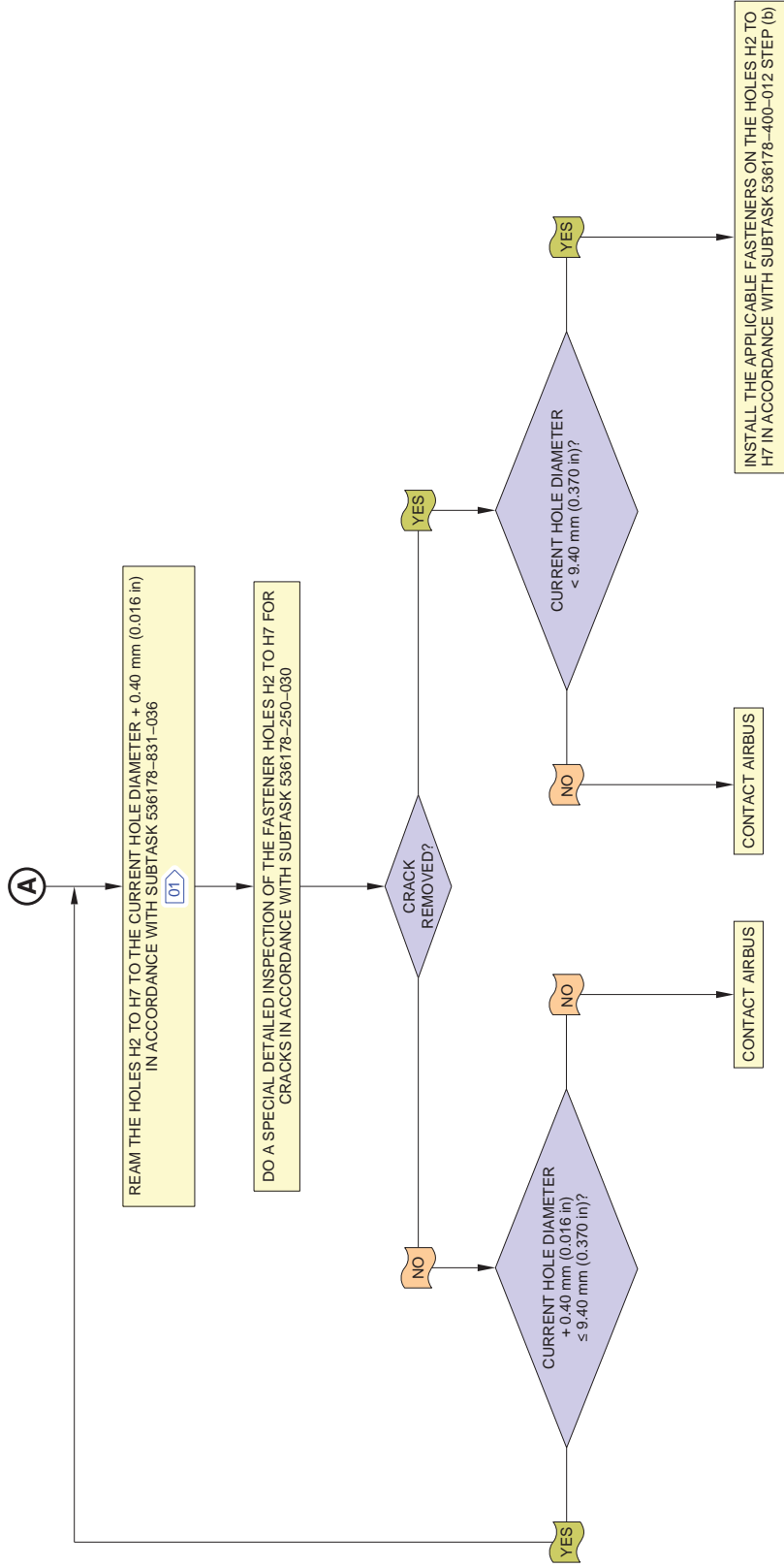
NOTE:

THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

D_SB_536178_5_FXAA_01_00

Figure A-FFXAA - Sheet 01
Flowchart for the Hole H2 to H7 from Frame 46, RH side

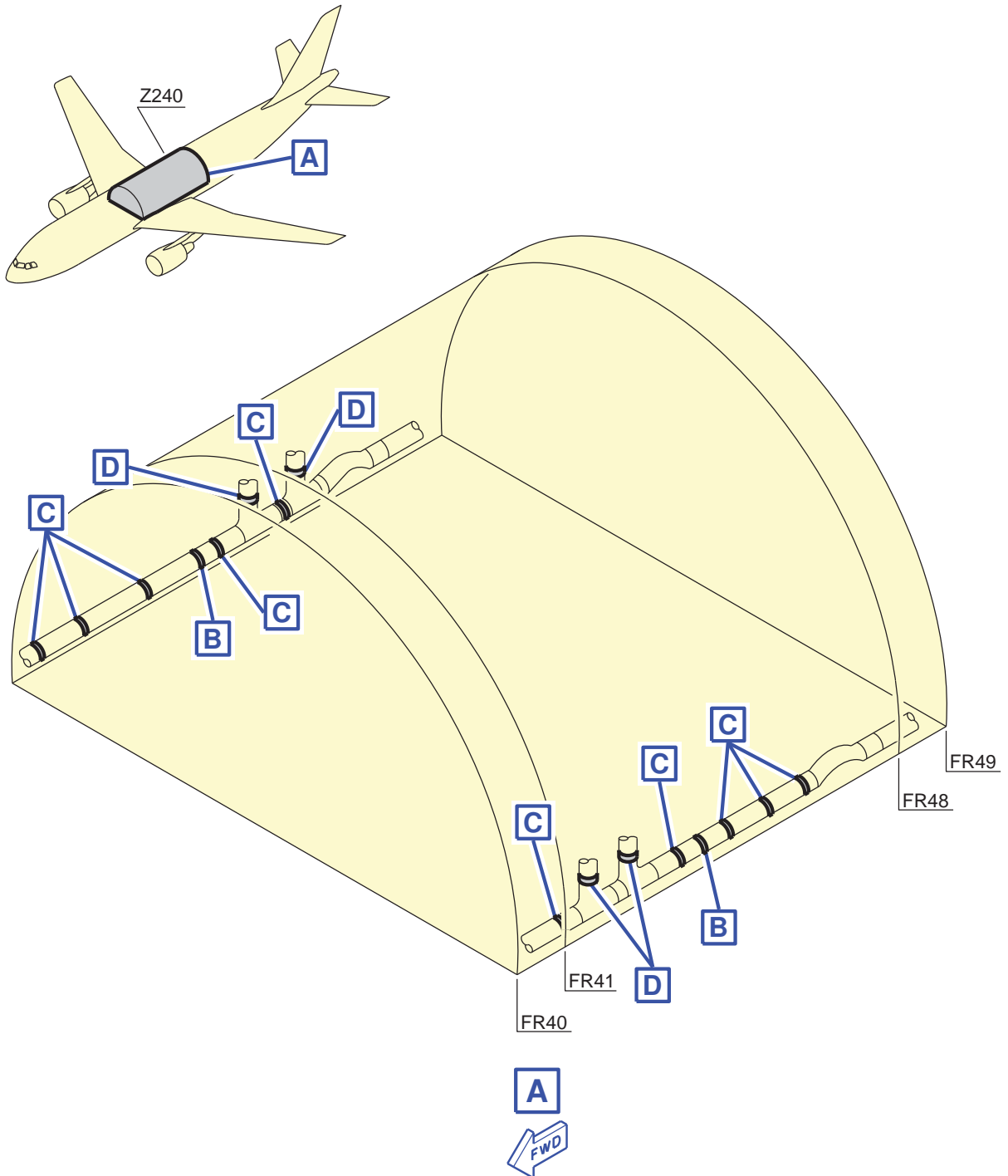
**CONF ALL



NOTE:
 01 MAKE SURE THAT THE CURRENT HOLE DIAMETER IS LESS THAN OR EQUAL TO THE LIMIT DIAMETER OF 9.40 mm (0.370 in). THE PURPOSE OF FLOWCHARTS IS TO SUPPLEMENT THE INFORMATION GIVEN IN THE PROCEDURE AND COMPLIANCE PARAGRAPHS AND NOT TO SERVE AS THE PRIMARY SOURCE FOR TASKS OR COMPLIANCE TIMES GIVEN IN THIS SERVICE BULLETIN.

Figure A-FFXAA - Sheet 02
 Flowchart for the Hole H2 to H7 from Frame 46, RH side

**CONF 003 thru 004



D_SB_536178_5_GAAA_01_00

Figure A-FGAAA - Sheet 01

Principle for the Removal and the Installation of the Smoke Detector Pipes in the Modification Area

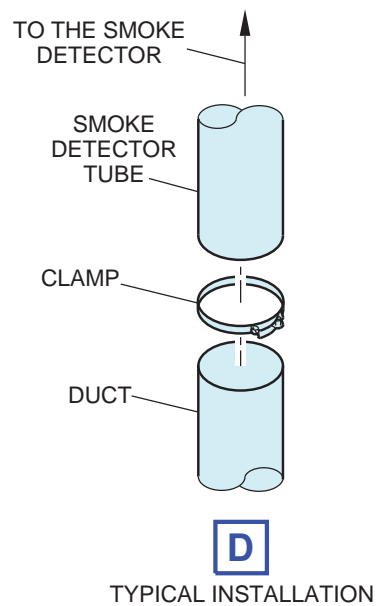
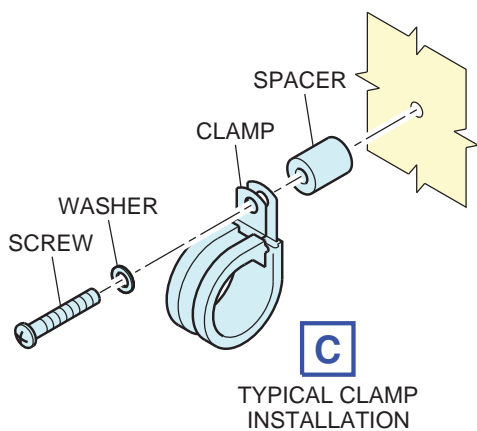
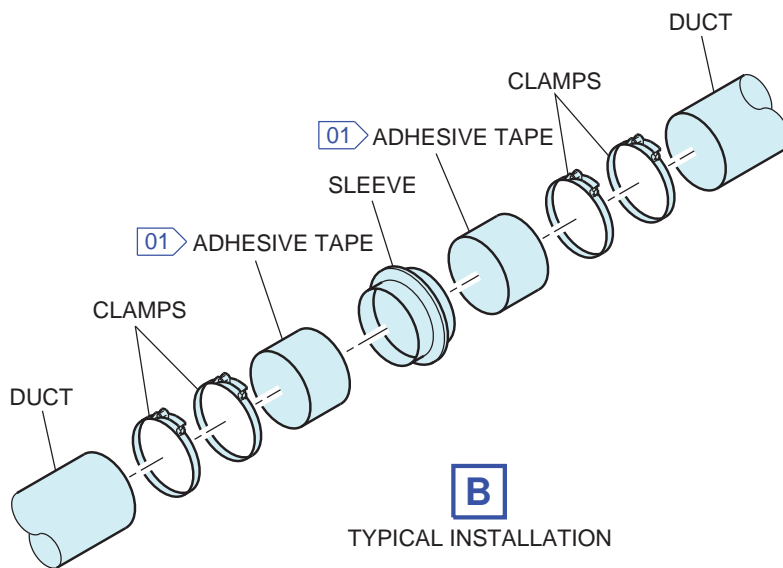
5 DATE: Mar 17/15

SERVICE BULLETIN No.: A300-53-6178

REVISION No.: 01 - Sep 20/19

Page: 1616

****CONF 003 thru 004**



NOTE:

