SERVICE BULLETIN
REVISION TRANSMITTAL SHEET

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

# MANDATORY MANDATORY MANDATORY

ATA SYSTEM: 57

## TITLE: WINGS - GENERAL - INTRODUCE UPPER CLEAT TO STRINGER ATTACHMENTS AT RIBS 2 - 7. MODIFICATION BY SB DUE TO WFD

MODIFICATION No.: 159478J4359 162156J4442

This page transmits Revision No.01 of Service Bulletin No.A320-57-1208

**ADDITIONAL WORK**

****CONF ALL**

NOTE: If you have previously accomplished this Service Bulletin at Revision 00, you must contact AIRBUS for further advice before you continue.

**REASON**

Revision 01 issued to:

- Add Modification No. 162156J4442 which replaces fastener type NAS5271 with a corrosion resistance conforming alternative fastener type NAS1751
- Add configuration Nos. 010 thru 017 for aircraft with Modification No. 155374K17141 embodied
- Update the Service Bulletin effectivity.

**CHANGES**

The main changes of this revision are:

- Effectivity updated
- Effectivity by operator updated
- Modification No. 162156J4442 added
- Configuration Nos. 010 thru 017 added
- Kits B01 and B29 revised to replace Bolt, Part Number (PN) NAS5271-4L5 with Bolt PN NAS1751-4L5
- Kits B03, B06, B08 and B17 revised to replace Bolt PN NAS5271-4L6 with Bolt PN NAS1751-4L6



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

- Kits B12 and B21 revised to add Nut PN ASNA2531-5
- Kits B12 and B16 revised to add Sealant Foam PNs D5725655721000, D5725655721200 and D5725655721400
- Kits B21 and B25 revised to add Sealant Foam PN D5725655720000
- Cleat refit and sealant procedure added for Rib 5 STGRs 4 and 5 and Rib 6 STGR 5 in configuration Nos. 005, 009, 011 and 015
- On bench procedure to increase the size the holes of the metallic packers for Rib 5 STGRs 4 and 5 and Rib 6 STGR 5 in configuration Nos. 005, 009, 011 and 015 added
- All figures revised
- Figures A-USBAA, A-USBAB, A-USBAC, A-USBAD, A-USBAF, A-UBHAA, A-UBHAB and A-UAAAC created
- WEIGHT AND BALANCE paragraph updated
- Reason paragraph updated.

| | | |
|---|---|---|
| **FRONT MATTER** | | |
| WINGS - GENERAL - INTRODUCE UPPER CLEAT TO STRINGER ATTACHMENTS AT RIBS 2 - 7. MODIFICATION BY SB DUE TO WFD | CONFIGURATION UPDATED | R |
| MODIFICATIONS | MODIFICATION NUMBER(S) UPDATED | R |
| **SUMMARY** | | |
| **MODIFICATIONS** | MODIFICATION CLASSIFICATION UPDATED | R |
| **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 |
| | MATERIAL PRICE INFORMATION TABLE UPDATED | R |
| | MATERIAL PRICE INFORMATION TABLE UPDATED | R |
| | MATERIAL PRICE INFORMATION TABLE UPDATED | R |



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

| | | |
|---|---|---|
| | MATERIAL PRICE INFORMATION TABLE UPDATED | R |
| | MATERIAL PRICE INFORMATION TABLE ADDED | N |
| | MATERIAL PRICE INFORMATION TABLE ADDED | N |
| | MATERIAL PRICE INFORMATION TABLE ADDED | N |
| | MATERIAL PRICE INFORMATION TABLE ADDED | N |
| | MATERIAL PRICE INFORMATION TABLE ADDED | N |
| | MATERIAL PRICE INFORMATION TABLE ADDED | N |
| | MATERIAL PRICE INFORMATION TABLE ADDED | N |
| | MATERIAL PRICE INFORMATION TABLE ADDED | N |
| **EFFECTIVITY** | OPERATOR LIST UPDATED | R |
| **MANPOWER** | MANPOWER UPDATED | R |
| | MANPOWER UPDATED | R |
| | MANPOWER ADDED | N |
| | MANPOWER ADDED | N |
| | MANPOWER ADDED | N |
| | MANPOWER ADDED | N |
| | MANPOWER ADDED | N |
| | MANPOWER ADDED | N |
| | MANPOWER ADDED | N |
| | MANPOWER ADDED | N |
| Fig. A-USAAA | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-USAAA Sheet 01 | SHEET UPDATED | R |
| Fig. A-USAAA Sheet 02 | SHEET DELETED | D |
| Fig. A-USAAB | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-USAAB Sheet 01 | SHEET UPDATED | R |
| Fig. A-USAAB Sheet 02 | SHEET DELETED | D |
| Fig. A-USAAC | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-USAAC Sheet 01 | SHEET UPDATED | R |
| Fig. A-USAAC Sheet 02 | SHEET DELETED | D |
| Fig. A-USAAD | FIGURE SOLUTION ADDED | N |
| Fig. A-USAAD Sheet 01 | SHEET ADDED | N |
| Fig. A-USAAF | FIGURE SOLUTION ADDED | N |
| Fig. A-USAAF Sheet 01 | SHEET ADDED | N |
| Fig. A-USBAA | FIGURE SOLUTION ADDED | N |
| Fig. A-USBAA Sheet 01 | SHEET ADDED | N |
| Fig. A-USBAB | FIGURE SOLUTION ADDED | N |
| Fig. A-USBAB Sheet 01 | SHEET ADDED | N |
| Fig. A-USBAC | FIGURE SOLUTION ADDED | N |
| Fig. A-USBAC Sheet 01 | SHEET ADDED | N |
| Fig. A-USBAD | FIGURE SOLUTION ADDED | N |



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

| | | |
|---|---|---|
| Fig. A-USBAD Sheet 01 | SHEET ADDED | N |
| Fig. A-USBAF | FIGURE SOLUTION ADDED | N |
| Fig. A-USBAF Sheet 01 | SHEET ADDED | N |
| Fig. A-USCAA | FIGURE SOLUTION ADDED | N |
| Fig. A-USCAA Sheet 01 | SHEET ADDED | N |
| **PLANNING INFORMATION** | | |
| **EFFECTIVITY** | EFFECTIVITY RELATED INFORMATION UPDATED | R |
| Configuration definition | CONFIGURATION LIST UPDATED | R |
| CONF 001 | CONFIGURATION DEFINITION UPDATED<br>CONFIGURATION DESCRIPTION UPDATED | R |
| CONF 002 | CONFIGURATION DEFINITION UPDATED<br>CONFIGURATION DESCRIPTION UPDATED | R |
| CONF 003 | CONFIGURATION DEFINITION UPDATED<br>CONFIGURATION DESCRIPTION UPDATED | R |
| CONF 004 | CONFIGURATION DEFINITION UPDATED<br>CONFIGURATION DESCRIPTION UPDATED | R |
| CONF 005 | CONFIGURATION DEFINITION UPDATED<br>CONFIGURATION DESCRIPTION UPDATED | R |
| CONF 006 | CONFIGURATION DEFINITION UPDATED<br>CONFIGURATION DESCRIPTION UPDATED | R |
| CONF 007 | CONFIGURATION DEFINITION UPDATED<br>CONFIGURATION DESCRIPTION UPDATED | R |
| CONF 008 | CONFIGURATION DEFINITION UPDATED<br>CONFIGURATION DESCRIPTION UPDATED | R |
| CONF 009 | CONFIGURATION DEFINITION UPDATED<br>CONFIGURATION DESCRIPTION UPDATED | R |
| CONF 010 | CONFIGURATION ADDED | N |
| CONF 011 | CONFIGURATION ADDED | N |
| CONF 012 | CONFIGURATION ADDED | N |
| CONF 013 | CONFIGURATION ADDED | N |
| CONF 014 | CONFIGURATION ADDED | N |
| CONF 015 | CONFIGURATION ADDED | N |
| CONF 016 | CONFIGURATION ADDED | N |
| CONF 017 | CONFIGURATION ADDED | N |
| Material Effectivity | MATERIAL EFFECTIVITY UPDATED<br>MATERIAL SET UPDATED | R |
| | MATERIAL EFFECTIVITY UPDATED<br>CONFIGURATION UPDATED | R |
| | MATERIAL EFFECTIVITY UPDATED<br>CONFIGURATION UPDATED | R |
| | MATERIAL EFFECTIVITY UPDATED<br>CONFIGURATION UPDATED | R |
| | MATERIAL EFFECTIVITY UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL SET UPDATED | R |



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

| | | |
|---|---|---|
| | MATERIAL EFFECTIVITY UPDATED<br>CONFIGURATION UPDATED | R |
| | MATERIAL EFFECTIVITY UPDATED<br>CONFIGURATION UPDATED | R |
| | MATERIAL EFFECTIVITY UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL SET UPDATED | R |
| | MATERIAL EFFECTIVITY UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL SET UPDATED | R |
| **REASON** | | |
| Objective/Action | OBJECTIVE/ACTION UPDATED | R |
| **DESCRIPTION** | DESCRIPTION UPDATED | R |
| **COMPLIANCE** | | |
| Accomplishment Timescale | ACCOMPLISHMENT TIMESCALE UPDATED | R |
| Accomplishment Timescale | ACCOMPLISHMENT TIMESCALE UPDATED | R |
| Accomplishment Timescale | ACCOMPLISHMENT TIMESCALE ADDED | N |
| Accomplishment Timescale | ACCOMPLISHMENT TIMESCALE ADDED | N |
| **MANPOWER** | MANPOWER UPDATED | R |
| | MANPOWER UPDATED | R |
| | MANPOWER UPDATED | R |
| | MANPOWER UPDATED | R |
| | MANPOWER UPDATED | R |
| | MANPOWER UPDATED | R |
| | MANPOWER UPDATED | R |
| | MANPOWER UPDATED | R |
| | MANPOWER UPDATED | R |
| | MANPOWER ADDED | N |
| | MANPOWER ADDED | N |
| | MANPOWER ADDED | N |
| | MANPOWER ADDED | N |
| | MANPOWER ADDED | N |
| | MANPOWER ADDED | N |
| | MANPOWER ADDED | N |
| | MANPOWER ADDED | N |
| **WEIGHT AND BALANCE** | WEIGHT AND BALANCE UPDATED | R |
| | WEIGHT AND BALANCE ADDED | N |
| | WEIGHT AND BALANCE ADDED | N |
| | WEIGHT AND BALANCE ADDED | N |
| **REFERENCES** | REFERENCED DOCUMENTATION UPDATED | R |
| | REFERENCED DOCUMENTATION UPDATED | R |
| | REFERENCED DOCUMENTATION UPDATED | R |
| | REFERENCED DOCUMENTATION UPDATED | R |
| | REFERENCED DOCUMENTATION UPDATED | R |
| | REFERENCED DOCUMENTATION UPDATED | R |
| | REFERENCED DOCUMENTATION UPDATED | R |



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

| | | |
|---|---|---|
| | REFERENCED DOCUMENTATION UPDATED | R |
| | REFERENCED DOCUMENTATION UPDATED | R |
| | REFERENCED DOCUMENTATION ADDED | N |
| | REFERENCED DOCUMENTATION ADDED | N |
| | REFERENCED DOCUMENTATION ADDED | N |
| | REFERENCED DOCUMENTATION ADDED | N |
| | REFERENCED DOCUMENTATION ADDED | N |
| | REFERENCED DOCUMENTATION ADDED | N |
| | REFERENCED DOCUMENTATION ADDED | N |
| | REFERENCED DOCUMENTATION ADDED | N |
| **MATERIAL INFORMATION** | | |
| **MATERIAL - PRICE AND AVAILABILITY** | | |
| Procurement Addresses | PROCUREMENT ADDRESSES UPDATED<br>MATERIAL SET UPDATED | R |
| Price and Availability | PRICE AND AVAILABILITY UPDATED<br>MATERIAL AVAILABILITY UPDATED<br>MATERIAL SET UPDATED<br>MATERIAL PRICE UPDATED | R |
| **LIST OF COMPONENTS** | | |
| Kit 571208B01R03 | PART MATERIAL SET UPDATED<br>MATERIAL SET LABEL UPDATED<br>PART NUMBER UPDATED | R |
| Kit 571208B03R02 | PART MATERIAL SET UPDATED<br>MATERIAL SET LABEL UPDATED<br>PART NUMBER UPDATED | R |
| Kit 571208B06R02 | PART MATERIAL SET UPDATED<br>MATERIAL SET LABEL UPDATED<br>PART NUMBER UPDATED | R |
| Kit 571208B07R01 | PART MATERIAL SET UPDATED | R |
| Kit 571208B08R02 | PART MATERIAL SET UPDATED<br>MATERIAL SET LABEL UPDATED<br>PART NUMBER UPDATED | R |
| Kit 571208B12R04 | PART MATERIAL SET UPDATED<br>MATERIAL SET LABEL UPDATED<br>KEYWORD UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED | R |
| Kit 571208B16R04 | PART MATERIAL SET UPDATED<br>MATERIAL SET LABEL UPDATED<br>KEYWORD UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED | R |
| Kit 571208B17R03 | PART MATERIAL SET UPDATED<br>MATERIAL SET LABEL UPDATED<br>PART NUMBER UPDATED | R |



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

| | | |
|---|---|---|
| Kit 571208B21R03 | PART MATERIAL SET UPDATED<br>MATERIAL SET LABEL UPDATED<br>KEYWORD UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED | R |
| Kit 571208B25R03 | PART MATERIAL SET UPDATED<br>MATERIAL SET LABEL UPDATED<br>KEYWORD UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED | R |
| Kit 571208B28R02 | PART MATERIAL SET UPDATED<br>MATERIAL SET LABEL UPDATED<br>QUANTITY UPDATED | R |
| Kit 571208B29R02 | PART MATERIAL SET UPDATED<br>MATERIAL SET LABEL UPDATED<br>PART NUMBER UPDATED | R |
| **LIST OF MATERIALS - OPERATOR SUPPLIED** | | |
| Consumable Materials | | |
| Consumable CMLB01 | CONSUMABLE MATERIAL SET UPDATED<br>CONSUMABLE UPDATED<br>QUANTITY UPDATED | R |
| **ACCOMPLISHMENT INSTRUCTIONS** | | |
| TASK 571208- 831-895-001-Modification | TASK SOLUTION UPDATED<br>NOTE UPDATED<br>CAUTION UPDATED | R |
| Task associated data - 005 | MAN HOURS UPDATED<br>ELAPSED TIME UPDATED | R |
| Task associated data - 009 | MAN HOURS UPDATED<br>ELAPSED TIME UPDATED | R |
| Task associated data - 010 | TASK ASSOCIATED DATA ADDED | N |
| Task associated data - 011 | TASK ASSOCIATED DATA ADDED | N |
| Task associated data - 012 | TASK ASSOCIATED DATA ADDED | N |
| Task associated data - 013 | TASK ASSOCIATED DATA ADDED | N |
| Task associated data - 014 | TASK ASSOCIATED DATA ADDED | N |
| Task associated data - 015 | TASK ASSOCIATED DATA ADDED | N |
| Task associated data - 016 | TASK ASSOCIATED DATA ADDED | N |
| Task associated data - 017 | TASK ASSOCIATED DATA ADDED | N |
| Subtask 571208-910-401-001 | SUBTASK SOLUTION UPDATED | R |
| Subtask 571208-910-401-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-910-401-001 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-910-401-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-910-401-001 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-910-401-002 | SUBTASK SOLUTION ADDED | N |