01 ADHESIVE TAPE TO BE REPLACED.

D_SB_536178_5_GAAA_02_00

Figure A-FGAAA - Sheet 02

Principle for the Removal and the Installation of the Smoke Detector Pipes in the Modification Area

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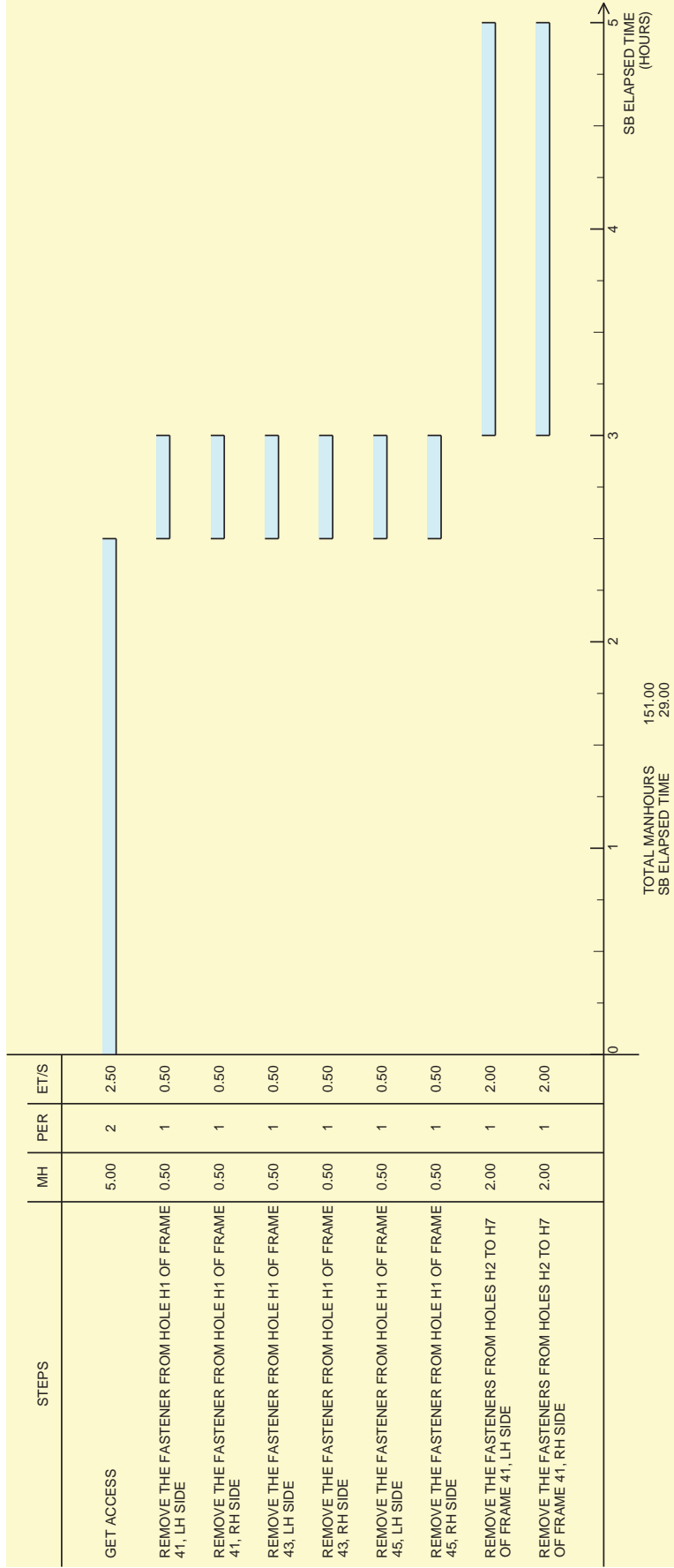
****CONF ALL**

- (1) For an explanation of the man-hours and elapsed time, refer to the following Gantt Chart.

**CONF ALL

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A300-53-6178

01 02



NOTE:

GANTT CHART CONTINUES ON SHEET 02.

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

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

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

D_SB_536178_5_AAAA_01_02

Figure A-FAAAA - Sheet 01
Gantt Chart

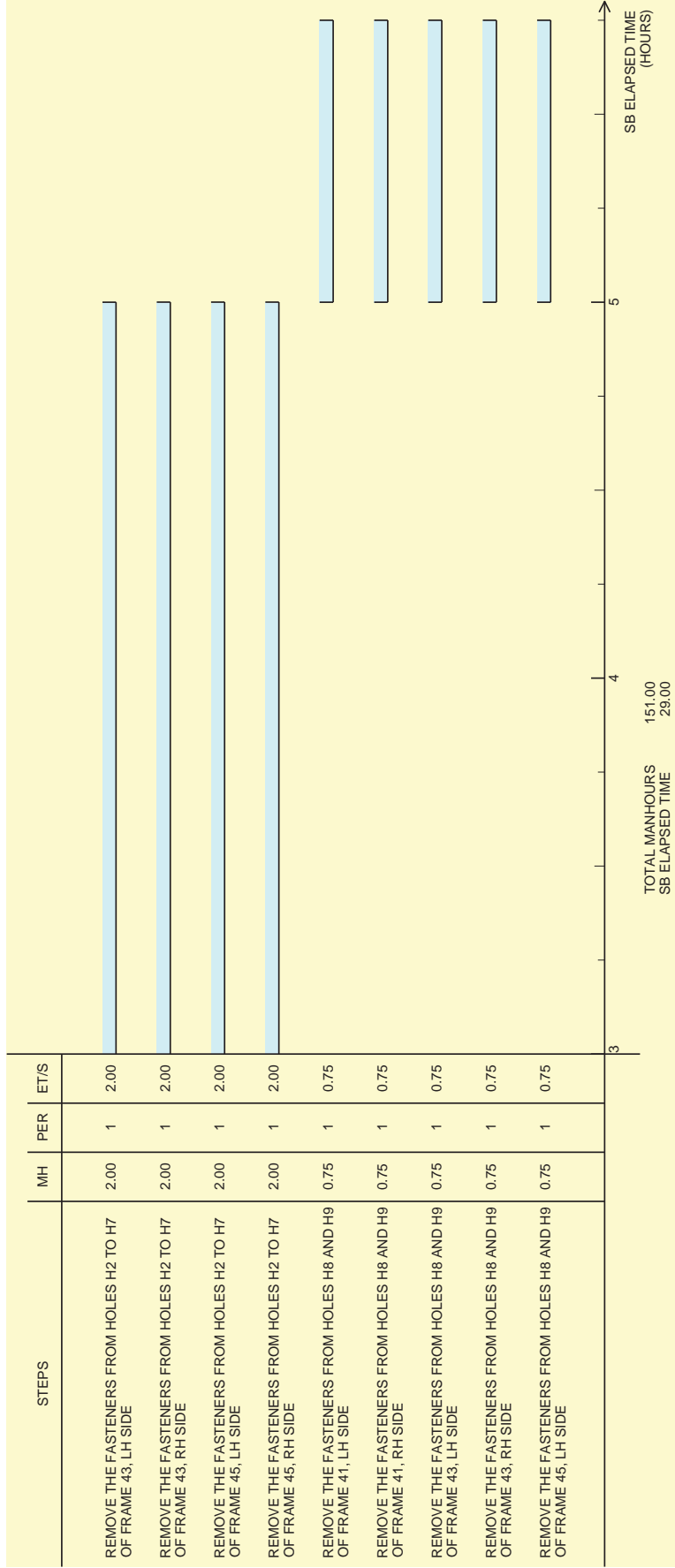


SERVICE BULLETIN
Appendix 01 - Elapsed Time Assumption

**CONF ALL

01 02

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A300-53-6178



NOTE:

GANTT CHART CONTINUES ON SHEET 03.

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

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

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

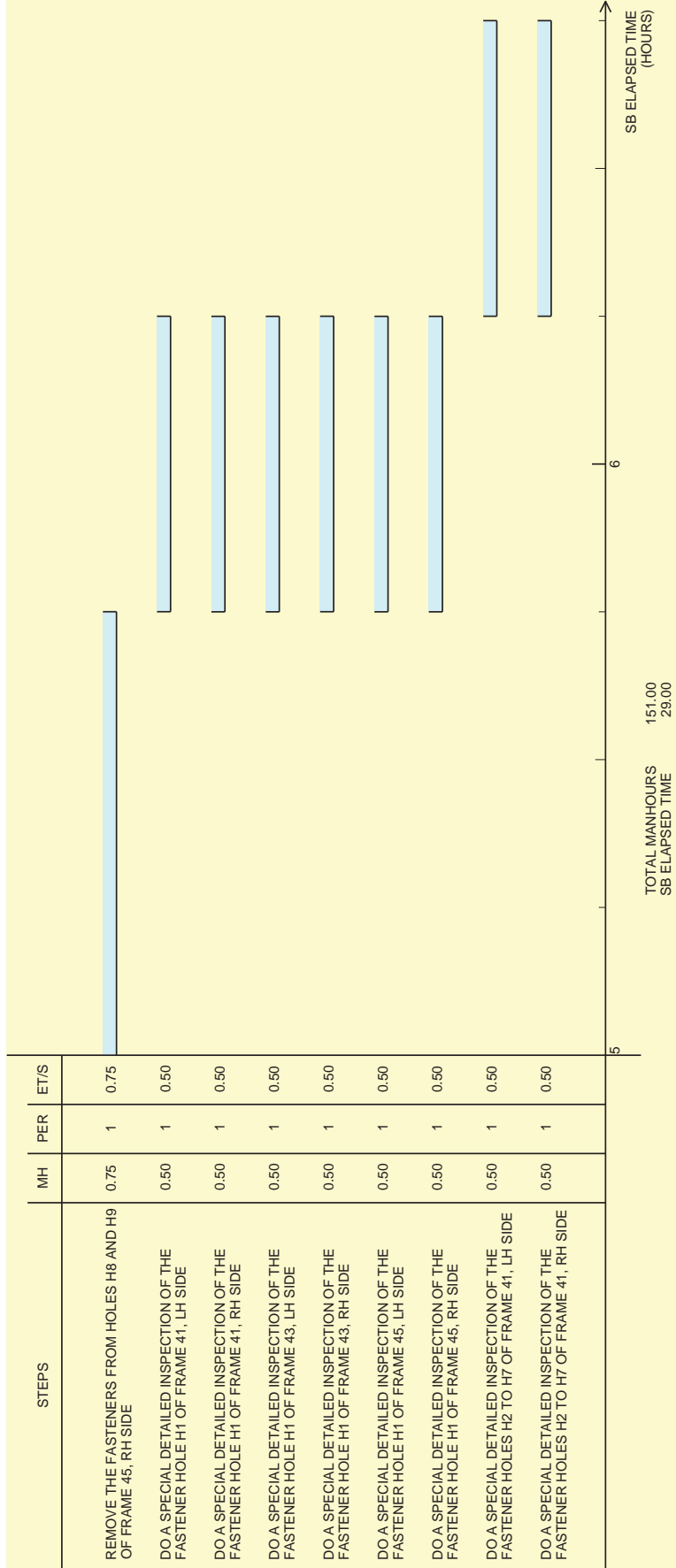
D_SB_536178_5_AAAA_02_01

Figure A-FAAAA - Sheet 02
Gantt Chart

**CONF ALL

01 02

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A300-53-6178



NOTE:

GANTT CHART CONTINUES ON SHEET 04.