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

| | | |
|---|---|---|
| Subtask 571208-910-401-001 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-910-401-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-910-401-001 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-910-401-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-910-401-001 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-910-401-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-910-401-001 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-910-401-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-910-401-001 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-910-401-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-910-401-001 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-910-401-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-839-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-910-401-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-839-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-910-401-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-839-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-910-401-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-839-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-910-401-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-839-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-910-401-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-839-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-910-401-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-839-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-910-401-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-839-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-941-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-941-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-941-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-941-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-941-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-941-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-941-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-941-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-401-002 | SUBTASK SOLUTION UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-401-002 | SUBTASK SOLUTION UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-831-401-002 | SUBTASK SOLUTION UPDATED<br>PART NUMBER UPDATED<br>MATERIAL LIST UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-000-401-002 | SUBTASK SOLUTION UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-403-002 | SUBTASK SOLUTION UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-831-402-002 | SUBTASK SOLUTION UPDATED<br>PART NUMBER UPDATED<br>MATERIAL LIST UPDATED | R |
| Subtask 571208-020-402-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-404-002 | SUBTASK SOLUTION UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-831-403-002 | SUBTASK SOLUTION UPDATED<br>PART NUMBER UPDATED<br>MATERIAL LIST UPDATED | R |
| Subtask 571208-020-403-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-405-002 | SUBTASK SOLUTION UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-831-404-002 | SUBTASK SOLUTION UPDATED<br>PART NUMBER UPDATED<br>MATERIAL LIST UPDATED | R |
| Subtask 571208-020-404-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-410-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-406-002 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-831-405-002 | SUBTASK SOLUTION UPDATED<br>PART NUMBER UPDATED<br>MATERIAL LIST UPDATED | R |
| Subtask 571208-020-405-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-407-002 | SUBTASK SOLUTION UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-831-406-002 | SUBTASK SOLUTION UPDATED<br>PART NUMBER UPDATED<br>MATERIAL LIST UPDATED | R |
| Subtask 571208-020-406-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-408-001 | SUBTASK SOLUTION UPDATED<br>CAUTION UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-831-407-001 | SUBTASK SOLUTION UPDATED<br>PART NUMBER UPDATED<br>MATERIAL LIST UPDATED | R |
| Subtask 571208-020-407-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-409-001 | SUBTASK SOLUTION UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-831-408-001 | SUBTASK SOLUTION UPDATED<br>PART NUMBER UPDATED<br>MATERIAL LIST UPDATED | R |
| Subtask 571208-020-408-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-414-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-410-001 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-831-409-001 | SUBTASK SOLUTION UPDATED<br>PART NUMBER UPDATED<br>MATERIAL LIST UPDATED | R |
| Subtask 571208-020-409-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-415-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-411-001 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-831-410-001 | SUBTASK SOLUTION UPDATED<br>PART NUMBER UPDATED<br>MATERIAL LIST UPDATED | R |
| Subtask 571208-020-410-005 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-419-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-412-002 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-412-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-411-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-411-005 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-320-418-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-413-002 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-250-413-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-412-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-412-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-417-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-414-002 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-831-413-002 | SUBTASK SOLUTION UPDATED<br>PART NUMBER UPDATED<br>MATERIAL LIST UPDATED | R |
| Subtask 571208-020-413-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-416-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-415-002 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-831-414-002 | SUBTASK SOLUTION UPDATED<br>PART NUMBER UPDATED<br>MATERIAL LIST UPDATED | R |
| Subtask 571208-020-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-000-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-250-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>NOTE UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-410-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-406-001 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-406-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL LIST UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-020-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-407-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-407-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-406-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL LIST UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-406-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-408-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-408-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-407-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-407-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-409-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-409-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-408-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-408-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-414-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-410-002 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-410-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-831-409-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-409-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-415-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-411-002 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-411-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-410-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-412-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-417-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-414-001 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-414-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-413-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-413-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-416-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-415-001 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-415-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-414-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-250-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-000-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>NOTE UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-320-410-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-406-001 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-250-406-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL LIST UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-407-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-407-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-406-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL LIST UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-406-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-408-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-408-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-407-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-407-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-409-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-409-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-408-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-020-408-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-414-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-410-003 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-250-410-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-409-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-409-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-415-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-411-003 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-250-411-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-410-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-412-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-417-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-414-001 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-250-414-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-413-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-413-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-416-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-415-001 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-250-415-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-831-414-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-000-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>NOTE UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-250-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-410-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-406-001 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-406-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL LIST UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-407-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-407-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-406-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL LIST UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-406-005 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-408-005 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-408-005 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-407-005 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-020-407-005 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-409-005 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-409-005 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-408-005 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-408-004 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-414-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-410-004 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-410-004 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-409-004 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-409-004 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-415-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-411-004 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-411-004 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-410-004 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-410-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-419-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-412-002 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-412-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-831-411-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-411-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-418-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-413-002 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-413-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-412-002 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-412-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-417-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-414-001 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-414-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-413-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-413-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-416-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-415-001 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-415-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-414-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-250-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-000-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>NOTE UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-320-410-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-406-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL LIST UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-407-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-407-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-406-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL LIST UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-406-006 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER DESCRIPTION UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-320-406-001 | SUBTASK SOLUTION UPDATED<br>LOCATION UPDATED<br>PANEL UPDATED<br>ZONE UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED<br>CONFIGURATION UPDATED<br>NOTE UPDATED<br>MANPOWER RESSOURCE UPDATED<br>REFERENCES UPDATED | R |
| Subtask 571208-320-408-006 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>CAUTION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>NOTE UPDATED<br>FIGURE REFERENCE UPDATED<br>MANPOWER RESSOURCE UPDATED | R |
| Subtask 571208-250-408-006 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-831-407-006 | SUBTASK SOLUTION UPDATED<br>KEYWORD UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED<br>CONSUMABLE UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED<br>NOTE UPDATED<br>PART NUMBER DESCRIPTION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>MATERIAL LIST UPDATED | R |
| Subtask 571208-020-407-006 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER DESCRIPTION UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-320-411-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-409-006 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>CAUTION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>NOTE UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-409-006 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-408-006 | SUBTASK SOLUTION UPDATED<br>KEYWORD UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED<br>CONSUMABLE UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED<br>NOTE UPDATED<br>PART NUMBER DESCRIPTION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>MATERIAL LIST UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-020-408-005 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER DESCRIPTION UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-320-412-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-414-005 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-410-005 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-250-410-005 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-409-005 | SUBTASK SOLUTION UPDATED<br>KEYWORD UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED<br>CONSUMABLE UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED<br>NOTE UPDATED<br>PART NUMBER DESCRIPTION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>MATERIAL LIST UPDATED | R |
| Subtask 571208-020-409-005 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER DESCRIPTION UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-320-413-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-415-005 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-411-005 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-250-411-005 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-831-410-005 | SUBTASK SOLUTION UPDATED<br>KEYWORD UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED<br>CONSUMABLE UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED<br>NOTE UPDATED<br>PART NUMBER DESCRIPTION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>MATERIAL LIST UPDATED | R |
| Subtask 571208-020-410-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-419-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-412-003 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-412-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-411-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-411-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-418-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-413-003 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-413-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-412-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-412-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-417-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-414-001 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-414-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-831-413-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-413-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-416-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-415-001 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-415-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-414-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-000-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>NOTE UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-402-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-404-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-250-404-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-403-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-403-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-405-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-250-405-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-404-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-410-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-406-001 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-406-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL LIST UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-407-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-407-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-406-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL LIST UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-020-406-007 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-408-007 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-408-007 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-407-007 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-407-007 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-409-007 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-409-007 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-408-007 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-408-007 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-414-007 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-410-007 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-410-007 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-409-007 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-409-007 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-415-007 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-411-007 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-831-410-007 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-020-412-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-417-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-414-003 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-250-414-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-413-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-413-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-416-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-415-003 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-250-415-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-414-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-000-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-831-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>NOTE UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-402-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-404-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-404-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-403-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-403-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-405-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-250-405-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-404-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-410-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-406-001 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-406-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL LIST UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-320-407-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-407-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-406-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL LIST UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-406-008 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-408-008 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-408-008 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-407-008 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-407-008 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-409-008 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-409-008 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-408-008 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-408-008 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-414-008 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-410-008 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-410-008 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-409-008 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-020-409-008 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-415-008 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-411-008 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-831-410-008 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-412-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-417-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-414-003 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-250-414-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-413-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-413-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-416-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-415-003 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-250-415-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-414-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-000-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>NOTE UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-402-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-404-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-404-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-403-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-403-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-405-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-250-405-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-404-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-410-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-406-001 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |



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

| | | |
|---|---|---|
| Subtask 571208-250-406-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL LIST UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-407-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-407-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-406-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL LIST UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-406-009 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-408-009 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-408-009 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-407-009 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-407-009 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-409-009 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-409-009 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-408-009 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-020-408-009 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-414-009 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-410-009 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-250-410-009 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-409-009 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-409-009 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-415-009 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-411-009 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-250-411-009 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-410-009 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-410-004 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-419-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-412-004 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-250-412-004 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-411-004 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL LIST UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-411-004 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-418-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-413-004 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |



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

| | | |
|---|---|---|
| Subtask 571208-250-413-004 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-412-004 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL LIST UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-412-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-417-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-414-003 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-414-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-413-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-413-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-416-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-415-003 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-415-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-414-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-000-401-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-320-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-403-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-402-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>NOTE UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-402-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-404-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-404-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-403-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-403-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-405-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-250-405-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-404-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-404-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-410-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-406-001 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-406-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-831-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL LIST UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-405-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-407-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-407-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-406-001 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL LIST UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-406-010 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER DESCRIPTION UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-320-406-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-408-010 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>CAUTION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>NOTE UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-408-010 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-407-010 | SUBTASK SOLUTION UPDATED<br>KEYWORD UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED<br>CONSUMABLE UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED<br>NOTE UPDATED<br>PART NUMBER DESCRIPTION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>MATERIAL LIST UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-020-407-010 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER DESCRIPTION UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-320-411-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-409-010 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>CAUTION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>NOTE UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-250-409-010 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-408-010 | SUBTASK SOLUTION UPDATED<br>KEYWORD UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED<br>CONSUMABLE UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED<br>NOTE UPDATED<br>PART NUMBER DESCRIPTION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>MATERIAL LIST UPDATED | R |
| Subtask 571208-020-408-010 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER DESCRIPTION UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-320-412-004 | SUBTASK SOLUTION UPDATED<br>LOCATION UPDATED<br>PANEL UPDATED<br>ZONE UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED<br>CONFIGURATION UPDATED<br>NOTE UPDATED<br>MANPOWER RESSOURCE UPDATED<br>REFERENCES UPDATED | R |
| Subtask 571208-320-414-010 | SUBTASK SOLUTION ADDED | N |



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

| | | |
|---|---|---|
| Subtask 571208-320-410-010 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-250-410-010 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-409-010 | SUBTASK SOLUTION UPDATED<br>KEYWORD UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED<br>CONSUMABLE UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED<br>NOTE UPDATED<br>PART NUMBER DESCRIPTION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>MATERIAL LIST UPDATED | R |
| Subtask 571208-020-409-010 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER DESCRIPTION UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-320-413-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-415-010 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-411-010 | SUBTASK SOLUTION DELETED FOR APPLICABLE MSN | D |
| Subtask 571208-250-411-010 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-410-010 | SUBTASK SOLUTION UPDATED<br>KEYWORD UPDATED<br>ITEM NUMBER UPDATED<br>PART NUMBER UPDATED<br>QUANTITY UPDATED<br>CONSUMABLE UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED<br>NOTE UPDATED<br>PART NUMBER DESCRIPTION UPDATED<br>REFERENCED DOCUMENTATION UPDATED<br>MATERIAL LIST UPDATED | R |
| Subtask 571208-020-410-004 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |



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

| | | |
|---|---|---|
| Subtask 571208-320-419-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-412-004 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-411-005 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>MATERIAL LIST UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-411-004 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-418-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-413-004 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-413-004 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-412-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-412-005 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-020-412-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-417-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-414-003 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-414-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-413-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-413-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED<br>CAUTION UPDATED | R |
| Subtask 571208-320-416-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-415-003 | SUBTASK SOLUTION DELETED FOR<br>APPLICABLE MSN | D |
| Subtask 571208-250-415-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-831-414-003 | SUBTASK SOLUTION UPDATED<br>CONFIGURATION UPDATED<br>FIGURE REFERENCE UPDATED | R |
| Subtask 571208-020-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-401-001 | SUBTASK SOLUTION ADDED | N |



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

| | | |
|---|---|---|
| Subtask 571208-250-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-000-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-410-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-406-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-407-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-407-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-406-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-406-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-408-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-408-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-407-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-407-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-409-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-409-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-408-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-408-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-414-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-410-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-409-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-409-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-415-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-411-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-410-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-412-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-417-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-414-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-413-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-413-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-416-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-415-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-414-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-960-401-001 | SUBTASK SOLUTION ADDED | N |



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

| | | |
|---|---|---|
| Subtask 571208-020-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-000-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-410-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-406-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-407-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-407-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-406-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-406-006 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-406-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-408-006 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-408-006 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-407-006 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-407-006 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-411-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-409-006 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-409-006 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-408-006 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-408-005 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-412-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-414-005 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-410-005 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-409-005 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-409-005 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-413-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-415-005 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-411-005 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-410-005 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-410-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-419-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-412-003 | SUBTASK SOLUTION ADDED | N |



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

| | | |
|---|---|---|
| Subtask 571208-831-411-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-411-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-418-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-413-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-412-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-412-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-417-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-414-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-413-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-413-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-416-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-415-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-414-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-960-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-000-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-402-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-404-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-404-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-403-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-403-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-405-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-405-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-404-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-410-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-406-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-407-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-407-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-406-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-406-007 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-408-008 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-408-008 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-407-008 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-407-008 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-409-008 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-409-008 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-408-008 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-408-008 | SUBTASK SOLUTION ADDED | N |



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

| | | |
|---|---|---|
| Subtask 571208-320-414-008 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-410-008 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-409-008 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-409-008 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-415-008 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-411-007 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-410-008 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-412-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-417-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-414-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-413-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-413-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-416-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-415-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-414-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-960-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-000-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-410-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-406-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-407-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-407-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-406-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-406-005 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-408-005 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-408-005 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-407-005 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-407-005 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-409-005 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-409-005 | SUBTASK SOLUTION ADDED | N |



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

| | | |
|---|---|---|
| Subtask 571208-831-408-005 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-408-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-414-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-410-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-409-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-409-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-415-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-411-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-410-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-410-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-419-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-412-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-411-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-411-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-418-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-413-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-412-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-412-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-417-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-414-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-413-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-413-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-416-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-415-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-414-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-960-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-000-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-402-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-404-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-404-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-403-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-403-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-405-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-405-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-404-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-410-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-406-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-405-001 | SUBTASK SOLUTION ADDED | N |



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

| | | |
|---|---|---|
| Subtask 571208-320-407-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-407-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-406-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-406-009 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-408-009 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-408-009 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-407-009 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-407-009 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-409-009 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-409-009 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-408-009 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-408-009 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-414-009 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-410-009 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-409-009 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-409-009 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-415-009 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-411-009 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-410-009 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-410-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-419-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-412-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-411-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-411-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-418-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-413-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-412-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-412-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-417-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-414-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-413-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-413-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-416-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-415-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-414-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-960-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-000-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-402-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-404-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-404-003 | SUBTASK SOLUTION ADDED | N |



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

| | | |
|---|---|---|
| Subtask 571208-831-403-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-403-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-405-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-405-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-404-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-410-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-406-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-407-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-407-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-406-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-406-010 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-406-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-408-010 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-408-010 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-407-010 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-407-010 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-411-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-409-010 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-409-010 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-408-010 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-408-010 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-412-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-414-010 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-410-010 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-409-010 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-409-010 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-413-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-415-010 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-411-010 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-410-010 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-410-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-419-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-412-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-411-005 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-411-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-418-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-413-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-412-004 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-412-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-417-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-414-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-413-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-413-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-416-003 | SUBTASK SOLUTION ADDED | N |



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

| | | |
|---|---|---|
| Subtask 571208-250-415-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-414-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-960-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-000-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-410-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-406-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-407-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-407-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-406-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-406-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-408-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-408-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-407-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-407-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-409-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-409-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-408-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-408-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-414-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-410-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-409-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-409-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-415-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-411-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-410-002 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-412-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-417-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-414-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-413-001 | SUBTASK SOLUTION ADDED | N |



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

| | | |
|---|---|---|
| Subtask 571208-020-413-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-416-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-415-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-414-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-960-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-000-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-403-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-402-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-402-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-404-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-404-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-403-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-403-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-405-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-405-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-404-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-404-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-410-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-406-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-405-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-407-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-407-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-406-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-406-008 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-408-007 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-408-007 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-407-007 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-407-007 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-409-007 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-409-007 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-408-007 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-408-007 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-414-007 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-410-007 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-409-007 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-409-007 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-415-007 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-411-008 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-410-007 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-412-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-417-003 | SUBTASK SOLUTION ADDED | N |



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

| | | |
|---|---|---|
| Subtask 571208-250-414-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-413-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-020-413-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-320-416-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-250-415-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-831-414-003 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-960-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-720-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-720-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-720-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-720-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-720-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-720-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-720-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-720-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-942-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-942-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-942-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-942-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-942-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-942-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-942-401-001 | SUBTASK SOLUTION ADDED | N |
| Subtask 571208-942-401-001 | SUBTASK SOLUTION ADDED | N |
| Fig. A-UBAAA | | |
| Fig. A-UBAAA Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBAAA Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBAAB | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBAAB Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBAAB Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBBAA | | |
| Fig. A-UBBAA Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBBAA Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBBAB | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBBAB Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBBAB Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBBAC | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBBAC Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBBAC Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBCAA | | |
| Fig. A-UBCAA Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBCAA Sheet 02 | SHEET UPDATED | R |



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

| | | |
|---|---|---|
| Fig. A-UBCAB | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBCAB Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBCAB Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBDAA | FIGURE SOLUTION UPDATED | R |
| Fig. A-UBDAA Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBDAA Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBDAA Sheet 03 | SHEET ADDED | N |
| Fig. A-UBDAB | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBDAB Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBDAB Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBDAC | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBDAC Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBDAC Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBDAD | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBDAD Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBDAD Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBDAE | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBDAE Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBDAE Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBDAE Sheet 03 | SHEET ADDED | N |
| Fig. A-UBDAE Sheet 04 | SHEET ADDED | N |
| Fig. A-UBDAF | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBDAF Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBDAF Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBDAG | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBDAG Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBDAG Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBDAH | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBDAH Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBDAH Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBDAJ | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBDAJ Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBDAJ Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBDAJ Sheet 03 | SHEET ADDED | N |
| Fig. A-UBDAJ Sheet 04 | SHEET ADDED | N |



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

| | | |
|---|---|---|
| Fig. A-UBEAA | | |
| Fig. A-UBEAA Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBEAA Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBEAB | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBEAB Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBEAB Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBEAC | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBEAC Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBEAC Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBEAD | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBEAD Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBEAD Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBEAE | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBEAE Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBEAE Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBEAE Sheet 03 | SHEET ADDED | N |
| Fig. A-UBEAF | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBEAF Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBEAF Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBEAG | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBEAG Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBEAG Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBEAH | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBEAH Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBEAH Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBEAJ | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBEAJ Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBEAJ Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBEAJ Sheet 03 | SHEET ADDED | N |
| Fig. A-UBFAA | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBFAA Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBFAA Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBFAB | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBFAB Sheet 01 | SHEET UPDATED | R |



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

| | | |
|---|---|---|
| Fig. A-UBFAB Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBFAC | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBFAC Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBFAC Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBGAA | | |
| Fig. A-UBGAA Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBGAA Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBGAB | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBGAB Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBGAB Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBGAC | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UBGAC Sheet 01 | SHEET UPDATED | R |
| Fig. A-UBGAC Sheet 02 | SHEET UPDATED | R |
| Fig. A-UBHAA | FIGURE SOLUTION ADDED | N |
| Fig. A-UBHAA Sheet 01 | SHEET ADDED | N |
| Fig. A-UBHAB | FIGURE SOLUTION ADDED | N |
| Fig. A-UBHAB Sheet 01 | SHEET ADDED | N |
| **Appendix 01 - Manpower Gantt Chart** | | |
| APPENDIX CONTENT | APPENDIX CONTENT ADDED | N |
| Fig. A-UAAAA | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UAAAA Sheet 01 | SHEET UPDATED | R |
| Fig. A-UAAAA Sheet 02 | SHEET UPDATED | R |
| Fig. A-UAAAA Sheet 03 | SHEET UPDATED | R |
| Fig. A-UAAAA Sheet 04 | SHEET UPDATED | R |
| Fig. A-UAAAA Sheet 05 | SHEET UPDATED | R |
| Fig. A-UAAAB | FIGURE SOLUTION UPDATED<br>CONFIGURATION UPDATED | R |
| Fig. A-UAAAB Sheet 01 | SHEET UPDATED | R |
| Fig. A-UAAAB Sheet 02 | SHEET UPDATED | R |
| Fig. A-UAAAB Sheet 03 | SHEET UPDATED | R |
| Fig. A-UAAAB Sheet 04 | SHEET UPDATED | R |
| Fig. A-UAAAC | FIGURE SOLUTION ADDED | N |
| Fig. A-UAAAC Sheet 01 | SHEET ADDED | N |
| Fig. A-UAAAC Sheet 02 | SHEET ADDED | N |
| Fig. A-UAAAC Sheet 03 | SHEET ADDED | N |
| Fig. A-UAAAC Sheet 04 | SHEET ADDED | N |
| Fig. A-UAAAC Sheet 05 | SHEET ADDED | N |



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

SERVICE BULLETIN
REVISION TRANSMITTAL SHEET

**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: Nov 21/16

REVISION No. : 01 - Sep 23/19



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

SERVICE BULLETIN
SUMMARY

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

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

# MANDATORY MANDATORY MANDATORY

ATA SYSTEM: 57

## TITLE: WINGS - GENERAL - INTRODUCE UPPER CLEAT TO STRINGER ATTACHMENTS AT RIBS 2 - 7. MODIFICATION BY SB DUE TO WFD

****CONF ALL**

**MODIFICATIONS**

| MODIFICATION CLASSIFICATION | | | | | |
|---|---|---|---|---|---|
| MAJOR | 159478J4359 | | | | |
| MINOR | 162156J4442 | | | | |

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**

FAR26.21 requirements determine the necessity to have a solution to achieve the Limit of Validity (LoV) in all structures, to demonstrate wide spread fatigue damage is unlikely to occur. To delay the onset of WFD a structural modification is required allowing the aircraft to continue operations up to the LoV. Upper Cleat to Upper Stringer attachments, at Ribs 2-7 inclusive, are to have the fatigue life in the holes restored by oversizing to demonstrate the LoV can be achieved.

This Service Bulletin details the procedure to oversize affected fastener position holes through cleats and stringer webs, between ribs 2-7 inclusive. Pre and post mod holes are clearance fit.

This modification applies to all legacy A320 family aircraft (Pre-Mod 160001J3282/160021J3446), Forward Fit Sharklet modification embodiment (Post-Mod 160001J3282/160021J3446 and Pre-Mod 161139J3572/161345J3834) and In-Service Retrofitted Sharklet Aircraft (Post-Mod 160080J3705).

The operator must always use the CONFIG definitions to identify the correct CONFIG for their MSN, not the CONFIG dictated by the MSN allocation shown in the Service Bulletin.

Original design intent will be restored.

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



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

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

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

AIRBUS disclaims any liability for the effect which the Service Bulletin may have on repairs performed on the aircraft before embodiment of the Service Bulletin.

If the post Service Bulletin repair status is not covered by the SRM and for repairs outside of the SRM covered by an RAS issued by AIRBUS, AIRBUS Customer Services Repair Engineering Support department should be contacted. Repair review will be done by AIRBUS at conditions of the Customer Services Catalogue.

## GENERAL EVALUATION

| EVALUATION TABLE | | | |
|---|---|---|---|
| COMPLIANCE | 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 | NO | VENDOR SB INVOLVED | NO |
| A/C MAINTENANCE JACKING | YES | DEFUELING/VENTING | YES |

NOTE (1): Service Bulletin must be accomplished.

## MATERIAL PRICE INFORMATION

****CONF 001**

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B01R03 | 1 | 3,050.00 | Bolts, nuts, washers |
| Kit 571208B03R02 | 1 | 2,390.00 | Bolts, nuts, washers |
| Kit 571208B06R02 | 1 | 2,520.00 | Bolts, nuts, washers |
| Kit 571208B08R02 | 1 | 2,660.00 | Bolts, nuts, washers |
| Kit 571208B17R03 | 1 | 2,190.00 | Bolts, nuts, washers |
| Kit 571208B26R01 | 1 | 50.00 | Bolts, nuts, washers |
| Kit 571208B29R02 | 1 | 2,160.00 | Bolts, nuts, washers |
| **TOTAL** | | **15,020.00** | |



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

**CONF 002

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B02R01 | 1 | 2,960.00 | Bolts, nuts, washers |
| Kit 571208B04R01 | 1 | 2,320.00 | Bolts, nuts, washers |
| Kit 571208B07R01 | 1 | 2,450.00 | Bolts, nuts, washers |
| Kit 571208B09R01 | 1 | 2,870.00 | Bolts, nuts, washers |
| Kit 571208B18R01 | 1 | 2,100.00 | Bolts, nuts, washers |
| Kit 571208B30R01 | 1 | 2,090.00 | Bolts, nuts, washers |
| **TOTAL** | | **14,790.00** | |

**CONF 003

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B02R01 | 1 | 2,960.00 | Bolts, nuts, washers |
| Kit 571208B04R01 | 1 | 2,320.00 | Bolts, nuts, washers |
| Kit 571208B07R01 | 1 | 2,450.00 | Bolts, nuts, washers |
| Kit 571208B10R01 | 1 | 2,660.00 | Bolts, nuts, washers |
| Kit 571208B19R01 | 1 | 2,100.00 | Bolts, nuts, washers |
| Kit 571208B30R01 | 1 | 2,090.00 | Bolts, nuts, washers |
| **TOTAL** | | **14,580.00** | |

**CONF 004

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B02R01 | 1 | 2,960.00 | Bolts, nuts, washers |
| Kit 571208B04R01 | 1 | 2,320.00 | Bolts, nuts, washers |
| Kit 571208B07R01 | 1 | 2,450.00 | Bolts, nuts, washers |
| Kit 571208B11R01 | 1 | 2,660.00 | Bolts, nuts, washers |
| Kit 571208B20R01 | 1 | 2,100.00 | Bolts, nuts, washers |
| Kit 571208B26R01 | 1 | 50.00 | Bolts, nuts, washers |
| Kit 571208B30R01 | 1 | 2,090.00 | Bolts, nuts, washers |
| **TOTAL** | | **14,630.00** | |

**CONF 005

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B02R01 | 1 | 2,960.00 | Bolts, nuts, washers |



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

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B04R01 | 1 | 2,320.00 | Bolts, nuts, washers |
| Kit 571208B07R01 | 1 | 2,450.00 | Bolts, nuts, washers |
| Kit 571208B12R04 | 1 | 2,560.00 | Bolts, nuts, washers, foam |
| Kit 571208B21R03 | 1 | 2,130.00 | Bolts, nuts, washers, foam |
| Kit 571208B27R01 | 1 | 50.00 | Bolts, nuts, washers |
| Kit 571208B30R01 | 1 | 2,090.00 | Bolts, nuts, washers |
| **TOTAL** | | **14,560.00** | |

****CONF 006**

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B02R01 | 1 | 2,960.00 | Bolts, nuts, washers |
| Kit 571208B05R02 | 1 | 2,460.00 | Bolts, nuts, washers |
| Kit 571208B07R01 | 1 | 2,450.00 | Bolts, nuts, washers |
| Kit 571208B13R01 | 1 | 2,660.00 | Bolts, nuts, washers |
| Kit 571208B22R01 | 1 | 2,010.00 | Bolts, nuts, washers |
| Kit 571208B31R01 | 1 | 2,020.00 | Bolts, nuts, washers |
| **TOTAL** | | **14,560.00** | |

****CONF 007**

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B02R01 | 1 | 2,960.00 | Bolts, nuts, washers |
| Kit 571208B05R02 | 1 | 2,460.00 | Bolts, nuts, washers |
| Kit 571208B07R01 | 1 | 2,450.00 | Bolts, nuts, washers |
| Kit 571208B14R01 | 1 | 2,660.00 | Bolts, nuts, washers |
| Kit 571208B23R01 | 1 | 2,100.00 | Bolts, nuts, washers |
| Kit 571208B31R01 | 1 | 2,020.00 | Bolts, nuts, washers |
| **TOTAL** | | **14,650.00** | |

****CONF 008**

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B02R01 | 1 | 2,960.00 | Bolts, nuts, washers |
| Kit 571208B05R02 | 1 | 2,460.00 | Bolts, nuts, washers |
| Kit 571208B07R01 | 1 | 2,450.00 | Bolts, nuts, washers |



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

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B15R01 | 1 | 2,370.00 | Bolts, nuts, washers |
| Kit 571208B24R01 | 1 | 2,100.00 | Bolts, nuts, washers |
| Kit 571208B28R02 | 1 | 50.00 | Bolts, nuts, washers |
| Kit 571208B31R01 | 1 | 2,020.00 | Bolts, nuts, washers |
| **TOTAL** | | **14,410.00** | |

****CONF 009**

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B02R01 | 1 | 2,960.00 | Bolts, nuts, washers |
| Kit 571208B05R02 | 1 | 2,460.00 | Bolts, nuts, washers |
| Kit 571208B07R01 | 1 | 2,450.00 | Bolts, nuts, washers |
| Kit 571208B16R04 | 1 | 2,530.00 | Bolts, nuts, washers, foam |
| Kit 571208B25R03 | 1 | 2,100.00 | Bolts, nuts, washers, foam |
| Kit 571208B28R02 | 1 | 50.00 | Bolts, nuts, washers |
| Kit 571208B31R01 | 1 | 2,020.00 | Bolts, nuts, washers |
| **TOTAL** | | **14,570.00** | |

****CONF 010**

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B02R01 | 1 | 2,960.00 | Bolts, nuts, washers |
| Kit 571208B04R01 | 1 | 2,320.00 | Bolts, nuts, washers |
| Kit 571208B07R01 | 1 | 2,450.00 | Bolts, nuts, washers |
| Kit 571208B10R01 | 1 | 2,660.00 | Bolts, nuts, washers |
| Kit 571208B19R01 | 1 | 2,100.00 | Bolts, nuts, washers |
| Kit 571208B30R01 | 1 | 2,090.00 | Bolts, nuts, washers |
| **TOTAL** | | **14,580.00** | |

****CONF 011**

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B02R01 | 1 | 2,960.00 | Bolts, nuts, washers |
| Kit 571208B04R01 | 1 | 2,320.00 | Bolts, nuts, washers |
| Kit 571208B07R01 | 1 | 2,450.00 | Bolts, nuts, washers |
| Kit 571208B12R04 | 1 | 2,560.00 | Bolts, nuts, washers, foam |