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

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

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

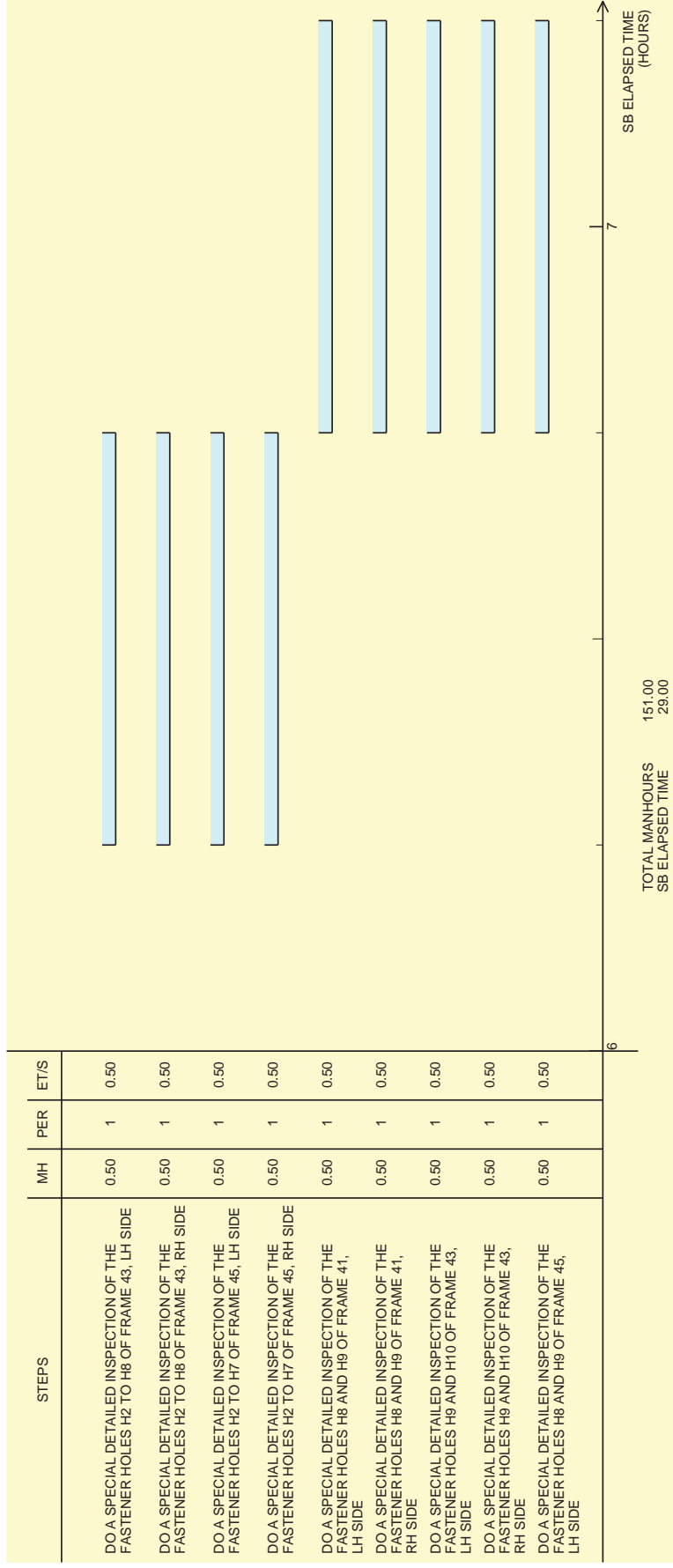
D_SB_536178_5_AAAA_03_01

Figure A-FAAAA - Sheet 03
Gantt Chart

**CONF ALL

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A300-53-6178

01 02



NOTE:

GANTT CHART CONTINUES ON SHEET 05.

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

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

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

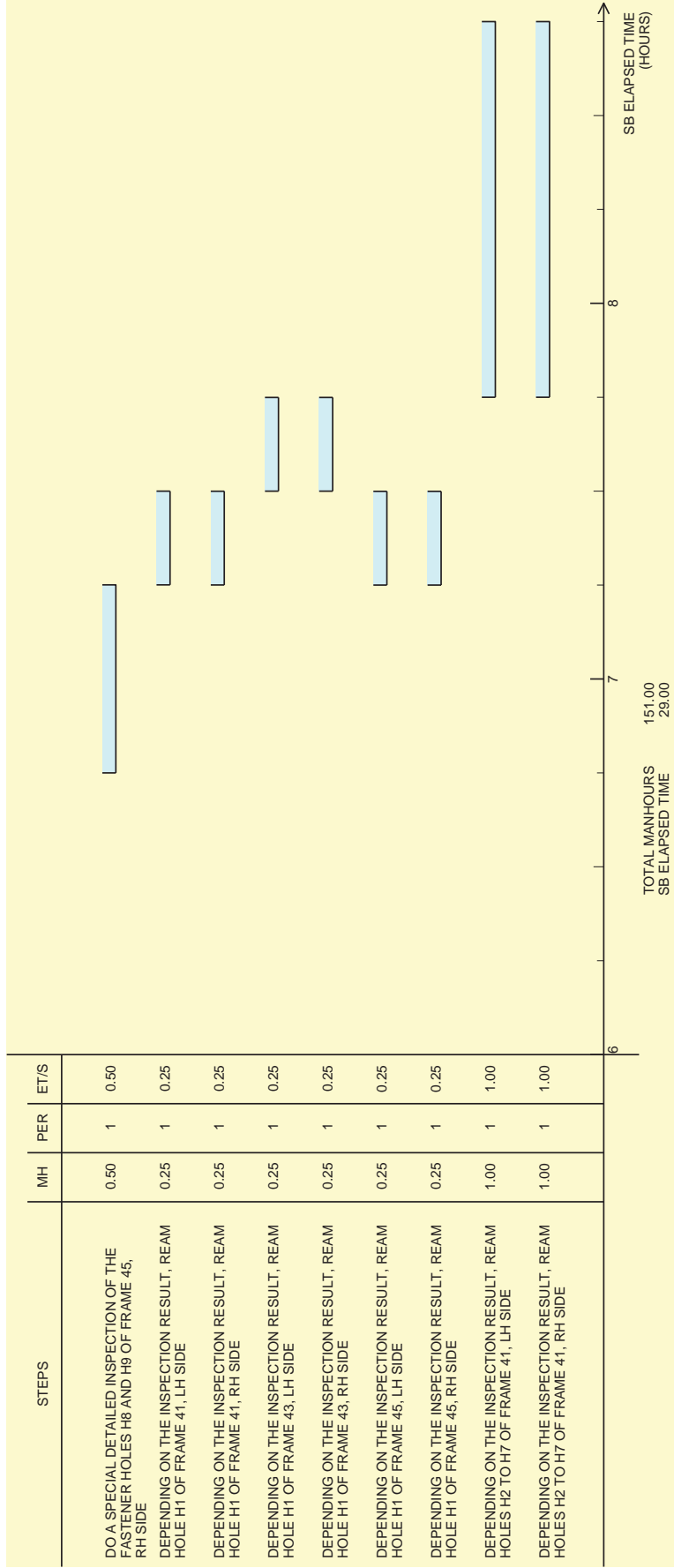
D_SB_536178_5_AAAA_04_01

Figure A-FAAAA - Sheet 04
Gantt Chart

**CONF ALL

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A300-53-6178

01 02



NOTE:

GANTT CHART CONTINUES ON SHEET 06.

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

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

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

D_SB_536178_5_AAAA_05_00

Figure A-FAAAA - Sheet 05
Gantt Chart

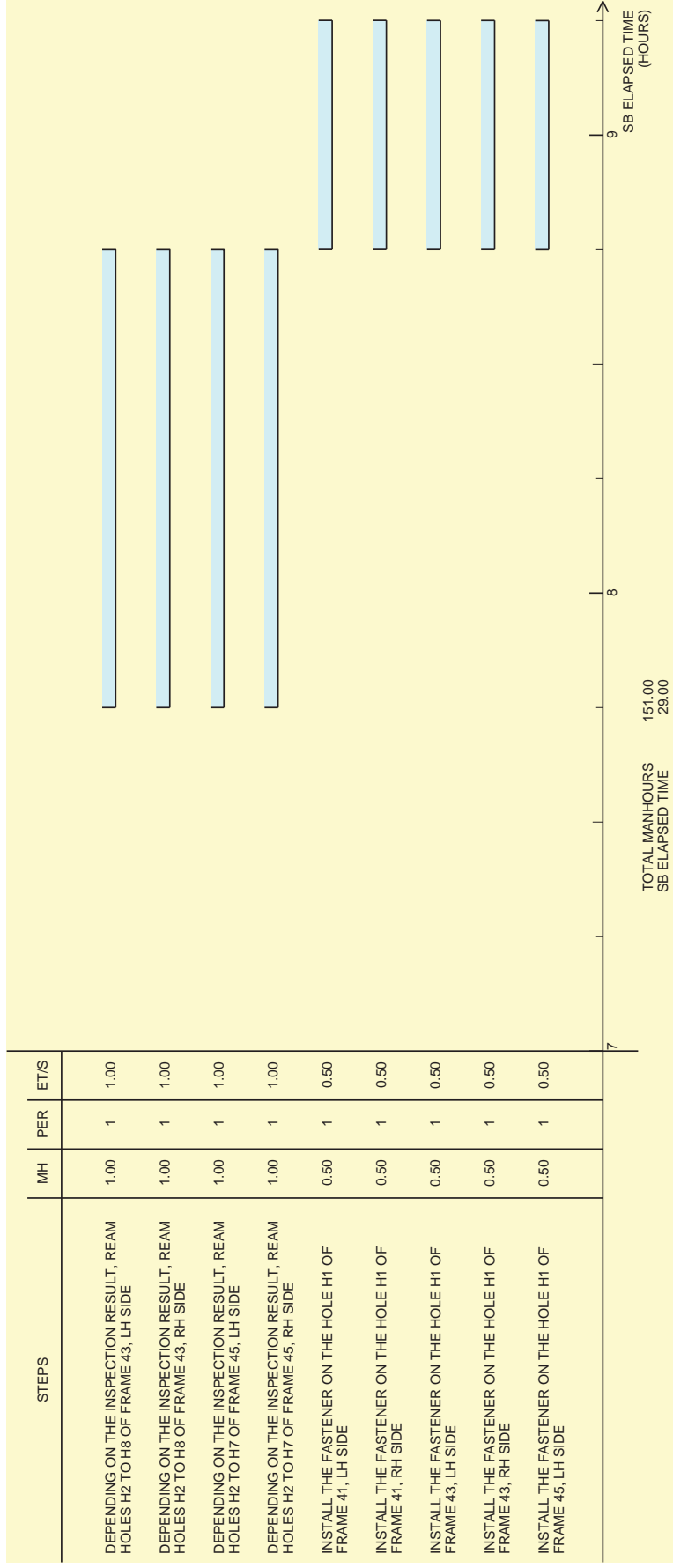


SERVICE BULLETIN
Appendix 01 - Elapsed Time Assumption

**CONF ALL

01 02

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A300-53-6178



NOTE:

GANTT CHART CONTINUES ON SHEET 07.