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

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B21R03 | 1 | 2,130.00 | Bolts, nuts, washers, foam |
| Kit 571208B27R01 | 1 | 50.00 | Bolts, nuts, washers |
| Kit 571208B30R01 | 1 | 2,090.00 | Bolts, nuts, washers |
| **TOTAL** | | **14,560.00** | |

****CONF 012**

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B02R01 | 1 | 2,960.00 | Bolts, nuts, washers |
| Kit 571208B05R02 | 1 | 2,460.00 | Bolts, nuts, washers |
| Kit 571208B07R01 | 1 | 2,450.00 | Bolts, nuts, washers |
| Kit 571208B14R01 | 1 | 2,660.00 | Bolts, nuts, washers |
| Kit 571208B23R01 | 1 | 2,100.00 | Bolts, nuts, washers |
| Kit 571208B31R01 | 1 | 2,020.00 | Bolts, nuts, washers |
| **TOTAL** | | **14,650.00** | |

****CONF 013**

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B02R01 | 1 | 2,960.00 | Bolts, nuts, washers |
| Kit 571208B04R01 | 1 | 2,320.00 | Bolts, nuts, washers |
| Kit 571208B07R01 | 1 | 2,450.00 | Bolts, nuts, washers |
| Kit 571208B11R01 | 1 | 2,660.00 | Bolts, nuts, washers |
| Kit 571208B20R01 | 1 | 2,100.00 | Bolts, nuts, washers |
| Kit 571208B26R01 | 1 | 50.00 | Bolts, nuts, washers |
| Kit 571208B30R01 | 1 | 2,090.00 | Bolts, nuts, washers |
| **TOTAL** | | **14,630.00** | |

****CONF 014**

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B02R01 | 1 | 2,960.00 | Bolts, nuts, washers |
| Kit 571208B05R02 | 1 | 2,460.00 | Bolts, nuts, washers |
| Kit 571208B07R01 | 1 | 2,450.00 | Bolts, nuts, washers |
| Kit 571208B15R01 | 1 | 2,370.00 | Bolts, nuts, washers |
| Kit 571208B24R01 | 1 | 2,100.00 | Bolts, nuts, washers |



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

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B28R02 | 1 | 50.00 | Bolts, nuts, washers |
| Kit 571208B31R01 | 1 | 2,020.00 | Bolts, nuts, washers |
| **TOTAL** | | **14,410.00** | |

****CONF 015**

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B02R01 | 1 | 2,960.00 | Bolts, nuts, washers |
| Kit 571208B05R02 | 1 | 2,460.00 | Bolts, nuts, washers |
| Kit 571208B07R01 | 1 | 2,450.00 | Bolts, nuts, washers |
| Kit 571208B16R04 | 1 | 2,530.00 | Bolts, nuts, washers, foam |
| Kit 571208B25R03 | 1 | 2,100.00 | Bolts, nuts, washers, foam |
| Kit 571208B28R02 | 1 | 50.00 | Bolts, nuts, washers |
| Kit 571208B31R01 | 1 | 2,020.00 | Bolts, nuts, washers |
| **TOTAL** | | **14,570.00** | |

****CONF 016**

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B02R01 | 1 | 2,960.00 | Bolts, nuts, washers |
| Kit 571208B04R01 | 1 | 2,320.00 | Bolts, nuts, washers |
| Kit 571208B07R01 | 1 | 2,450.00 | Bolts, nuts, washers |
| Kit 571208B09R01 | 1 | 2,870.00 | Bolts, nuts, washers |
| Kit 571208B18R01 | 1 | 2,100.00 | Bolts, nuts, washers |
| Kit 571208B30R01 | 1 | 2,090.00 | Bolts, nuts, washers |
| **TOTAL** | | **14,790.00** | |

****CONF 017**

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| Kit 571208B02R01 | 1 | 2,960.00 | Bolts, nuts, washers |
| Kit 571208B05R02 | 1 | 2,460.00 | Bolts, nuts, washers |
| Kit 571208B07R01 | 1 | 2,450.00 | Bolts, nuts, washers |
| Kit 571208B13R01 | 1 | 2,660.00 | Bolts, nuts, washers |
| Kit 571208B22R01 | 1 | 2,010.00 | Bolts, nuts, washers |
| Kit 571208B31R01 | 1 | 2,020.00 | Bolts, nuts, washers |



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

| MATERIAL PRICE INFORMATION TABLE | | | |
|---|---|---|---|
| **MATERIAL SET** | **QTY PER A/C** | **PRICE PER A/C (USD)** | **MAIN PARTS** |
| **TOTAL** | | **14,560.00** | |

**EFFECTIVITY**

****CONF ALL**

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

| | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 02K | 03Q | 06R | 10N | 11K | 11S | 11X | 13Y | 14S | 15S | 15T | 16T | 17M |
| 17R | 17S | 19R | 20M | 20Q | 23R | 25P | 26L | 27V | 28M | 29S | 31V | 31X |
| 32Q | 34L | 36R | 38W | 39L | 39N | 40N | 40S | 41N | 41S | 43S | 45K | 46L |
| 46U | 47P | 48L | 48O | 48P | 49O | 50T | 53Z | 56O | 59Z | 60U | 61W | 66X |
| 68M | 69X | 72T | 73W | 76W | 78X | 80X | 82M | 82U | 83O | 83Q | 83V | 84M |
| 85T | 86P | 86Z | 87Q | 89Q | 91X | 93M | 95V | 95W | 96O | 96Q | 96U | 98W |
| 98X | 99W | A1L | AAF | AAL | AAR | AAV | AAW | AAY | ABL | ABN | ABQ | ABY |
| ACA | ACI | ADR | AEE | AFL | AFR | AHY | AIC | AIJ | ALK | AMC | AMU | AMV |
| ANA | ANR | ANZ | APJ | ART | ARU | ASA | ASL | ASV | ATR | AUA | AUH | AVA |
| AVJ | AWC | AWW | AXM | AZA | AZU | B2V | BAV | BAW | BEC | BEG | BEL | BGF |
| BGH | BJN | BKP | BRS | BSX | BTK | BTN | BUC | BWJ | C2C | CBG | CBJ | CCA |
| CCM | CDC | CEB | CEF | CES | CFG | CGH | CHB | CLH | CQH | CQN | CRK | CSA |
| CSC | CSN | CSZ | CTB | CTN | CTV | CYP | DAL | DCS | DKH | DLH | DNU | DQA |
| DRK | DTR | EAF | EDW | EIN | ELB | ERN | ETD | ETJ | EVA | EVE | EWE | EWG |
| EZY | F2I | FAD | FBS | FFT | FHM | FHY | FIA | FIN | FLI | FOO | FRN | G4I |
| G8E | GAF | GAP | GBB | GCR | GFA | GJT | GLG | GMI | GOW | GSH | GSW | GWI |
| GWR | GZQ | HDA | HES | HFM | HFY | HIM | HKE | HKJ | HVN | HXA | I2L | IAW |
| IBE | IBS | IGO | IND | IRA | IRB | IRC | IRM | ISR | IYE | IZG | JAD | JAT |
| JAV | JBU | JBW | JCC | JES | JJP | JOC | JSA | JST | JZR | KAC | KAY | KHV |
| KIS | KKK | KME | KNE | KZR | LAA | LAN | LAO | LBT | LDM | LFO | LGW | LKE |
| LLM | LMJ | LMU | LUR | LWA | LYX | LZB | MAC | MAU | MEA | MJF | MJN | MKR |
| MLD | MLM | MMA | MMM | MMO | MRJ | MSC | MSR | MXA | MYX | NIA | NKS | NMA |
| NMB | NUM | NVD | NWK | NWS | O8K | OHY | OLY | OMS | ONE | ORF | OTC | OTF |
| OZW | PAL | PGT | PIA | PIC | PKZ | PTI | QAF | QDA | QQE | QSM | QTR | R1T |
| RBA | RBG | RIH | RJA | RJD | RNA | ROT | RSY | RWZ | RYL | RYW | RZO | SAA |
| SAS | SAW | SBI | SDM | SDR | SEK | SEY | SFJ | SFW | SGQ | SHJ | SHU | SKU |
| SLK | SMC | SND | SNG | SOL | SSG | SSV | SUD | SVA | SVR | SVW | SWM | SWR |
| SYR | SZN | TAE | TAI | TAM | TAP | TAR | TBA | TBJ | TBZ | TCI | TCN | TCX |
| TDR | TGW | THD | THY | TJS | TNA | TSC | TTW | U6A | UAL | UEA | UJX | UKN |
| UNA | USA | UZB | VAW | VIP | VIV | VJC | VKG | VLG | VNL | VOE | VOI | VRE |
| VTI | VVC | WHT | WOW | WRC | WZZ | | | | | | | |

**CONCURRENT REQUIREMENTS**

None

**REFERENCES / REPERCUSSIONS**

| | |
|---|---|
| TFU | None |
| OEB | None |
| AOT | None |
| SIL | None |



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

| | |
|---|---|
| ISI | None |
| LINE MAINTENANCE AFFECTED | No |
| LIFE LIMIT | YES |
| OTHER | OIT ref.999.0101/15 |

**NATURE OF THE WORK**

| | |
|---|---|
| AIRCRAFT | YES |
| EQUIPMENT | NO |
| HARD | NO |
| SOFT | NO |
| OBRM | NO |

**MANPOWER**

****CONF 001**

| Task 571208-831-895-001: Modification | |
|---|---|
| TOTAL MANHOURS | 125.00 |
| ELAPSED TIME (HOURS) | 34.50 |

****CONF 002**

| Task 571208-831-895-001: Modification | |
|---|---|
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

****CONF 003**

| Task 571208-831-895-001: Modification | |
|---|---|
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

****CONF 004**

| Task 571208-831-895-001: Modification | |
|---|---|
| TOTAL MANHOURS | 125.00 |
| ELAPSED TIME (HOURS) | 34.50 |

****CONF 005**

| Task 571208-831-895-001: Modification | |
|---|---|
| TOTAL MANHOURS | 127.00 |
| ELAPSED TIME (HOURS) | 35.50 |

****CONF 006**

| Task 571208-831-895-001: Modification | |
|---|---|
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |



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

**CONF 007

| Task 571208-831-895-001: Modification | |
|---|---|
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

**CONF 008

| Task 571208-831-895-001: Modification | |
|---|---|
| TOTAL MANHOURS | 125.00 |
| ELAPSED TIME (HOURS) | 34.50 |

**CONF 009

| Task 571208-831-895-001: Modification | |
|---|---|
| TOTAL MANHOURS | 127.00 |
| ELAPSED TIME (HOURS) | 35.50 |

**CONF 010

| Task 571208-831-895-001: Modification | |
|---|---|
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

**CONF 011

| Task 571208-831-895-001: Modification | |
|---|---|
| TOTAL MANHOURS | 127.00 |
| ELAPSED TIME (HOURS) | 35.50 |

**CONF 012

| Task 571208-831-895-001: Modification | |
|---|---|
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

**CONF 013

| Task 571208-831-895-001: Modification | |
|---|---|
| TOTAL MANHOURS | 125.00 |
| ELAPSED TIME (HOURS) | 34.50 |

**CONF 014

| Task 571208-831-895-001: Modification | |
|---|---|
| TOTAL MANHOURS | 125.00 |
| ELAPSED TIME (HOURS) | 34.50 |



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

**CONF 015

| Task 571208-831-895-001: Modification | |
|---|---|
| TOTAL MANHOURS | 127.00 |
| ELAPSED TIME (HOURS) | 35.50 |

**CONF 016

| Task 571208-831-895-001: Modification | |
|---|---|
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

**CONF 017

| Task 571208-831-895-001: Modification | |
|---|---|
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

**APPENDICES**

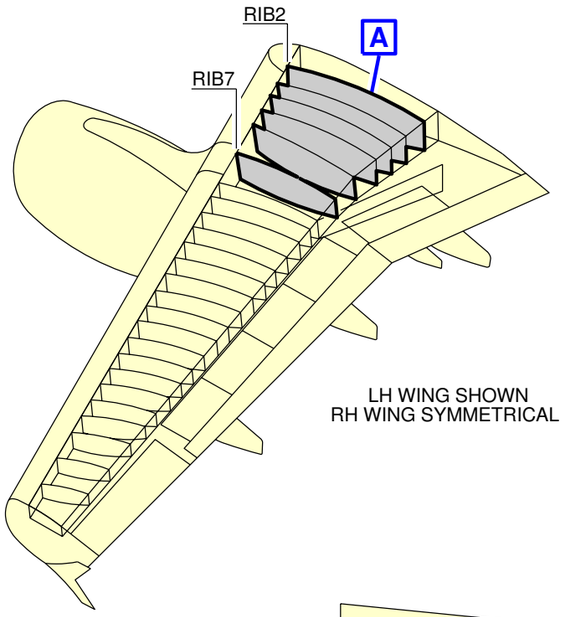
**CONF ALL

Appendix 01 - Manpower Gantt Chart

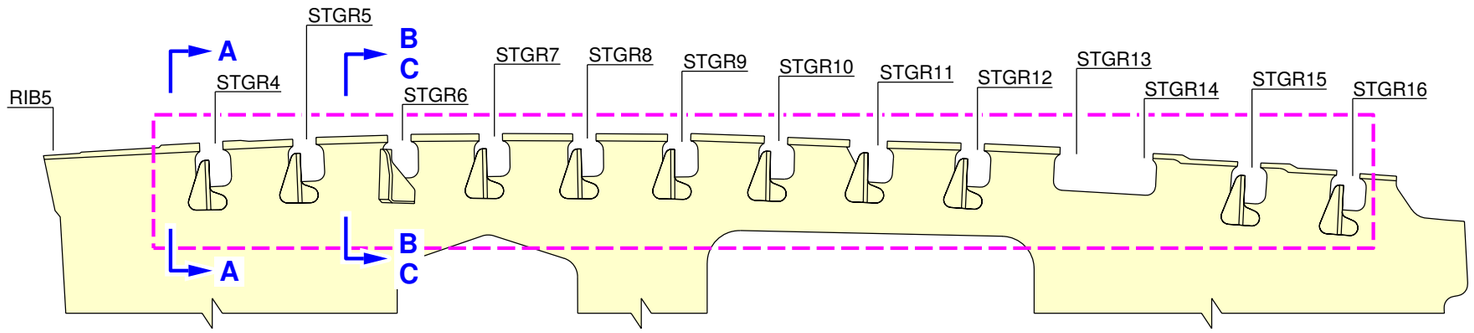


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

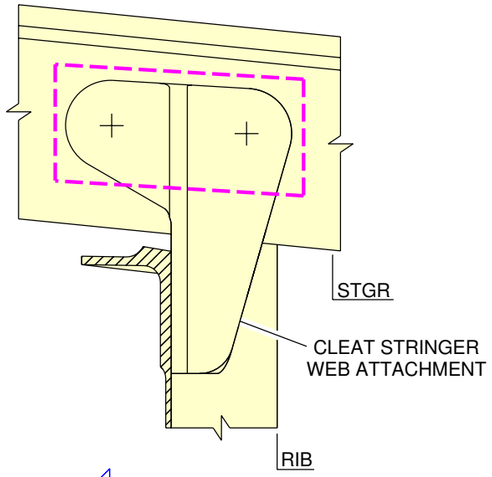
**CONF 002, 006, 016 thru 017




LH WING SHOWN
RH WING SYMMETRICAL

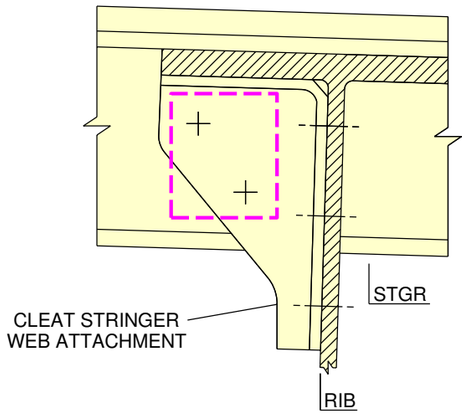


VIEW LOOKING INBOARD
UPPER CLEAT ATTACHMENTS SHOWN
RIB 5 SHOWN
RIBS 2, 3, 4, 6 AND 7 SIMILAR



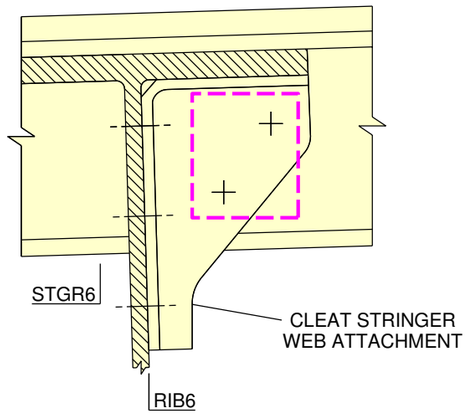
**A - A**

VIEW LOOKING AFT
TYPICAL
EXCEPT WHERE SHOWN



**B - B**

VIEW LOOKING AFT
TYPICAL FOR
RIB 5, STGR 6 AND
RIB 6, STGR 5



**C - C**

VIEW LOOKING AFT

| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

MODIFICATION AREA

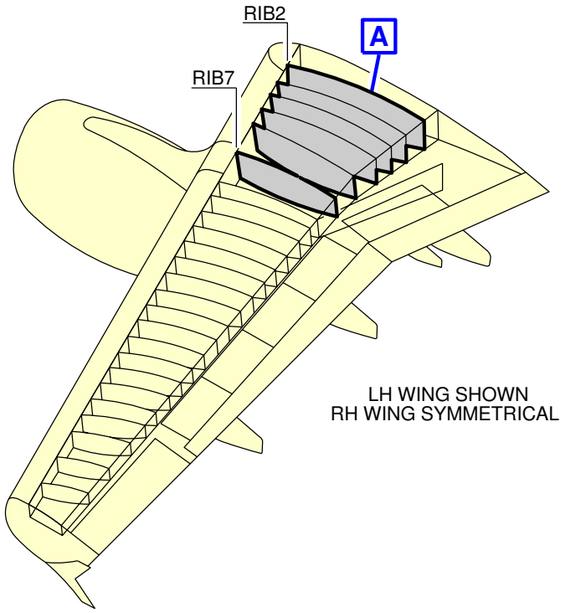
N_SB_571208_7_SAAA_01_03

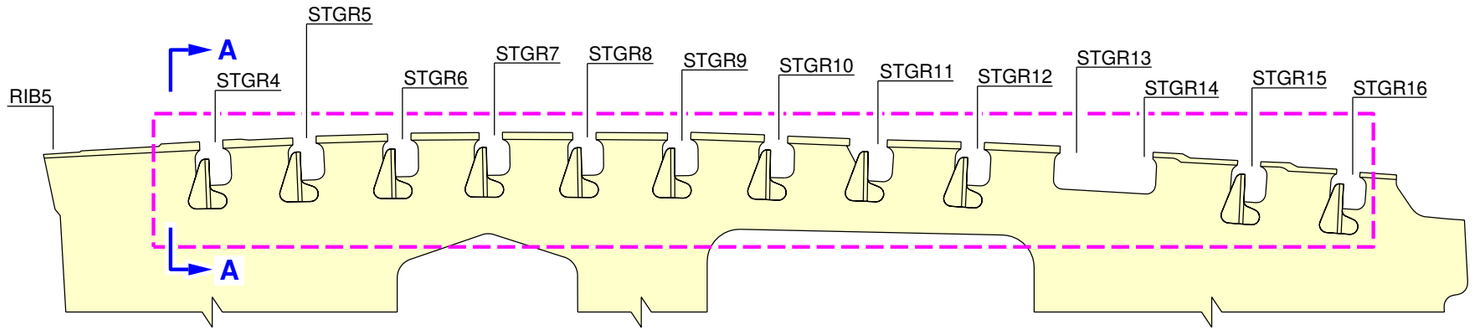
Figure A-USAAA - Sheet 01

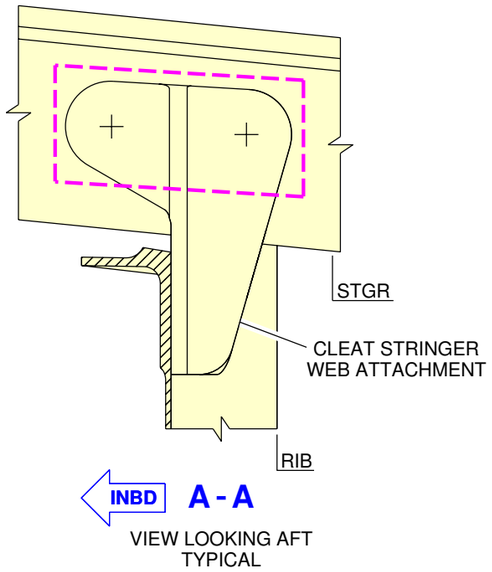


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 003, 007, 010, 012




| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

MODIFICATION AREA

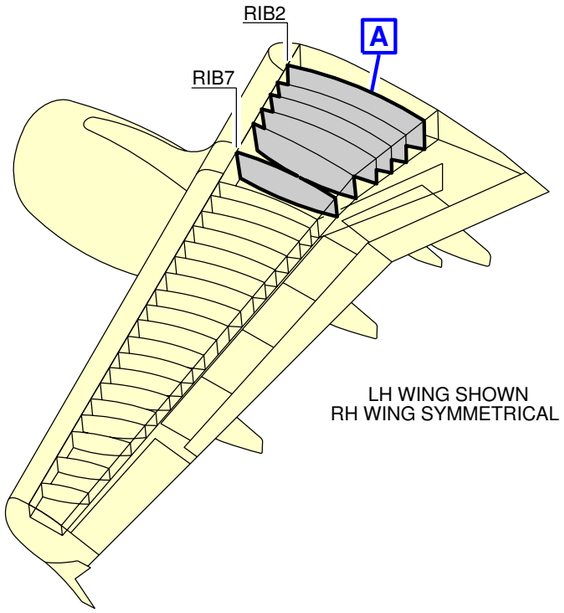
N_SB_571208_7_SAAB_01_04

Figure A-USAAB - Sheet 01

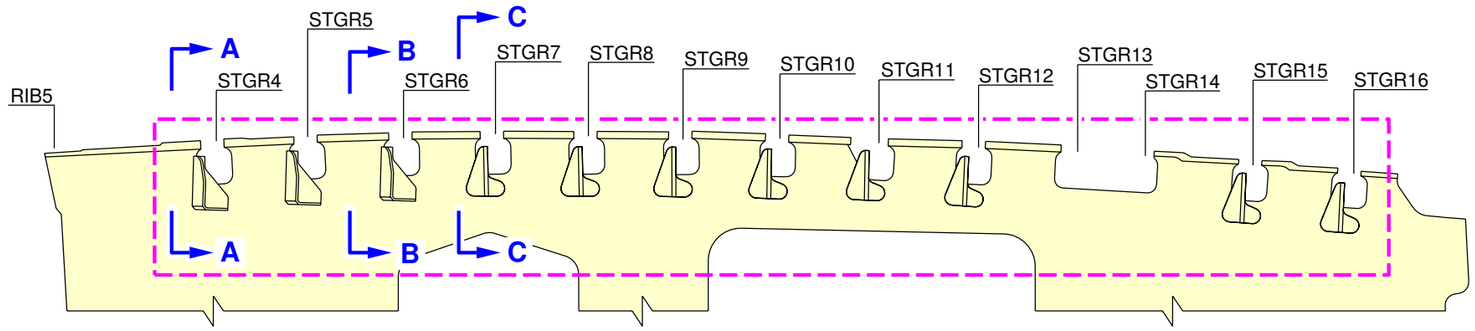


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 004, 008, 013 thru 014

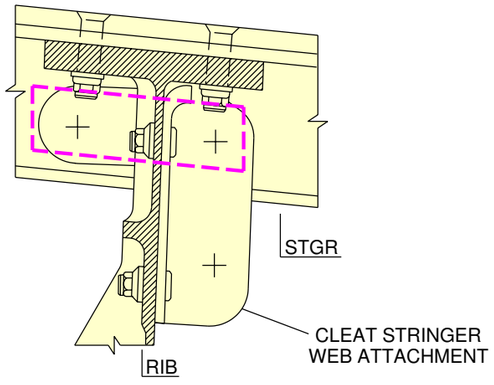



LH WING SHOWN
RH WING SYMMETRICAL



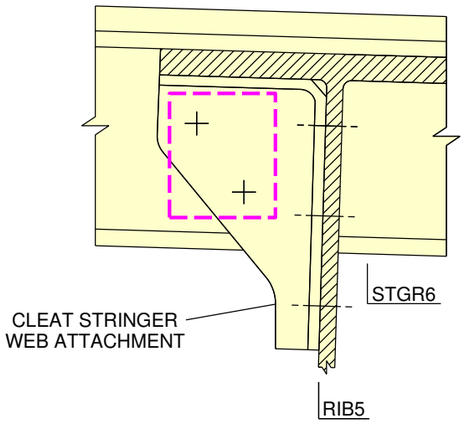

FWD A

VIEW LOOKING INBOARD
UPPER CLEAT ATTACHMENTS SHOWN
RIB 5 SHOWN
RIBS 2, 3, 4, 6 AND 7 SIMILAR



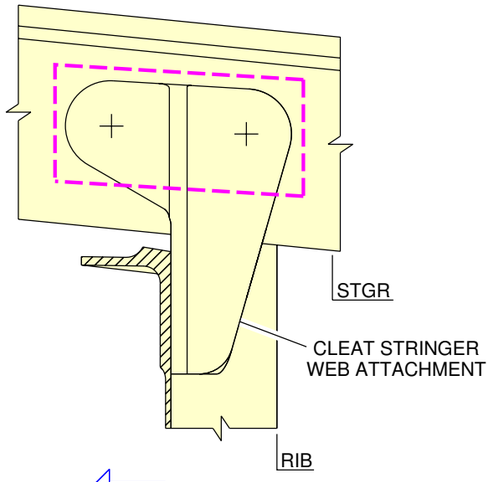

INBD **A - A**

VIEW LOOKING AFT
TYPICAL FOR
RIB 5, STGRS 4 AND 5
AND RIB 6, STGR 5




INBD **B - B**

VIEW LOOKING AFT




INBD **C - C**

VIEW LOOKING AFT
TYPICAL
EXCEPT WHERE SHOWN

| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

MODIFICATION AREA

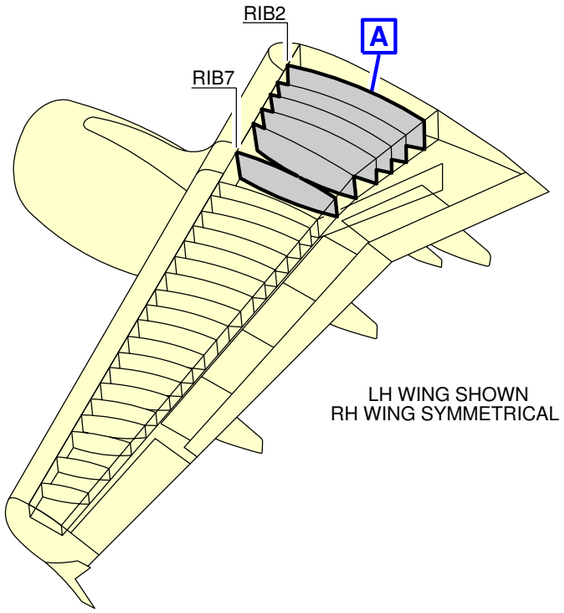
N_SB_571208_7_SAAC_01_05

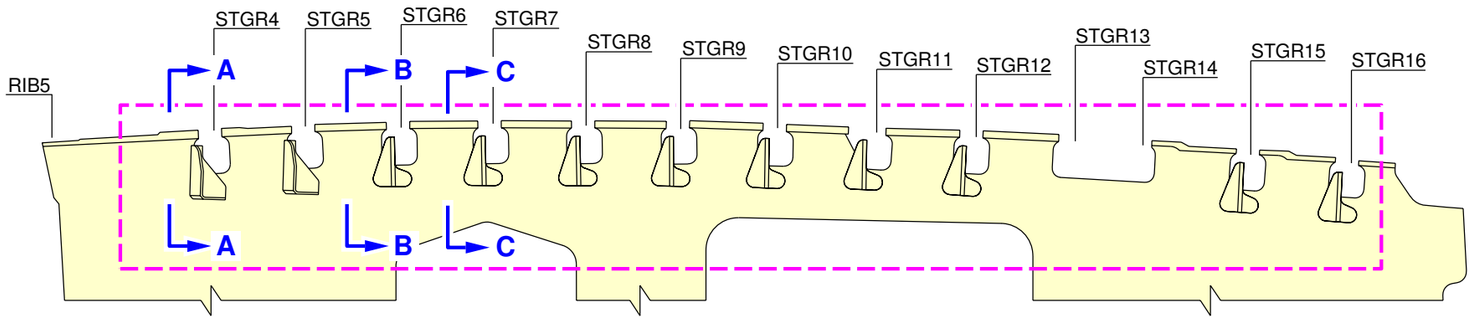
Figure A-USAAC - Sheet 01



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

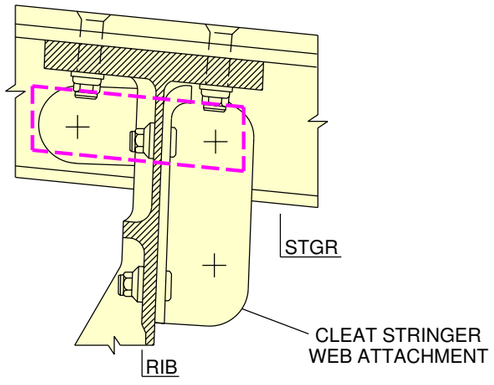
**CONF 005, 009, 011, 015



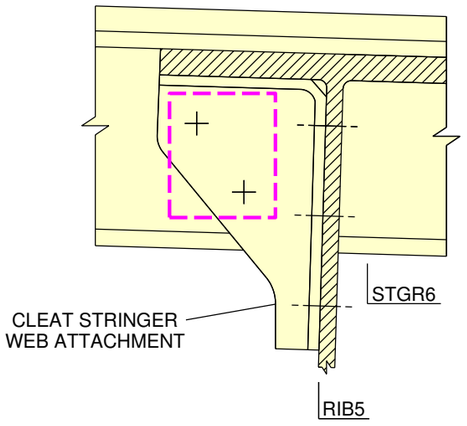

FWD A