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

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

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

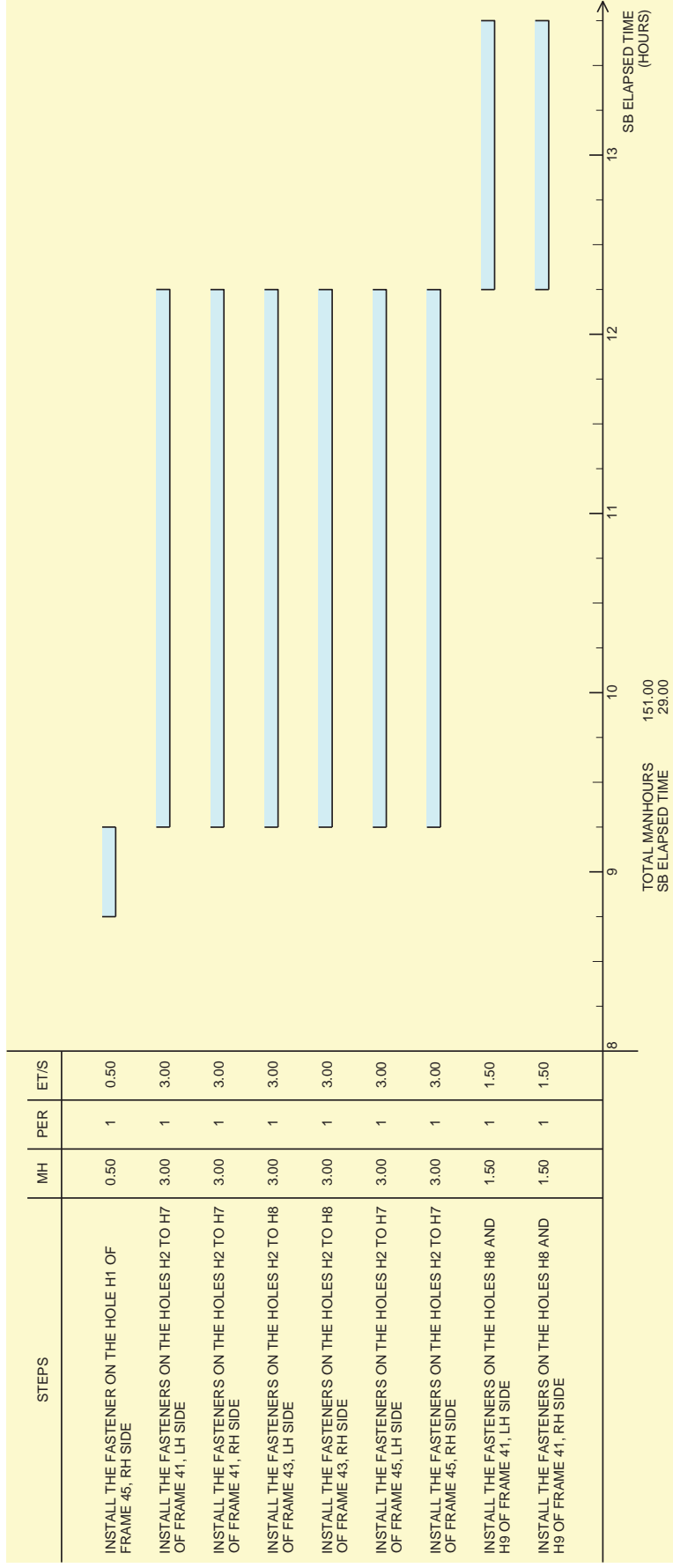
D_SB_536178_5_AAAA_06_00

Figure A-FAAAA - Sheet 06
Gantt Chart

**CONF ALL

01 02

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A300-53-6178



NOTE:

GANTT CHART CONTINUES ON SHEET 08.

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

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

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

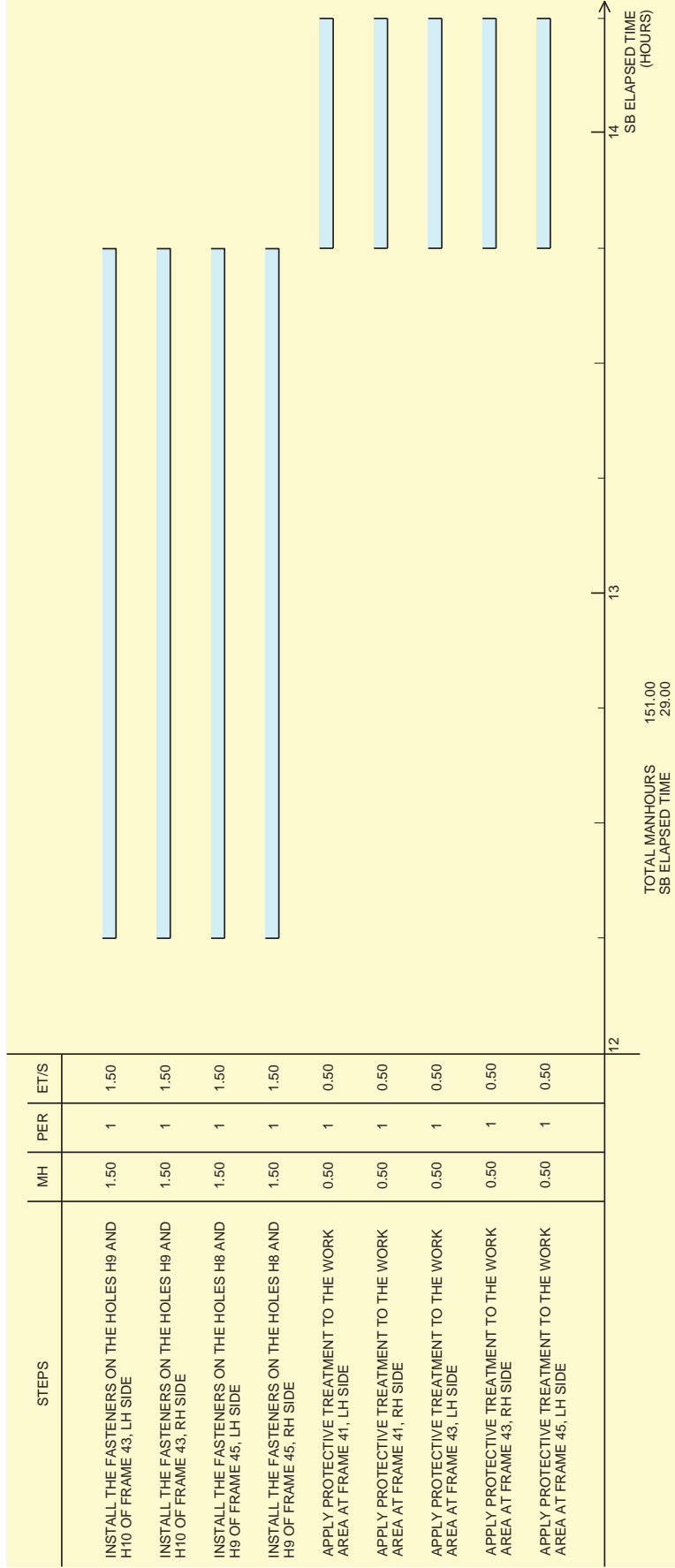
D_SB_536178_5_AAAA_07_00

Figure A-FAAAA - Sheet 07
Gantt Chart

**CONF ALL

01 02

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A300-53-6178



NOTE:

GANTT CHART CONTINUES ON SHEET 09.

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

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

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

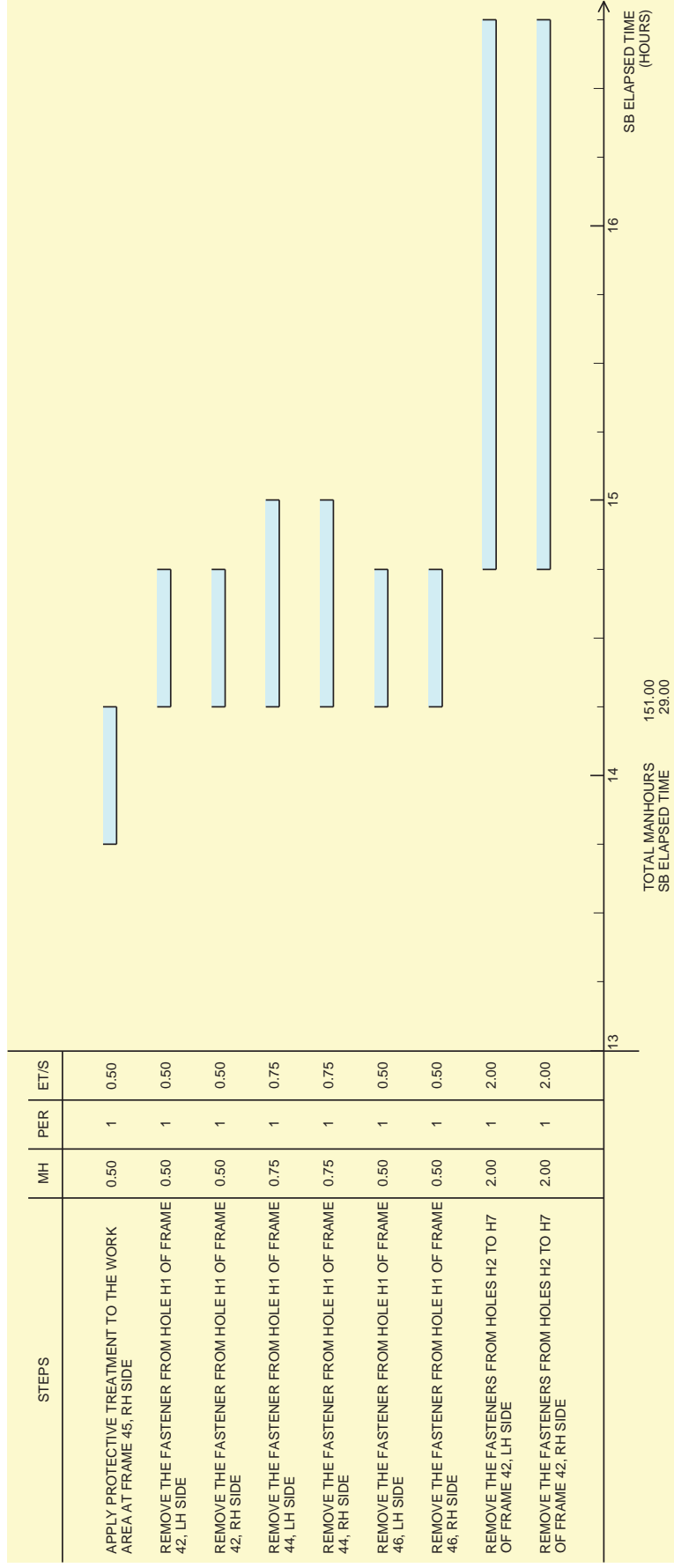
D_SB_536178_5_AAAA_08_00

Figure A-FAAAA - Sheet 08
Gantt Chart

**CONF ALL

01 02

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A300-53-6178



NOTE:

GANTT CHART CONTINUES ON SHEET 10.

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

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

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

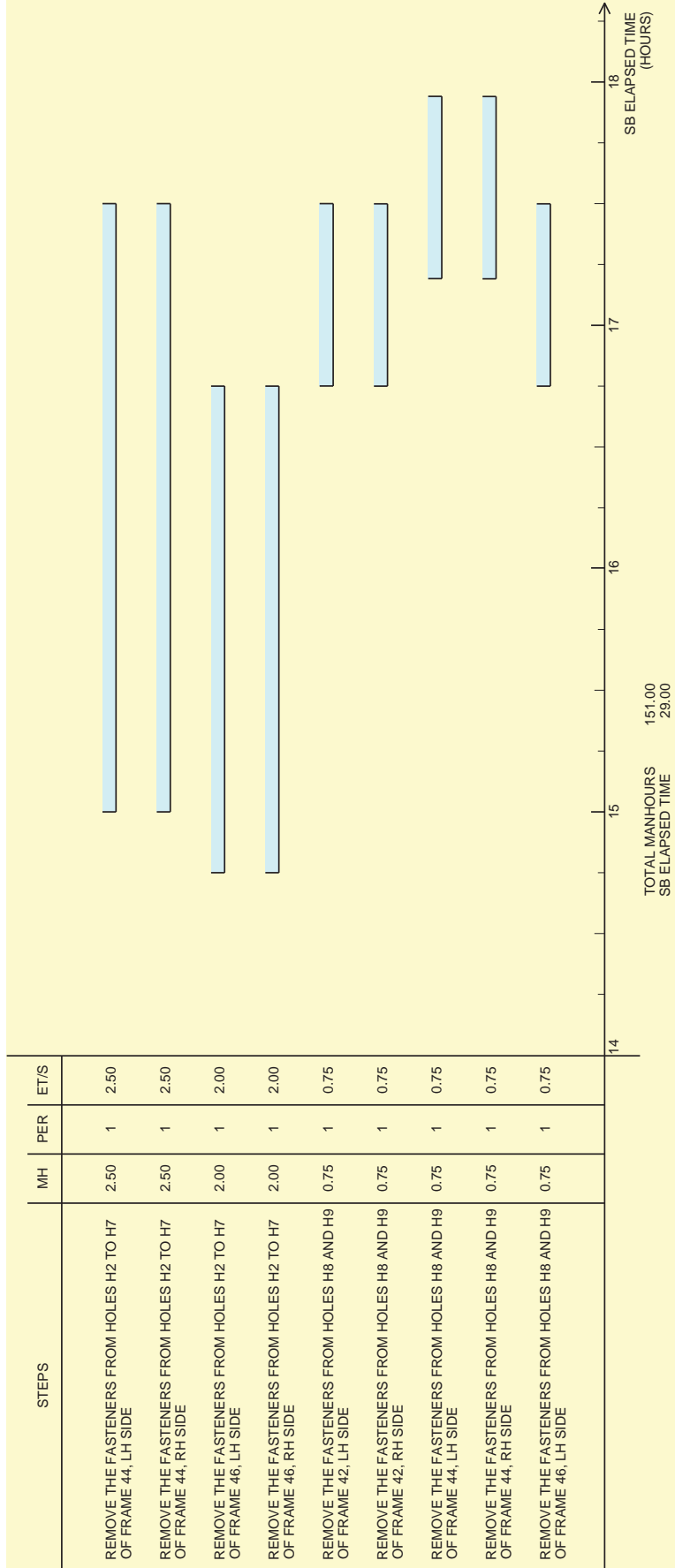
D_SB_536178_5_AAAA_09_00

Figure A-FAAAA - Sheet 09
Gantt Chart

**CONF ALL

01 02

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A300-53-6178



NOTE:
GANTT CHART CONTINUES ON SHEET 11.
01 THIS CHART IS ONLY A PROPOSAL. OPERATORS MAY DETERMINE THAT ANOTHER WAY TO DO THE WORK IS MORE SUITABLE FOR THEM.
02 IF A VSB IS INVOLVED, THE ASSOCIATED MANHOURS ARE NOT REFLECTED IN THIS GANTT CHART.

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

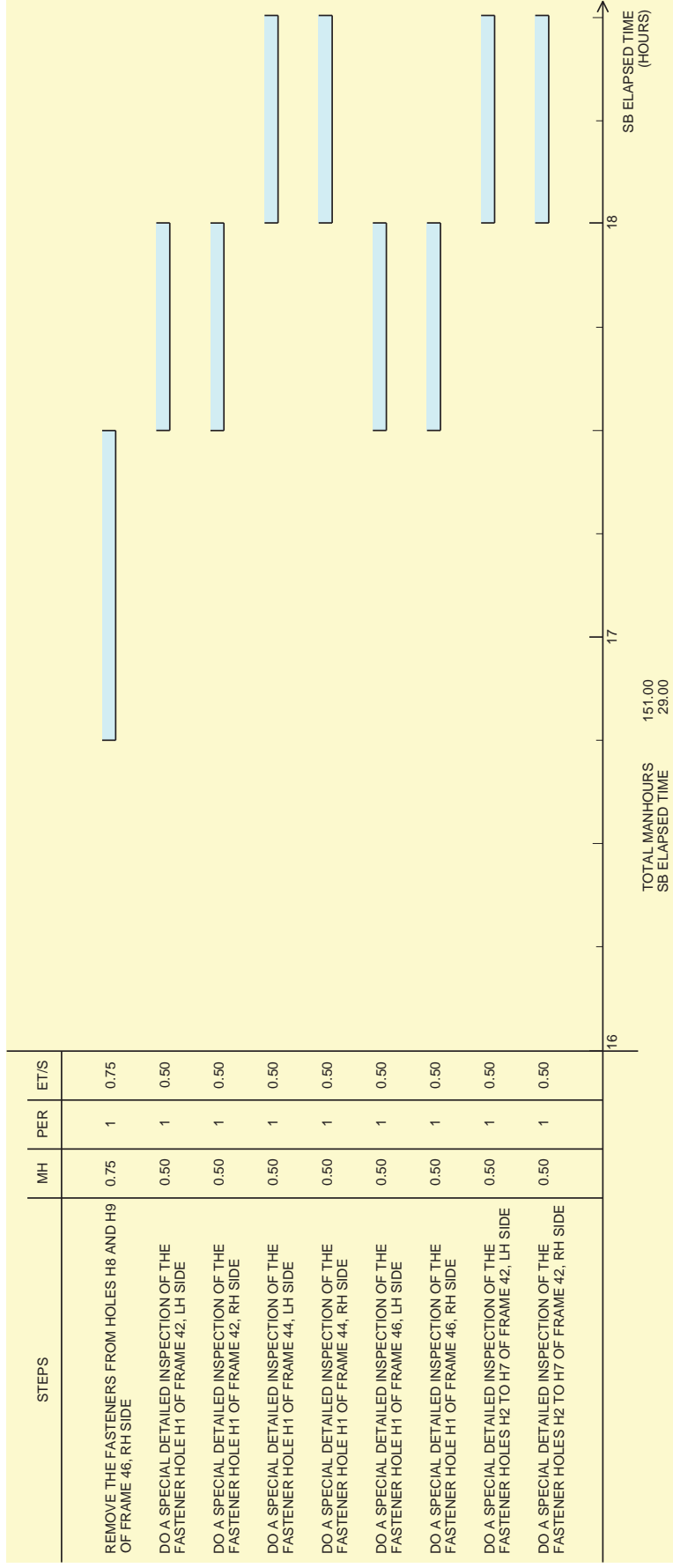
D_SB_536178_5_AAAA_10_00

Figure A-FAAAA - Sheet 10
Gantt Chart

**CONF ALL

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A300-53-6178

01 02



NOTE:
 GANTT CHART CONTINUES ON SHEET 12.
 THIS CHART IS ONLY A PROPOSAL. OPERATORS MAY DETERMINE THAT ANOTHER WAY TO DO THE WORK IS MORE SUITABLE FOR THEM.
 IF A VSB IS INVOLVED, THE ASSOCIATED MANHOURS ARE NOT REFLECTED IN THIS GANTT CHART.

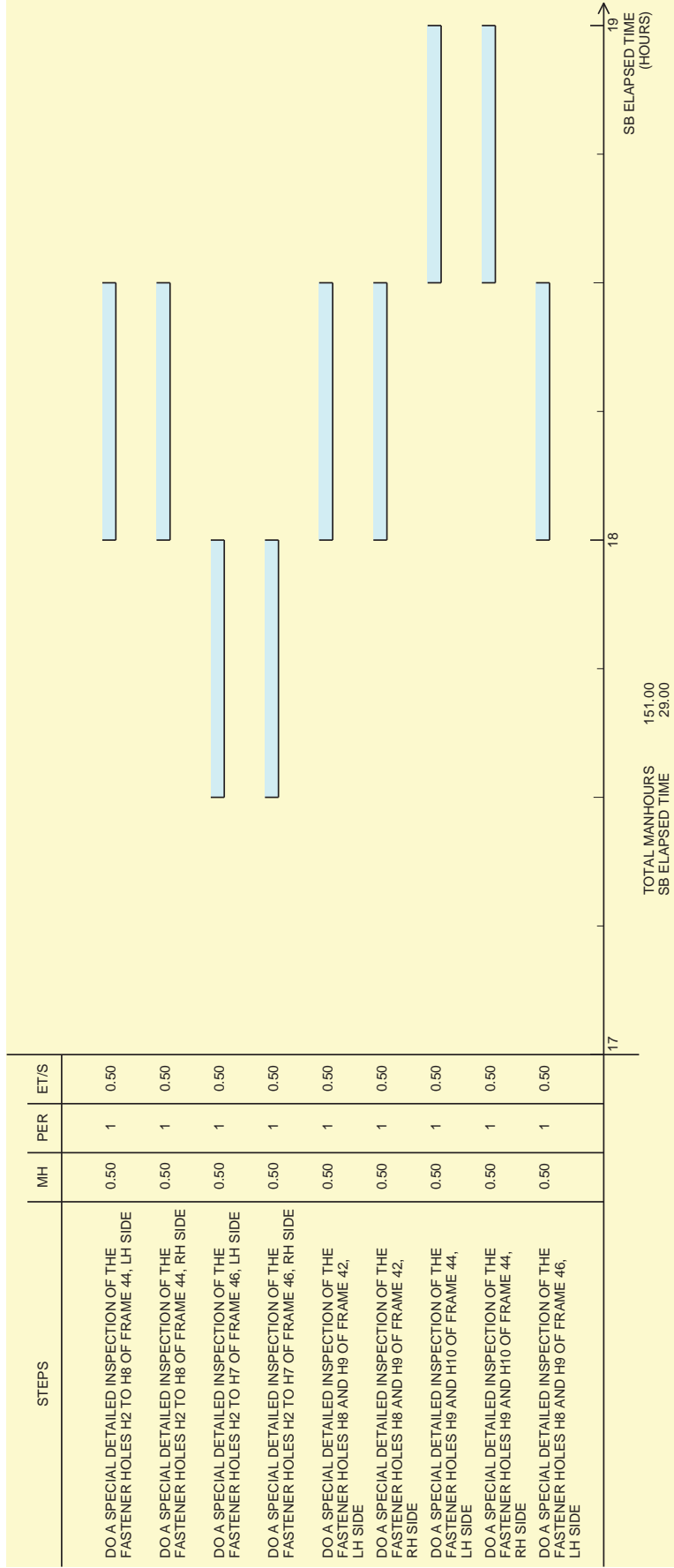
MH : MANHOURS
 PER : NUMBER OF PERSONS
 ET/S : ELAPSED TIME PER STEP

Figure A-FAAAA - Sheet 11
Gantt Chart

**CONF ALL

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A300-53-6178

01 02



NOTE:

GANTT CHART CONTINUES ON SHEET 13.