VIEW LOOKING INBOARD
UPPER CLEAT ATTACHMENTS SHOWN
RIB 5 SHOWN
RIBS 2, 3, 4, 6 AND 7 SIMILAR



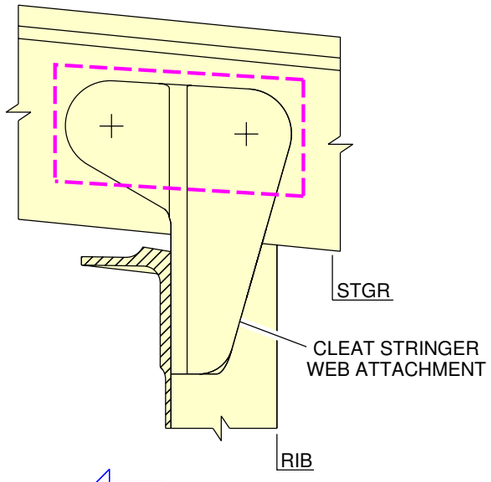

INBD **A - A**

VIEW LOOKING AFT
TYPICAL FOR
RIB 5, STGRS 4 AND 5
AND RIB 6, STGR 5




INBD **B - B**

VIEW LOOKING AFT




INBD **C - C**

VIEW LOOKING AFT
TYPICAL
EXCEPT WHERE SHOWN

| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

MODIFICATION AREA

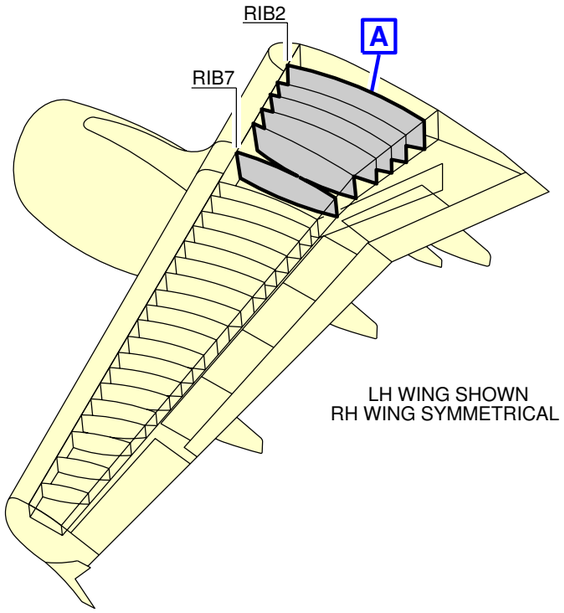
N_SB_571208_7_SAAD_01_04

Figure A-USAAD - Sheet 01

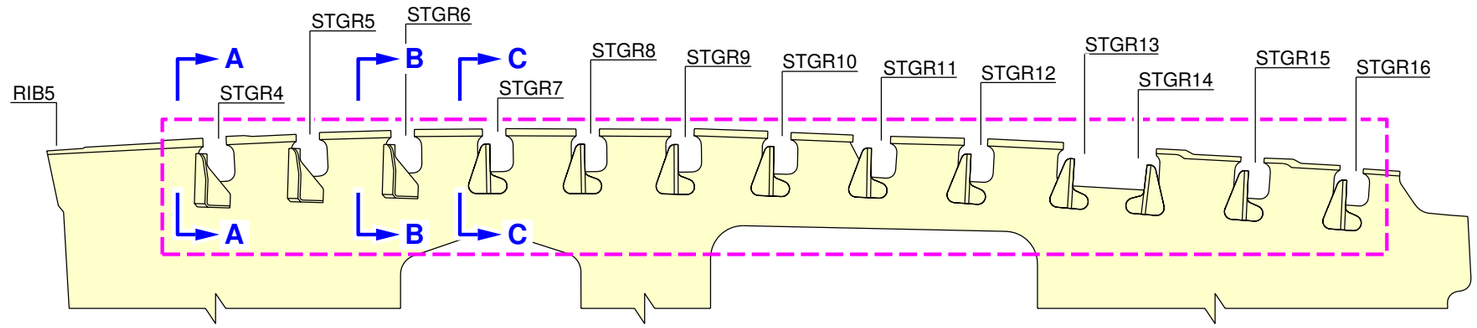


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 001

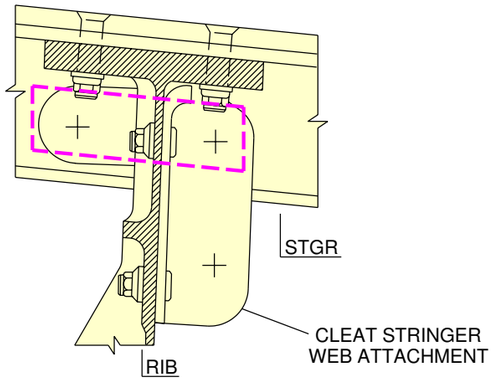



LH WING SHOWN
RH WING SYMMETRICAL



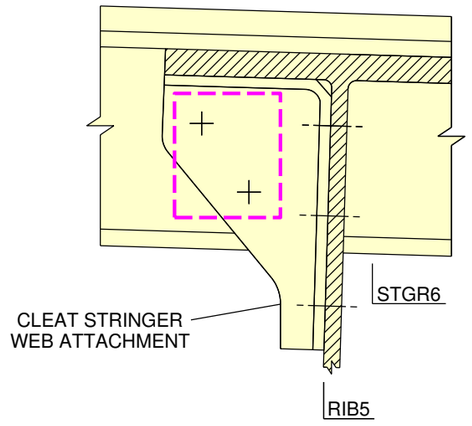

FWD A

VIEW LOOKING INBOARD
UPPER CLEAT ATTACHMENTS SHOWN
RIB 5 SHOWN
RIBS 2, 3, 4, 6 AND 7 SIMILAR



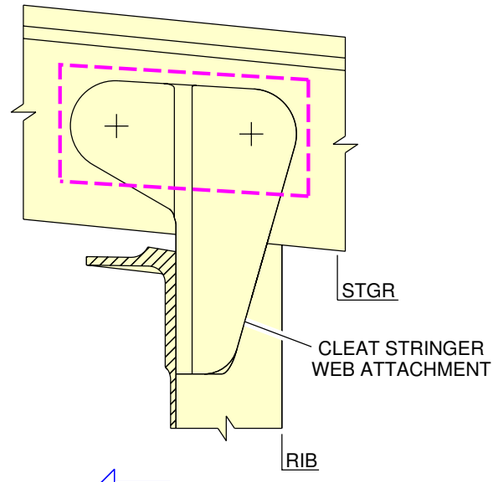

INBD **A - A**

VIEW LOOKING AFT
TYPICAL FOR
RIB 5, STGRS 4 AND 5
AND RIB 6, STGR 5




INBD **B - B**

VIEW LOOKING AFT




INBD **C - C**

VIEW LOOKING AFT
TYPICAL
EXCEPT WHERE SHOWN

| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

MODIFICATION AREA

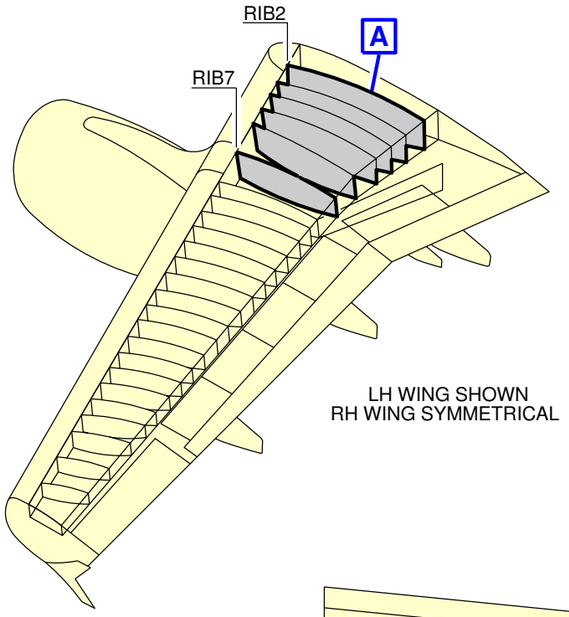
N_SB_571208_7_SAAF_01_03

Figure A-USAAF - Sheet 01

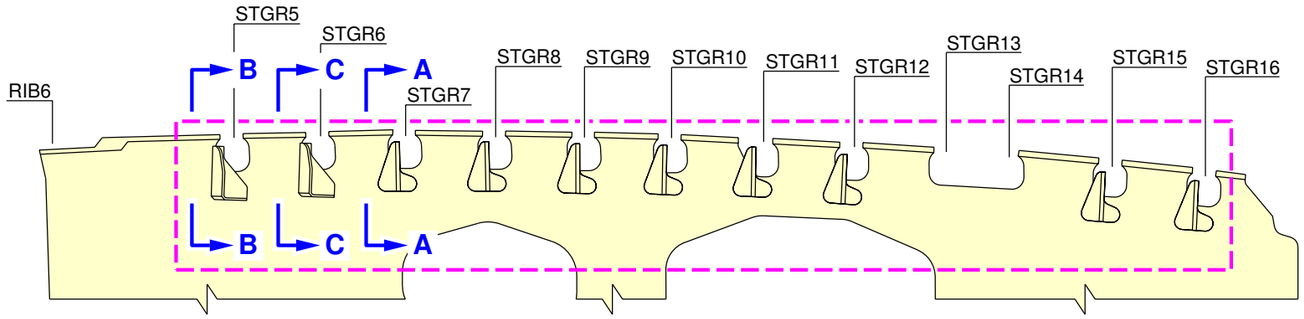


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 002, 006, 016 thru 017

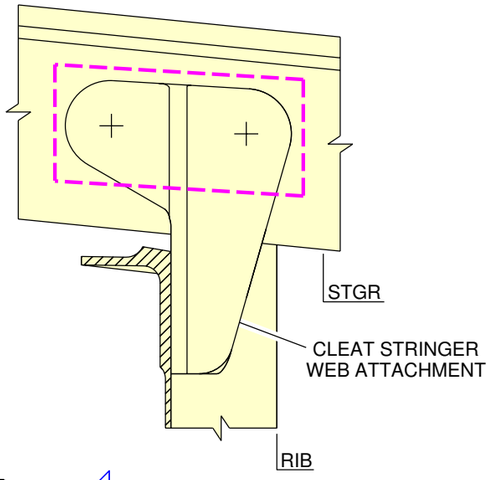



LH WING SHOWN
RH WING SYMMETRICAL



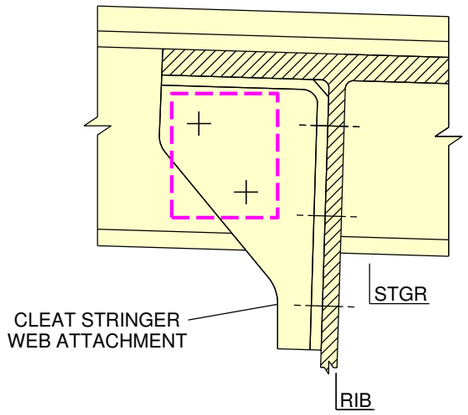

FWD A

VIEW LOOKING INBOARD
UPPER CLEAT ATTACHMENTS SHOWN
RIB 6 SHOWN
RIBS 2, 3, 4, 5 AND 7 SIMILAR



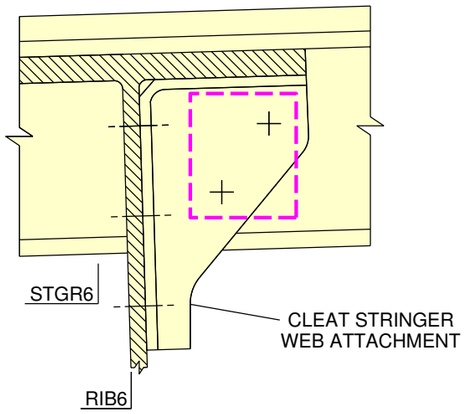

INBD **A - A**

VIEW LOOKING AFT
TYPICAL
EXCEPT WHERE SHOWN




INBD **B-B**

VIEW LOOKING AFT
TYPICAL FOR
RIB 5, STGR 6 AND
RIB 6, STGR 5




INBD **C-C**

VIEW LOOKING AFT

| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

MODIFICATION AREA

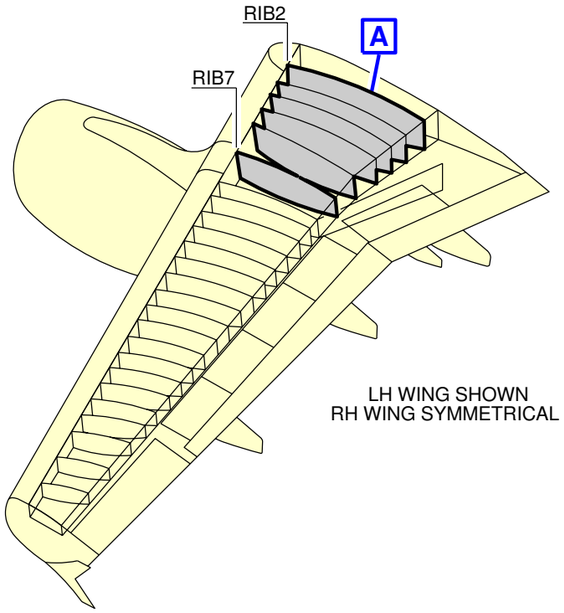
N_SB_571208_7_SBAA_01_01

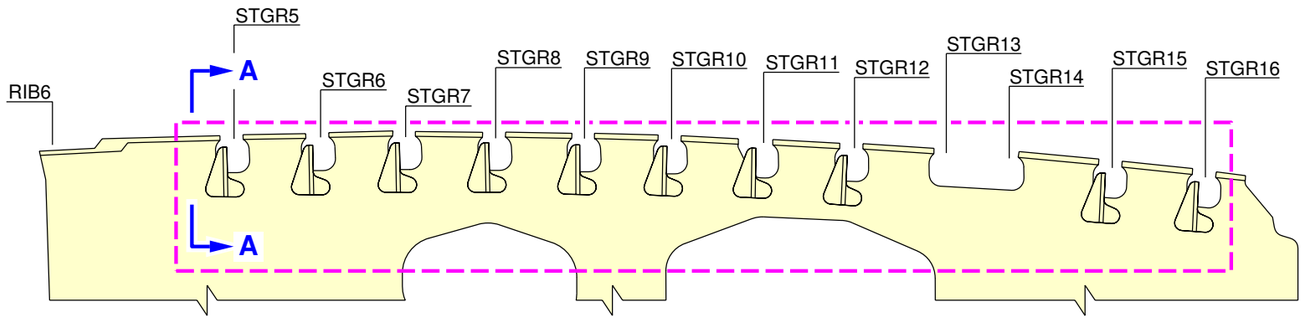
Figure A-USBAA - Sheet 01



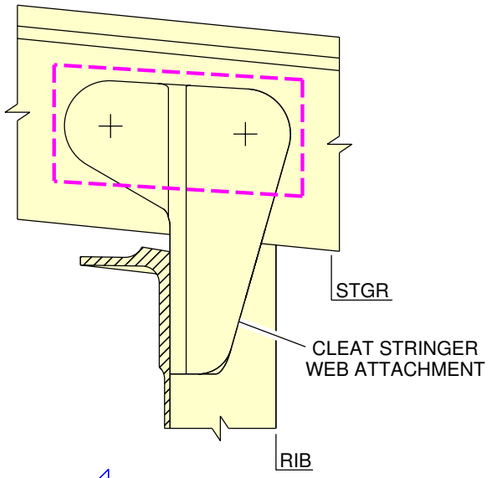
Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 003, 007, 010, 012



VIEW LOOKING INBOARD
UPPER CLEAT ATTACHMENTS SHOWN
RIB 6 SHOWN
RIBS 2, 3, 4, 5 AND 7 SIMILAR



A - A

VIEW LOOKING AFT
TYPICAL FOR
STGRS 5 THRU 12,
15 AND 16

| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

MODIFICATION AREA

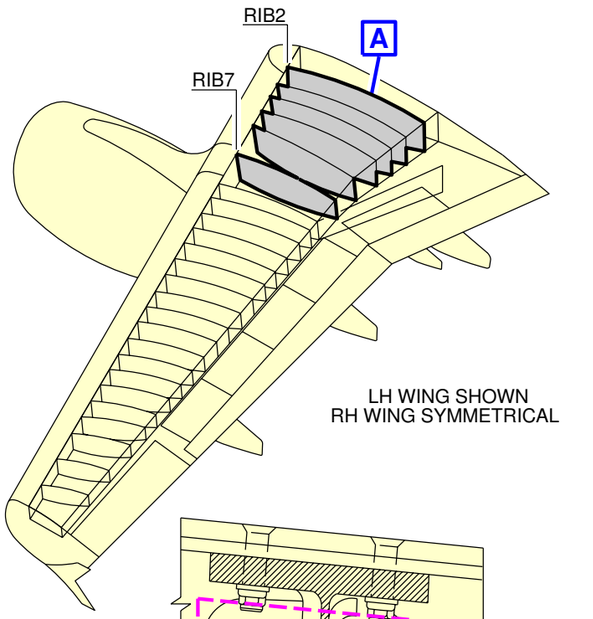
N_SB_571208_7_SBAB_01_00

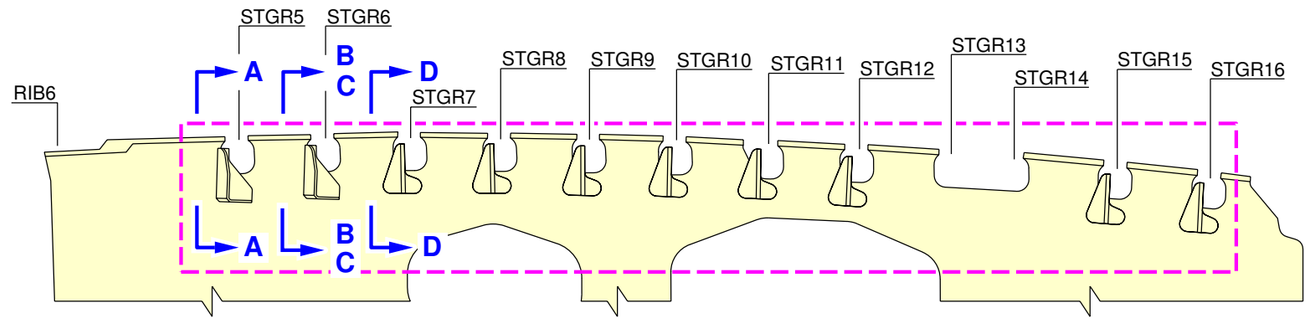
Figure A-USBAB - Sheet 01



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

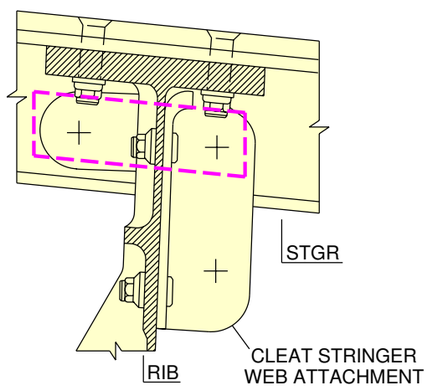
**CONF 004, 008, 013 thru 014



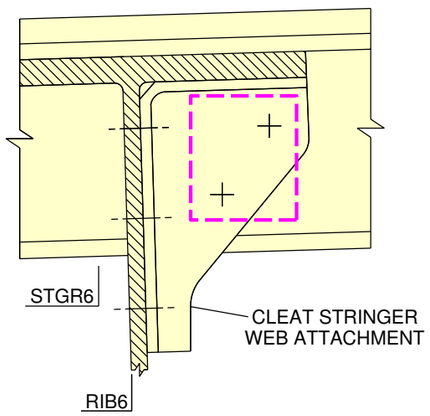

FWD A

VIEW LOOKING INBOARD
UPPER CLEAT ATTACHMENTS SHOWN
RIB 6 SHOWN
RIBS 2, 3, 4, 5 AND 7 SIMILAR



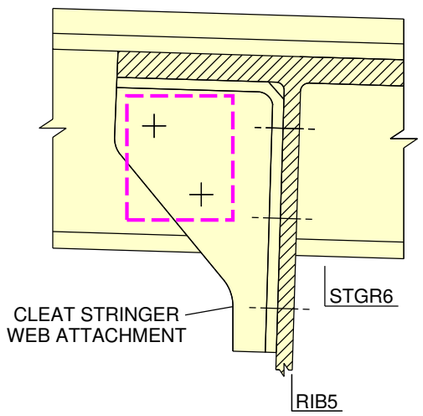

INBD **A - A**

VIEW LOOKING AFT
TYPICAL FOR
RIB 5, STGRS 4 AND 5
RIB 6, STGR 5



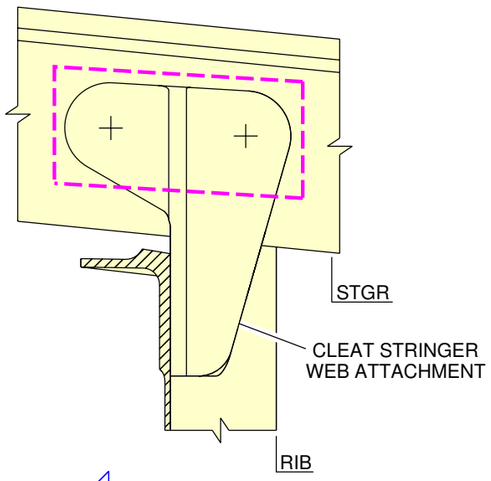

INBD **B-B**

VIEW LOOKING AFT




INBD **C-C**

VIEW LOOKING AFT




INBD **D-D**

VIEW LOOKING AFT
TYPICAL
EXCEPT WHERE SHOWN

| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

MODIFICATION AREA

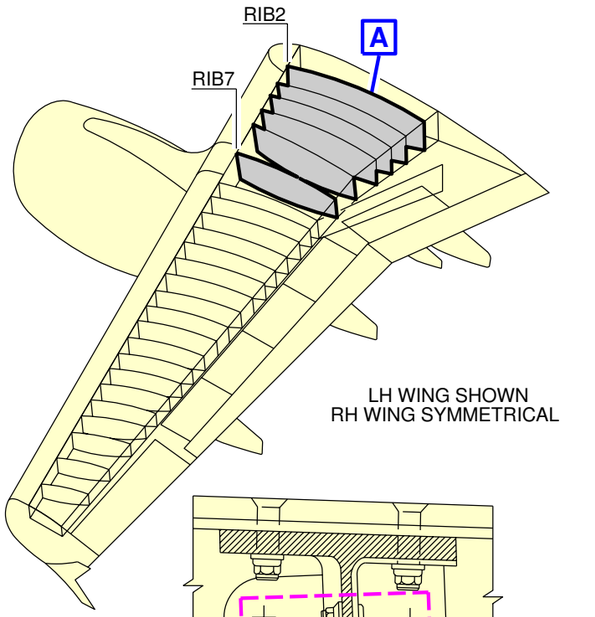
N_SB_571208_7_SBAC_01_01

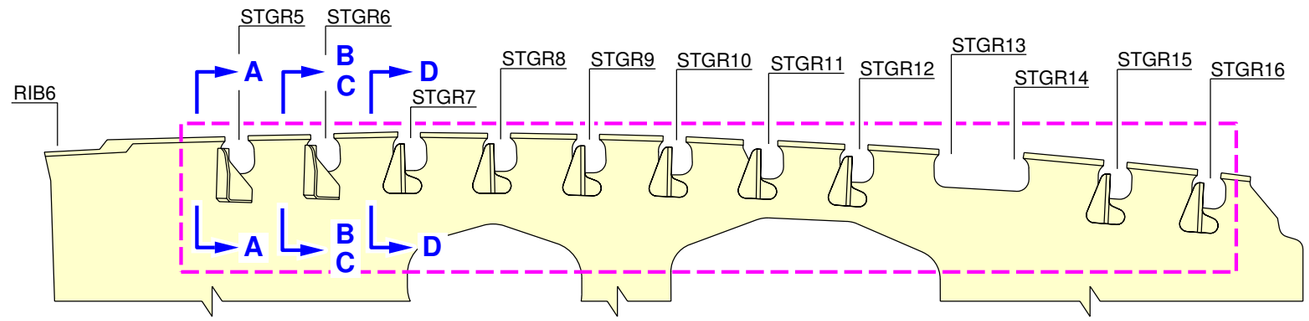
Figure A-USBAC - Sheet 01



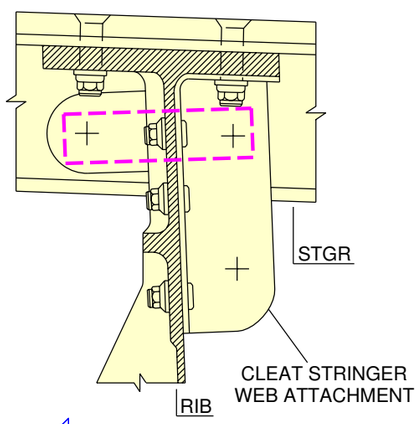
Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 005, 009, 011, 015



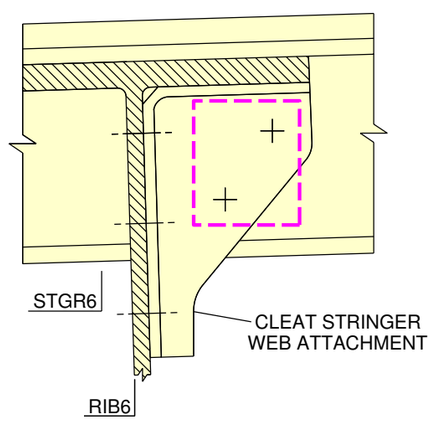



VIEW LOOKING INBOARD
UPPER CLEAT ATTACHMENTS SHOWN
RIB 6 SHOWN
RIBS 2, 3, 4, 5 AND 7 SIMILAR



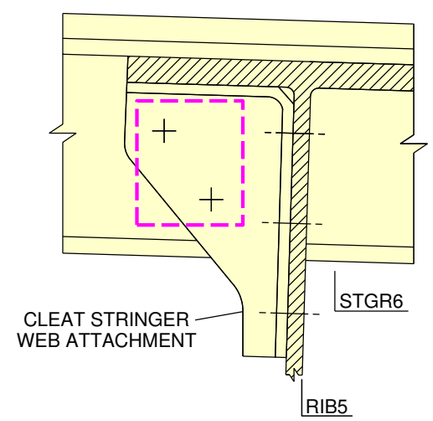

INBD **A - A**

VIEW LOOKING AFT
TYPICAL FOR
RIB 5, STGRS 4 AND 5
RIB 6, STGR 5



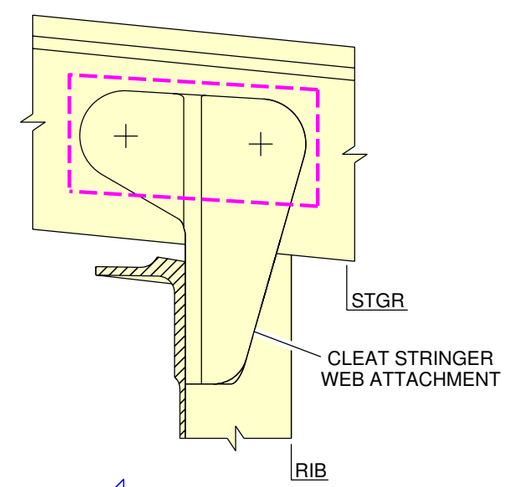

INBD **B-B**

VIEW LOOKING AFT




INBD **C-C**

VIEW LOOKING AFT




INBD **D-D**

VIEW LOOKING AFT
TYPICAL
EXCEPT WHERE SHOWN

| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

MODIFICATION AREA

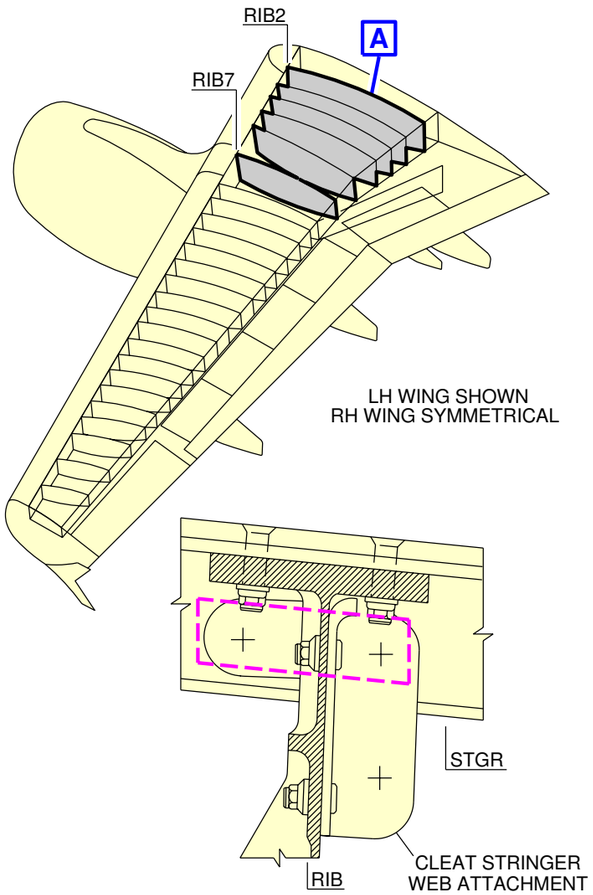
N_SB_571208_7_SBAD_01_01

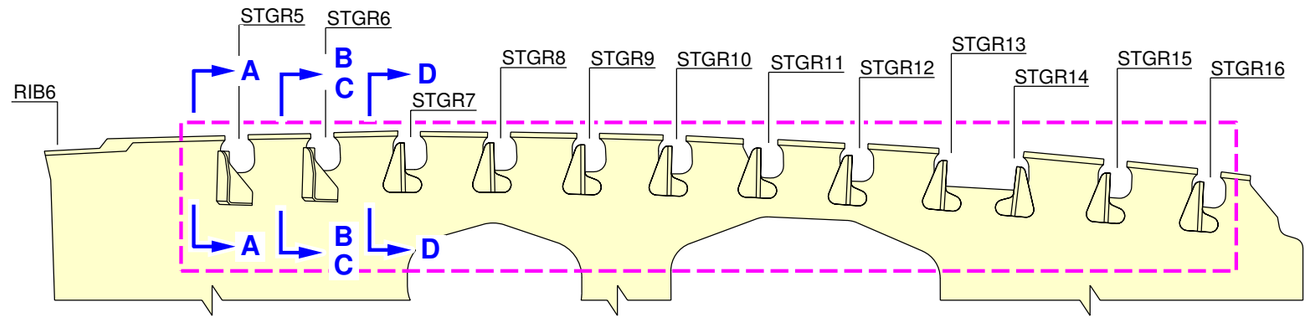
Figure A-USBAD - Sheet 01

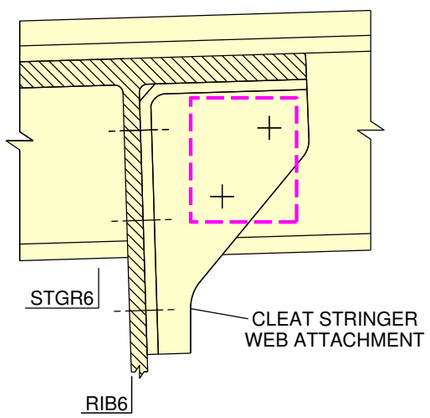


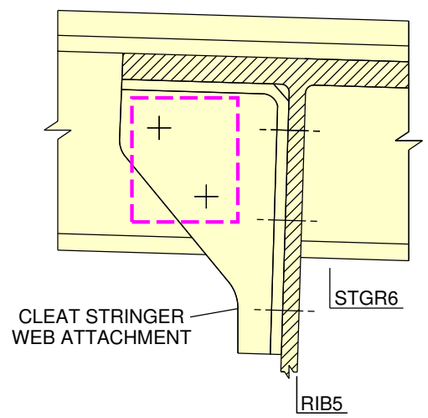
Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