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

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

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

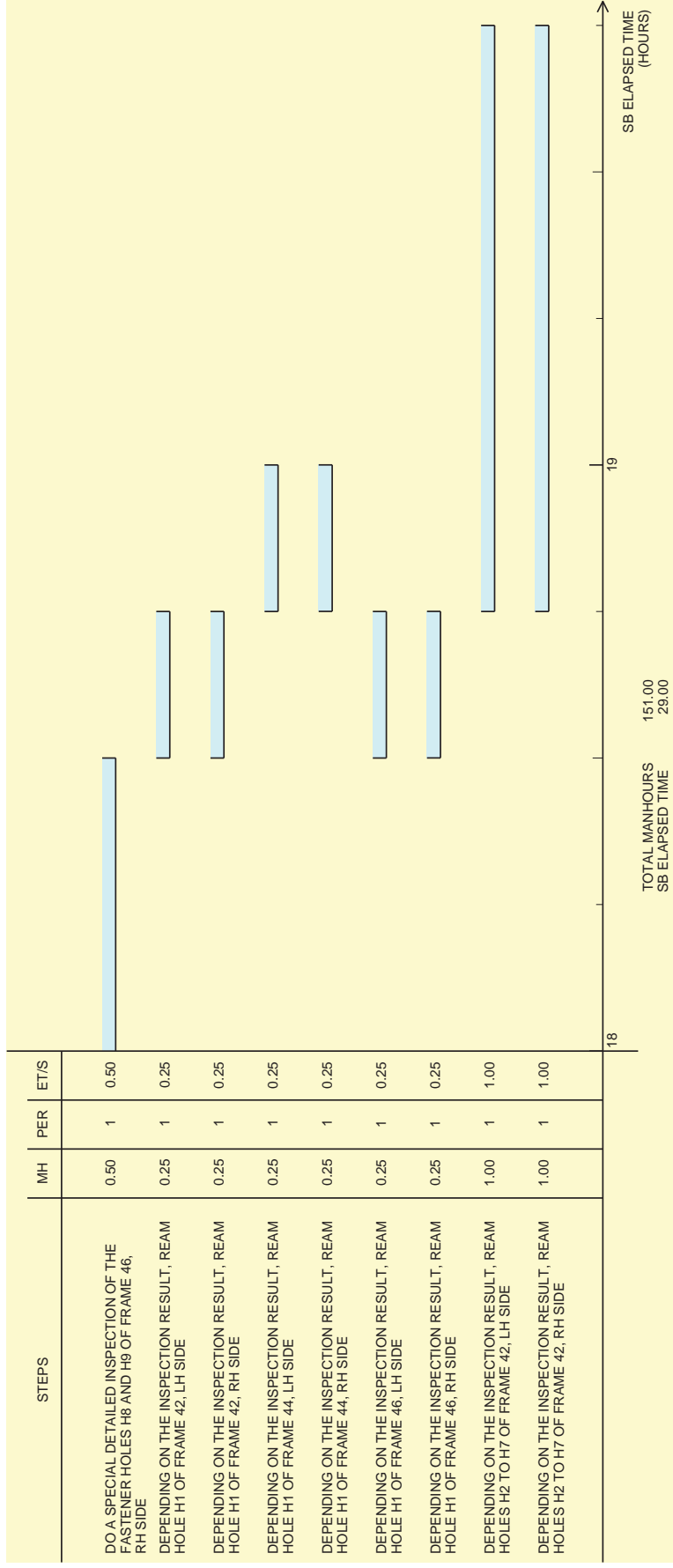
D_SB_536178_5_AAAA_12.00

Figure A-FAAAA - Sheet 12
Gantt Chart

**CONF ALL

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A300-53-6178

01 02



NOTE:

GANTT CHART CONTINUES ON SHEET 14.

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

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

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

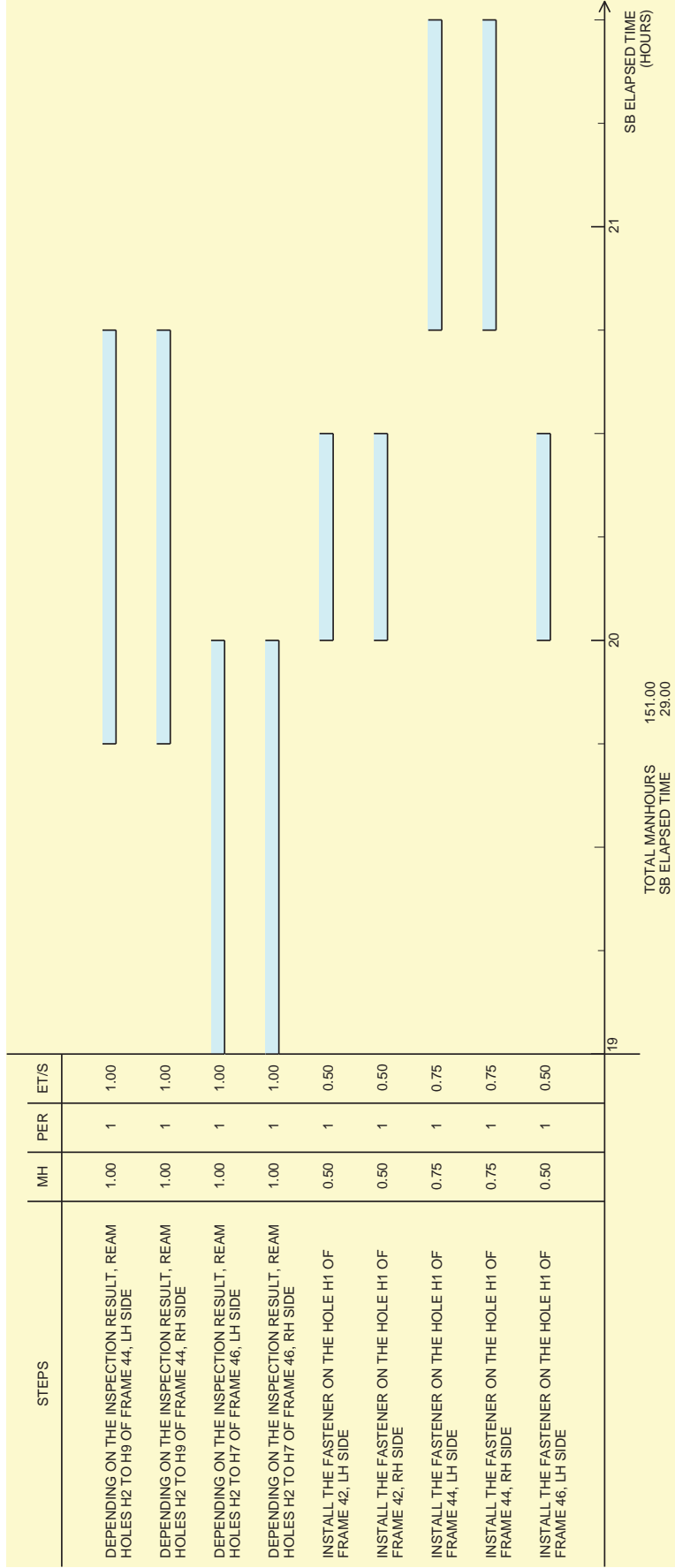
D_SB_536178_5_AAAA_13_00

Figure A-FAAAA - Sheet 13
Gantt Chart

**CONF ALL

01 02

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A300-53-6178



NOTE:

GANTT CHART CONTINUES ON SHEET 15.

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

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

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

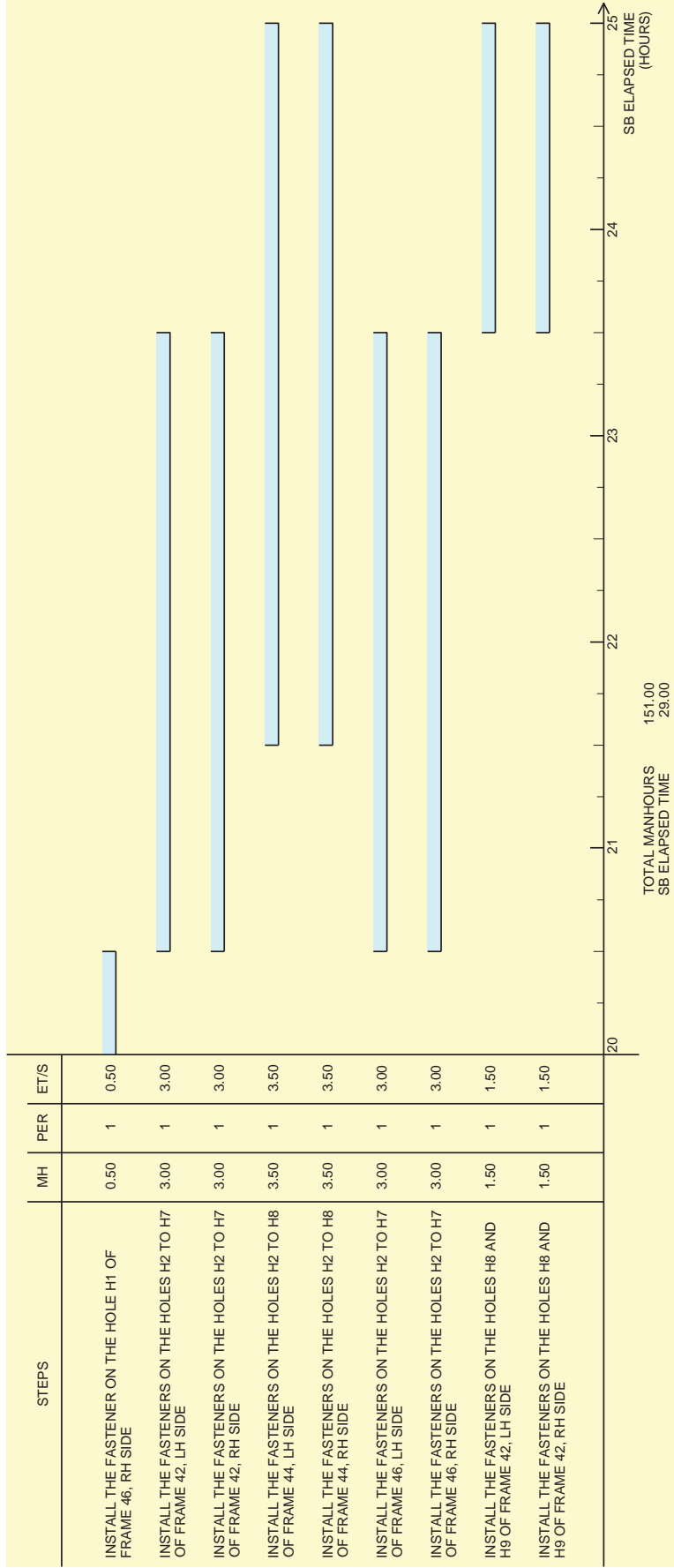
D_SB_536178_5_AAAA_14_00

Figure A-FAAAA - Sheet 14
Gantt Chart

**CONF ALL

01 02

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A300-53-6178



NOTE:

GANTT CHART CONTINUES ON SHEET 16.

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

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

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

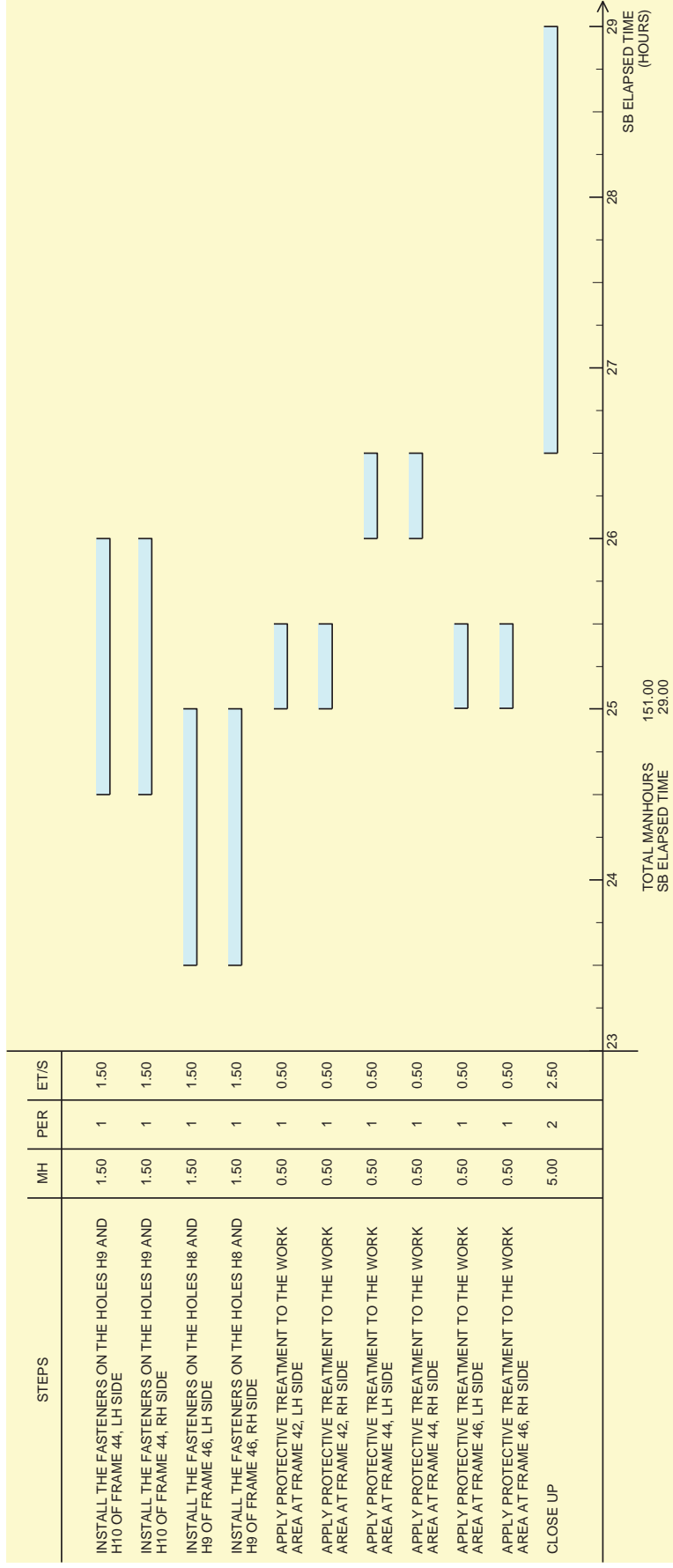
D_SB_536178_5_AAAA_15_00

Figure A-FAAAA - Sheet 15
Gantt Chart

****CONF ALL**

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A300-53-6178

01 02



NOTE:
 01 THIS CHART IS ONLY A PROPOSAL. OPERATORS MAY DETERMINE THAT ANOTHER WAY TO DO THE WORK IS MORE SUITABLE FOR THEM.
 02 IF A VSB IS INVOLVED, THE ASSOCIATED MANHOURS ARE NOT REFLECTED IN THIS GANTT CHART.

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

D_SB_536178_5_AAAA_16_00

Figure A-FAAAA - Sheet 16
Gantt Chart

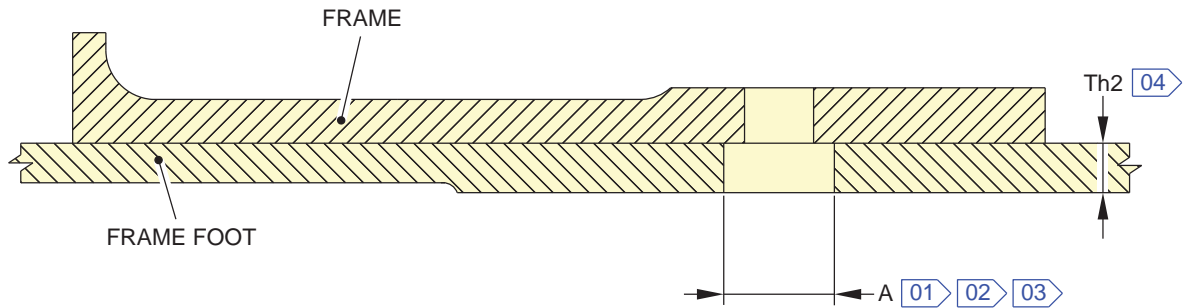
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****CONF ALL**

- (1) In the frame foot layer ONLY, ream the existing hole between 10.9 mm (0.394 in.) and 12 mm (0.472 in) as shown in the [Fig. A-FACAA Sheet 01](#).
- (2) Precisely measure the hole "A" in the frame foot layer (to 0.001 mm (0.000039 in.)) as shown in the [Fig. A-FACAA Sheet 01](#).
- (3) Precisely measure the thickness "Th1" of the frame foot, as shown in [Fig. A-FACAA Sheet 02](#).
- (4) Make a straight bush, as shown in [Fig. A-FACAA Sheet 02](#), with the following characteristics:
 - Outer diameter "B": between "A"+ 0.028 mm (0.0011 in.) and "A"+ 0.039 mm (0.0015 in.)
 - Bush thickness "Ep": measured frame foot thickness "Th1"- 0.1 mm (0.0039 in.)
 - Pilot hole diameter "d": 4.80 mm (0.1889 in.)
 - Material: 7175T73, 7175T7351, 7075T6 or equivalent
 - Bush surface protection: material No. 10ABC1 and material No. 04EAC2.
- (5) Install the bush using liquid nitrogen as shown in [Fig. A-FADAA Sheet 03](#).
- (6) Renew the protective finish in accordance with SRM 51-24-00.

**CONF ALL

PRINCIPLE OF BUSH MACHINING AND INSTALLATION ON FRAME



TYPICAL VIEW

CAUTION:

TO AVOID DAMAGES TO THE FRAME FOOT, REAMING MUST STOP WHEN INTERFAY SEALANT BETWEEN THE FRAME AND THE FRAME FOOT CAN BE SEEN.

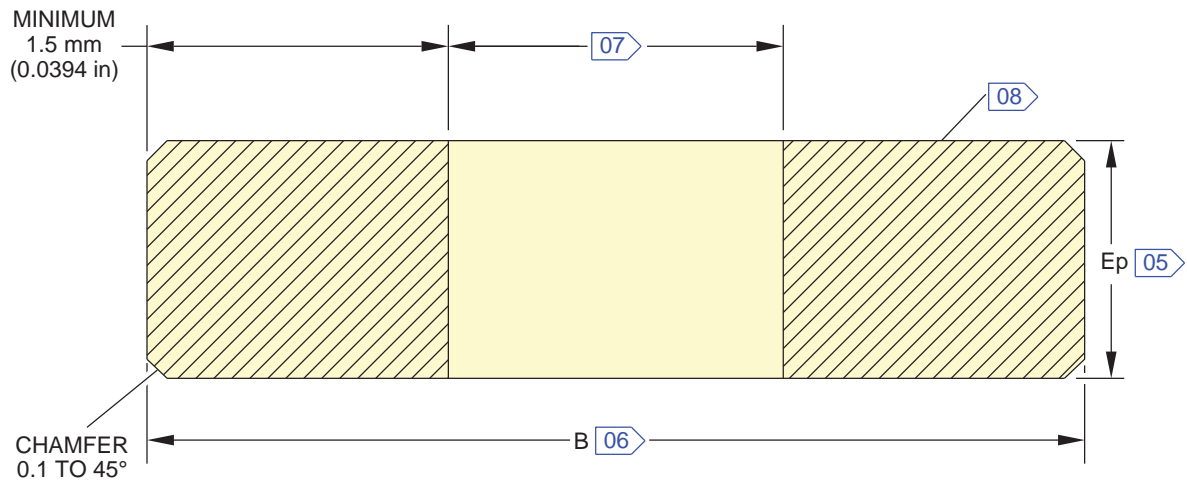
NOTE:

- 01 DRILL THE HOLE BETWEEN 10.90 mm (0.394 in) AND 12 mm (0.472 in) DIAMETER.
- 02 PROTECT THE HOLE WITH MATERIAL No 10ABC1 AND MATERIAL No 04EAC2.
- 03 MEASURE THE DIAMETER OF THE HOLE "A" AFTER THE DRILLING.
- 04 MEASURE THE FRAME FOOT THICKNESS "Th2" ON AIRCRAFT.

D_SB_536178_5_ACAA_01_01

Figure A-FACAA - Sheet 01
Principle of Bush Machining and Installation in the Frame Foot

****CONF ALL**



TYPICAL VIEW

CAUTION:

FOR THE BUSH MACHINING, USE MATERIAL 7175T73 OR 7175T7351 OR 7075T6 OR EQUIVALENT.

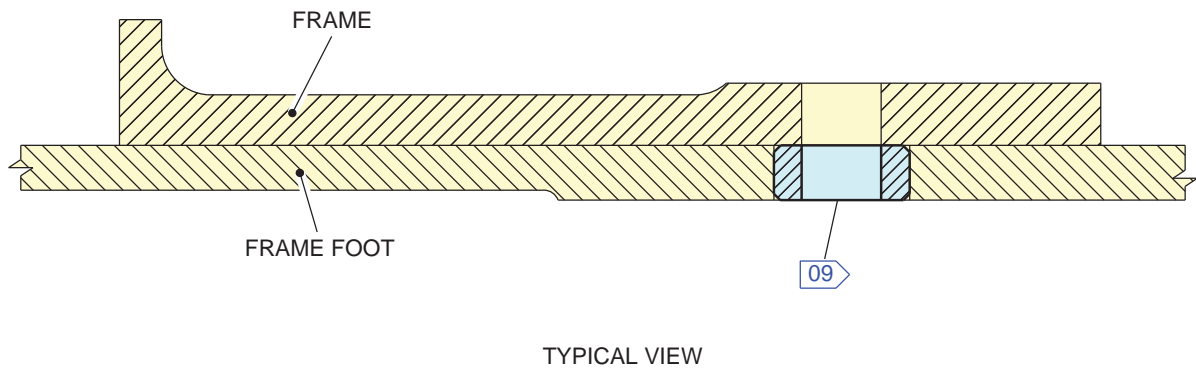
NOTE:

- 05 BUSH THICKNESS "Ep" MUST BE EQUAL TO "Th2" - 0.10 mm (0.0039 in).
- 06 BUSH DIAMETER "B" MUST BE BETWEEN DIAMETER "A" + 0.028 mm (0.0011 in) AND DIAMETER "A" + 0.039 mm (0.0015 in).
- 07 PRIOR INSTALLATION OF THE BUSH ON AIRCRAFT, DRILL A PILOT HOLE OF 4.80 mm (0.1889 in) DIAMETER.
- 08 PROTECT THE BUSH WITH MATERIAL No 10ABC1 AND MATERIAL No 04EAC2.

D_SB_536178_5_ACAA_02_01

Figure A-FACAA - Sheet 02
Principle of Bush Machining and Installation in the Frame Foot

**CONF ALL



NOTE:

09 INSTALL THE BUSH WITH H7S6 INTERFERENCE FIT USING LIQUID NITROGEN.

D_SB_536178_5_ACAA_03_01

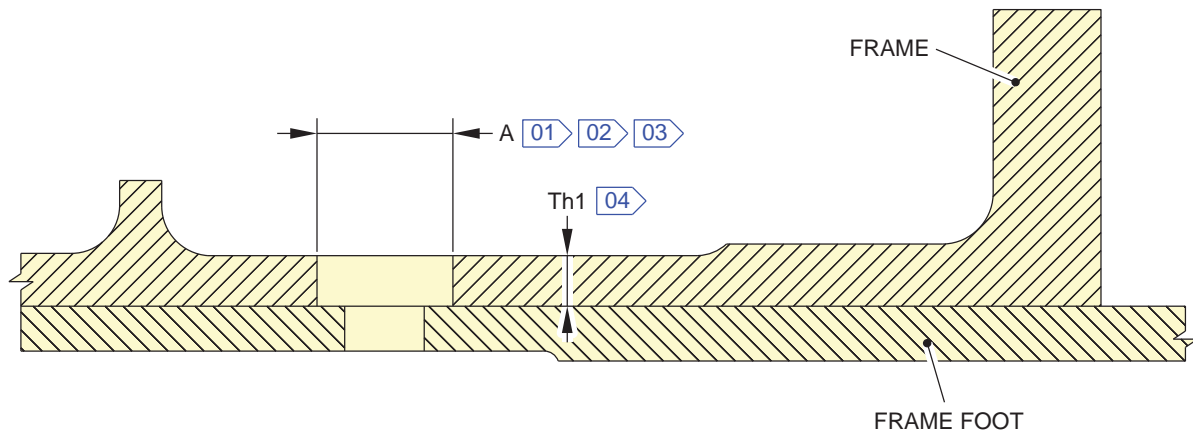
Figure A-FACAA - Sheet 03
Principle of Bush Machining and Installation in the Frame Foot

****CONF ALL**

- (1) In the frame layer ONLY, ream the existing hole between 10.9 mm (0.394 in.) and 12 mm (0.472 in) as shown in the [Fig. A-FADAA Sheet 01](#).
- (2) Precisely measure the hole "A" in the frame layer (to 0.001 mm (0.000039 in.)) as shown in the [Fig. A-FADAA Sheet 01](#).
- (3) Precisely measure the thickness "Th2" of the frame, as shown in [Fig. A-FADAA Sheet 01](#).
- (4) Make a straight bush, as shown in [Fig. A-FADAA Sheet 02](#), with the following characteristics:
 - Outer diameter "B": comprised between "A"+ 0.028 mm (0.0011 in.) and "A"+ 0.039 mm (0.0015 in.)
 - Bush thickness "Ep": measured frame foot thickness "Th2"- 0.1 mm (0.0039 in.)
 - Pilot hole diameter "d": 4.80 mm (0.1889 in.)
 - Material: 7175T73, 7175T7351, 7075T6 or equivalent
 - Bush surface protection: material No. 10ABC1 and material No. 04EAC2.
- (5) Install the bush using liquid nitrogen as shown in [Fig. A-FACAA Sheet 03](#).
- (6) Renew the protective finish in accordance with SRM 51-24-00.

**CONF ALL

PRINCIPLE OF BUSH MACHINING AND INSTALLATION IN FRAME



TYPICAL VIEW

CAUTION:

TO AVOID DAMAGES TO THE FRAME FOOT, REAMING MUST STOP WHEN INTERFAY SEALANT BETWEEN THE FRAME AND THE FRAME FOOT CAN BE SEEN.

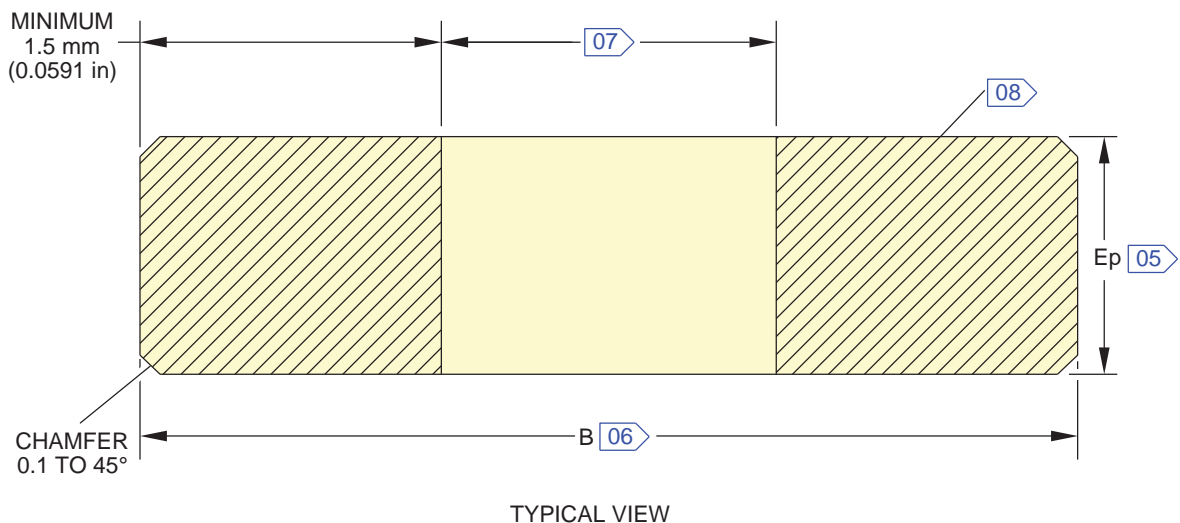
NOTE:

- 01 DRILL THE HOLE BETWEEN 10.90 mm (0.394 in) AND 12 mm (0.472 in) DIAMETER.
- 02 PROTECT THE HOLE WITH MATERIAL No 10ABC1 AND MATERIAL No 04EAC2.
- 03 MEASURE THE DIAMETER OF THE HOLE "A" AFTER THE DRILLING.
- 04 MEASURE THE FRAME THICKNESS "Th1" ON AIRCRAFT.

D_SB_536178_5_ADA01_01

Figure A-FADAA - Sheet 01
Principle of Bush Machining and Installation in the Frame

****CONF ALL**



CAUTION:

FOR THE BUSH MACHINING, USE MATERIAL 7175T73 OR 7175T7351 OR 7075T6 OR EQUIVALENT.

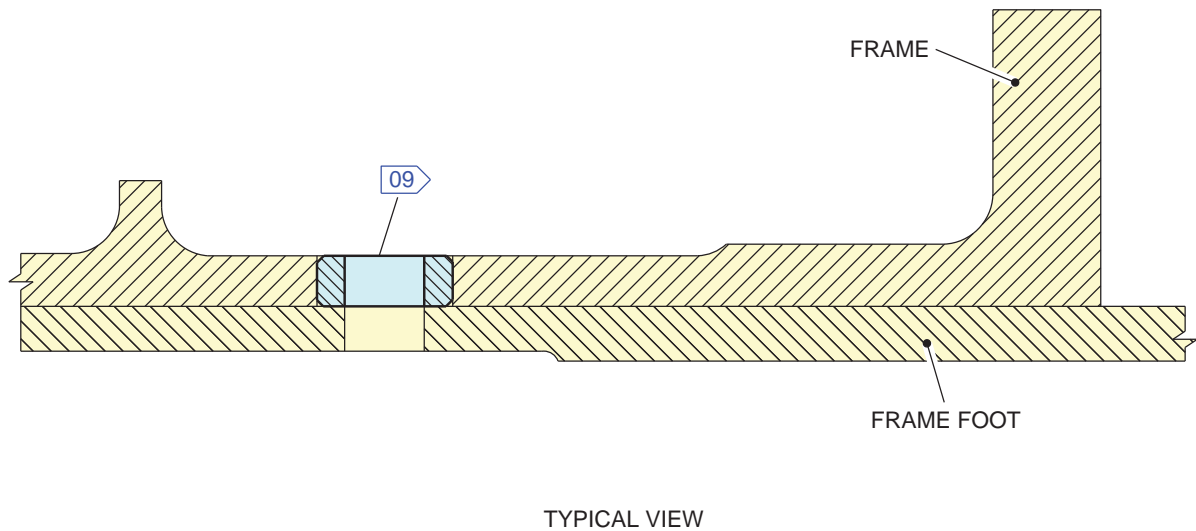
NOTE:

- 05 BUSH THICKNESS "Ep" MUST BE EQUAL TO "Th1" - 0.10 mm (0.0039 in).
- 06 BUSH DIAMETER "B" MUST BE BETWEEN DIAMETER "A" + 0.028 mm (0.0011 in) AND DIAMETER "A" + 0.039 mm (0.0015 in).
- 07 PRIOR INSTALLATION OF THE BUSH ON AIRCRAFT, DRILL A PILOT HOLE OF 4.80 mm (0.1889 in) DIAMETER.
- 08 PROTECT THE BUSH WITH MATERIAL No 10ABC1 AND MATERIAL No 04EAC2.

D_SB_536178_5_ADA_A_02_01

Figure A-FADAA - Sheet 02
Principle of Bush Machining and Installation in the Frame

**CONF ALL



NOTE:

09 INSTALL THE BUSH WITH H7S6 INTERFERENCE FIT USING LIQUID NITROGEN.

D_SB_536178_5_ADAA_03_01

Figure A-FADAA - Sheet 03
Principle of Bush Machining and Installation in the Frame

****CONF ALL**

Tables of the Components

	Frame 41	Frame 42	Frame 43	Frame 44	Frame 45	Frame 46
	LH side	LH side	LH side	LH side	LH side	LH side
Config. 001	Component COMPA01 and Component COMPA13	Component COMPA03 and Component COMPA13	Component COMPA05 and Component COMPA13	Component COMPA07 , Component COMPA13 and Component COMPA15	Component COMPA09 and Component COMPA13	Component COMPA11 and Component COMPA13
Config. 002	Component COMPA02 and Component COMPA13	Component COMPA04 and Component COMPA13	Component COMPA06 and Component COMPA13	Component COMPA08 , Component COMPA13 and Component COMPA15	Component COMPA10 and Component COMPA13	Component COMPA12 and Component COMPA13
Config. 003	Component COMPA01 and Component COMPA13	Component COMPA03 and Component COMPA13	Component COMPA05 and Component COMPA13	Component COMPA07 , Component COMPA13 and Component COMPA15	Component COMPA09 and Component COMPA13	Component COMPA11 and Component COMPA13
Config. 004	Component COMPA02 and Component COMPA13	Component COMPA04 and Component COMPA13	Component COMPA06 and Component COMPA13	Component COMPA08 , Component COMPA13 and Component COMPA15	Component COMPA10 and Component COMPA13	Component COMPA12 and Component COMPA13
Config. 005	Component COMPA02 and Component COMPA14	Component COMPA04 and Component COMPA14	Component COMPA06 and Component COMPA14	Component COMPA16 , Component COMPA15 and Component COMPA13	Component COMPA10 and Component COMPA14	Component COMPA12 and Component COMPA14

	Frame 41	Frame 42	Frame 43	Frame 44	Frame 45	Frame 46
	RH Side	RH Side	RH Side	RH Side	RH Side	RH Side
Config. 001	Component COMPA01 and Component COMPA14	Component COMPA03 and Component COMPA14	Component COMPA05 and Component COMPA14	Component COMPA07 , Component COMPA14 and Component COMPA15	Component COMPA09 and Component COMPA14	Component COMPA11 and Component COMPA14

SERVICE BULLETIN
Appendix 04 - Table of the Components and Configurations

	Frame 41	Frame 42	Frame 43	Frame 44	Frame 45	Frame 46
	RH Side	RH Side	RH Side	RH Side	RH Side	RH Side
Config. 002	Component COMPA02 and Component COMPA14	Component COMPA04 and Component COMPA14	Component COMPA06 and Component COMPA14	Component COMPA08 , Component COMPA14and Component COMPA15	Component COMPA10 and Component COMPA14	Component COMPA12 and Component COMPA14
Config. 003	Component COMPA01 and Component COMPA14	Component COMPA03 and Component COMPA14	Component COMPA05 and Component COMPA14	Component COMPA07 , Component COMPA14and Component COMPA15	Component COMPA09 and Component COMPA14	Component COMPA11 and Component COMPA14
Config. 004	Component COMPA02 and Component COMPA14	Component COMPA04 and Component COMPA14	Component COMPA06 and Component COMPA14	Component COMPA08 , Component COMPA14and Component COMPA15	Component COMPA10 and Component COMPA14	Component COMPA12 and Component COMPA14
Config. 005	Component COMPA02 and Component COMPA13	Component COMPA04 and Component COMPA13	Component COMPA06 and Component COMPA13	Component COMPA16 , Component COMPA13 and Component COMPA14	Component COMPA10 and Component COMPA13	Component COMPA12 and Component COMPA13

**TITLE: FUSELAGE - CENTER SECTION - OVERSIZE UPPER FRAME FEET
SPLICING FROM FR41 TO FR46**

MODIFICATION No.: 13743S22884

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.

SERVICE BULLETIN QUALITY PERCEPTION FORM

Use this form to tell us what is your perception of the quality of this Service Bulletin. The reported data that you provide us will be used to analyse areas of difficulties and to take corrective action to further improve the quality of our Service Bulletins.

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

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

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

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

Planning	Material	Instructions
<input checked="" type="checkbox"/> Effectivity	<input checked="" type="checkbox"/> Kit content	<input checked="" type="checkbox"/> Preparation
<input checked="" type="checkbox"/> Reason	<input checked="" type="checkbox"/> List of Materials Operator Supplied	<input checked="" type="checkbox"/> Mod/Inspection
<input checked="" type="checkbox"/> Manpower	<input checked="" type="checkbox"/> Industry support	<input checked="" type="checkbox"/> Test
<input checked="" type="checkbox"/> References	<input checked="" type="checkbox"/> Re-identification	<input checked="" type="checkbox"/> Close-Up
<input checked="" type="checkbox"/> Publication	<input checked="" type="checkbox"/> Tooling	<input checked="" type="checkbox"/> Illustrations

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