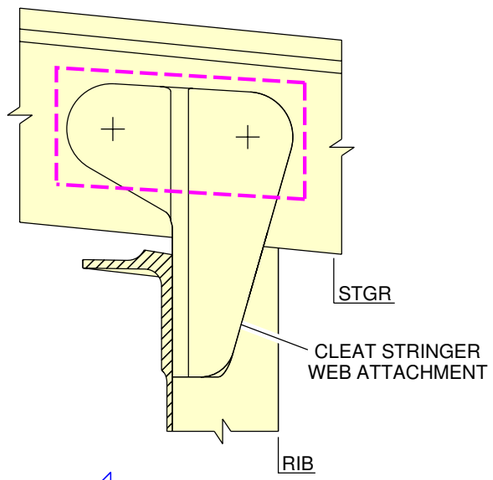
**CONF 001




| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

MODIFICATION AREA

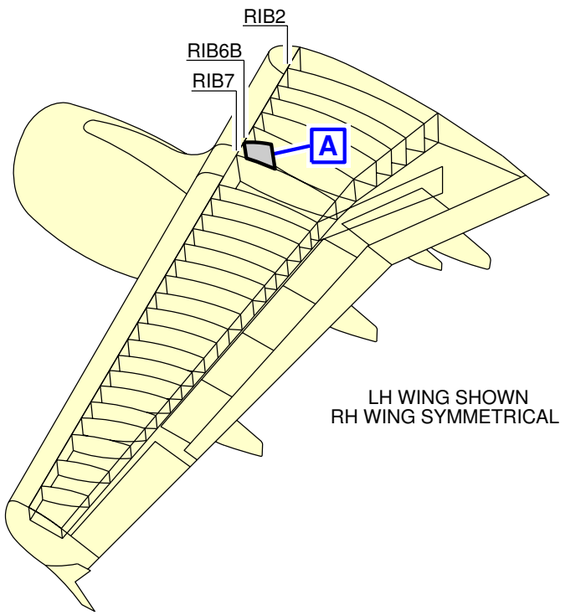
N_SB_571208_7_SBAF_01_01

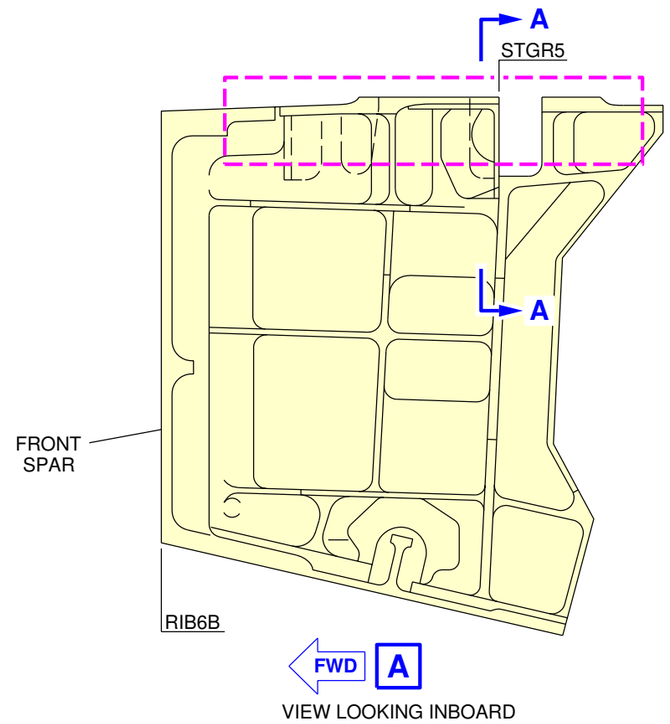
Figure A-USBAF - Sheet 01

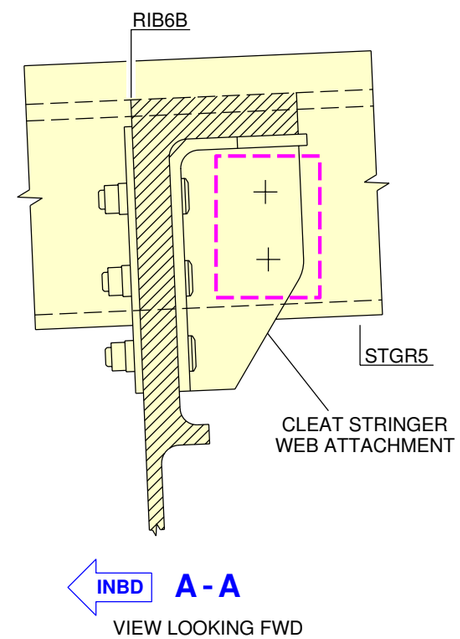


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 001, 004 thru 005, 008 thru 009, 011, 013 thru 015




| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

MODIFICATION AREA

N_SB_571208_7_SCAA_01_00

Figure A-USCAA - Sheet 01



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

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

# MANDATORY MANDATORY MANDATORY

ATA SYSTEM: 57

## TITLE: WINGS - GENERAL - INTRODUCE UPPER CLEAT TO STRINGER ATTACHMENTS AT RIBS 2 - 7. MODIFICATION BY SB DUE TO WFD

MODIFICATION No.: 159478J4359 162156J4442

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

### 1. PLANNING INFORMATION

****CONF ALL**

#### A. EFFECTIVITY

(1) Models

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| 318-111 | 318-112 | 318-121 | 318-122 | 319-111 | 319-112 | 319-113 | 319-114 |
| 319-115 | 319-131 | 319-132 | 319-133 | 320-211 | 320-212 | 320-214 | 320-216 |
| 320-231 | 320-232 | 320-233 | 321-111 | 321-112 | 321-131 | 321-211 | 321-212 |
| 321-213 | 321-231 | 321-232 | | | | | |

(2) Effectivity by MSN

0029 0045-0046 0049-0057 0059 0064-0073 0076-0078 0081-0087 0093-0094 0099
0104 0110-0113 0115-0118 0121-0122 0124-0127 0135 0137-0138 0140-0142
0148-0150 0152-0154 0157 0159-0162 0164-0166 0168-0169 0171-0172 0174-0175
0178 0181-0183 0185 0192 0194-0195 0197-0198 0200-0203 0205-0206 0208-0211
0213 0216-0220 0229-0232 0234 0237 0239 0242-0243 0248-0249 0251-0256
0259-0260 0262-0263 0265 0267-0269 0272-0273 0275-0277 0279 0281-0282
0284-0285 0287 0290-0294 0296-0298 0300-0303 0306-0309 0311-0312 0314
0316-0322 0324-0325 0328-0332 0339-0343 0345-0347 0351 0353-0355 0357-0358
0360-0362 0364 0366-0368 0370-0373 0376 0378 0380-0382 0385-0388 0390 0393
0395 0398-0410 0412 0414-0418 0420-0424 0426-0432 0434-0436 0438-0439
0441-0442 0444-0445 0447-0450 0452 0454 0456-0458 0460 0462-0466 0468 0470



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

0472-0477 0479-0480 0483-0491 0493 0495-0500 0502-0506 0508-0514 0516-0530
0532-0533 0535 0537-0544 0546 0548 0550-0556 0558-0561 0563-0587 0589
0591-0593 0595-0600 0603-0604 0607 0609-0614 0616-0623 0625 0627 0629-0631
0633-0639 0641-0662 0664-0673 0675 0677-0706 0709 0711-0746 0748-0752
0754-0771 0773-0788 0790-0792 0794-0798 0800-0873 0875-0898 0900-0953 0955
0957-0968 0970-0977 0979-1043 1045-1067 1069-1073 1075-1097 1099-1112
1114-1144 1146-1153 1155-1185 1187-1217 1219-1277 1279-1304 1306-1332
1334-1373 1375-1382 1384-1385 1387-1463 1465-1607 1609-1630 1632-1659
1661-1675 1677-1681 1683-1697 1699-1726 1728 1730-1767 1769-1812 1814-1821
1823-1829 1831-1918 1920-1929 1931-1938 1940-1942 1944-1984 1986-1990
1993-2016 2018-2024 2026-2050 2052-2057 2059-2087 2089-2110 2112-2127
2129-2217 2219-2275 2277-2423 2425-2499 2502-2649 2651-2721 2723-2890
2892-2940 2942-3037 3039-3091 3093-3103 3105-3109 3111-3162 3164-3243
3245-3647 3649-3820 3822-4329 4331-4449 4451-4821 4823-6100 6102-6285
6287-6418 6420-6463 6465-6619 6621-6641 6643-6672 6674-6719 6721-6743
6745-6771 6773-6798 6800 6802-6818 6820-6828 6830-6832 6834-6838 6840-6848
6850-6859 6861-6863 6865-6867 6869-6903 6905-6906 6908-6913 6915-6919
6921-6945 6947-6951 6953-6966 6968-6974 6976-7000 7002-7010 7012-7032
7034-7046 7048-7050 7052 7054-7059 7061-7073 7075-7077 7079-7082 7084-7093
7095-7101 7104-7106 7108-7123 7125 7127-7128 7130-7139 7142-7146 7148-7149
7151-7161 7163-7171 7173-7174 7176-7180 7182-7184 7187-7191 7193-7194
7196-7204 7206-7208 7210-7235 7237-7248 7250-7251 7253-7268 7270-7272
7274-7276 7278-7282 7284-7289 7292-7308 7310-7320 7322 7324-7328 7332
7335-7340 7342 7344-7351 7353 7355-7358 7360-7366 7368-7379 7381-7385
7388-7390 7392-7395 7397-7398 7400 7402-7408 7410-7416 7418-7427 7430-7448
7450-7458 7460-7465 7467-7469 7471 7473-7474 7476 7478-7479 7481-7482 7485
7487-7488 7490-7493 7496-7498 7500 7502-7503 7506 7509 7511 7513 7515-7516
7518-7520 7522 7524-7525 7527-7529 7531-7532 7534 7536-7537 7539 7541-7543
7545-7546 7549-7552 7556-7558 7561-7562 7564 7566 7569-7570 7572-7575 7578
7580 7582-7586 7590 7592-7593 7595-7597 7599 7601 7604-7605 7607-7609 7611
7613-7615 7617 7619-7625 7627-7628 7630-7633 7635-7637 7640-7641 7643-7647
7650-7661 7664-7670 7672-7675 7678-7681 7683-7687 7689-7693 7695-7696
7699-7702 7704 7706-7709 7711-7718 7720 7722 7724-7726 7728-7730 7732 7734
7736 7738-7743 7745 7747-7750 7752 7754 7756 7758-7763 7765-7767 7769
7771-7775 7777 7779-7785 7787 7789-7790 7792-7793 7796-7798 7801 7805-7806
7808-7810 7814-7821 7823 7825-7827 7829-7833 7836 7838 7840 7843 7845-7846
7852 7855 7857 7863 7865-7870 7872-7874 7876 7878-7880 7882-7886 7888-7890
7893-7894 7896 7898 7900-7911 7913 7915-7916 7919 7922-7924 7926-7927 7929
7932-7935 7937-7938 7940 7943 7947-7948 7953-7958 7962-7964 7966 7969-7971
7973-7978 7981-7982 7985 7987-7989 7993-7994 7998 8006-8007 8009-8013
8018-8019 8021-8022 8024 8026-8029 8032-8037 8040-8042 8044-8047 8049
8053-8055 8057 8060-8073 8075-8076 8078 8080-8083 8097 8104 8111 8114-8116
8119 8124-8125 8127-8128 8130 8132-8134 8141 8143 8147 8149 8151 8153
8159-8163 8165 8169 8171 8174 8176-8180 8183 8185 8188-8192 8200-8201 8205
8207 8210-8211 8213 8215-8216 8220 8222-8223 8227 8230 8232-8234 8236 8238
8241 8244-8245 8250-8252 8254 8258 8263 8269 8271 8276 8279 8281 8283 8285
8287 8293 8295-8296 8298-8299 8305 8311 8313 8315-8317 8319 8321-8322
8324-8325 8327-8329 8332 8334 8336 8339 8342-8344 8346-8347 8352 8354-8355
8358-8359 8362-8363 8370 8376 8378-8379 8381 8384-8385 8388 8390-8391
8393-8394 8396 8398 8400-8401 8407 8410 8418 8422-8424 8427-8429 8434-8435
8437-8439 8442 8447-8448 8450 8452 8457 8462-8463 8466 8473 8477 8479 8481
8485 8493 8499-8500 8502 8504 8509 8519 8522 8525 8530 8532 8534 8536
8538-8539 8548-8550 8555 8561 8574 8577 8579 8581-8582 8585 8590 8592 8595



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

8597 8599-8600 8604-8606 8611 8614-8616 8625 8632 8634 8640-8641 8644 8646 8651-8652 8657 8659 8663-8664 8667 8670-8673 8676-8677 8680 8694-8697 8709 8713 8716 8724 8730 8734 8746 8748 8763 8765 8778 8784 8786 8791 8797-8798 8808-8810 8812 8822 8824 8835 8838 8841-8842 8845 8847 8853-8854 8856 8858-8859 8871 8879 8891-8892 8902 8911 8914-8916 8925 8931 8942-8943 8947 8950-8951 8960 8964 8974-8975 8986 8994 9009-9010 9020 9025 9027-9028 9033 9037 9043 9052 9057-9058 9066-9067 9081 9104 9122 9125-9126 9128 9130 9176 9185 9279 9292 9304 9313 9319 9329 9360 9409 9448 9485 9538 9588

(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 |
|---|---|
| 02K | 5040 |
| 03Q | 0584 0620 0631 0770 |
| 06R | 0527 |
| 10N | 0734 |
| 11K | 0828 0915 1041 1605 |
| 11S | 4211 |
| 11X | 0115 |
| 13Y | 0371 |
| 14S | 0870 0967 1054 1400 |
| 15S | 1589 |
| 15T | 0764 1494 2910 3164 3261 |
| 16T | 4024 4679 |
| 17M | 3856 5445 |
| 17R | 5768 |
| 17S | 3333 |
| 19R | 0421 0781 |
| 20M | 1429 |
| 20Q | 4842 |
| 23R | 1730 |
| 25P | 0582 0614 |
| 26L | 0625 0637 |
| 27V | 3826 |
| 28M | 0055 |
| 29S | 0291 0292 |
| 31V | 0164 0293 0332 0420 0436 0565 0579 0591 0737 0749 0760 0816 0855 0932 0943 0992 1048 |
| 31X | 4319 |
| 32Q | 1228 1283 2985 3285 |
| 34L | 3604 3865 |
| 36R | 1747 1818 2023 |
| 38W | 1194 |
| 39L | 9037 9122 |



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

| OPERATOR | MSN |
|---|---|
| 39N | 1893 2414 2452 |
| 40N | 0065 |
| 40S | 1973 |
| 41N | 2165 4768 6727 |
| 41S | 0630 |
| 43S | 4650 |
| 45K | 0447 |
| 46L | 0990 1947 1955 3533 3560 |
| 46U | 3275 3296 3332 3674 3734 3986 4053 5900 6032 6749 |
| 47P | 0619 |
| 48L | 2780 |
| 48O | 3362 3412 |
| 48P | 2192 |
| 49O | 0662 |
| 50T | 6168 |
| 53Z | 1468 |
| 56O | 1285 |
| 59Z | 1556 |
| 60U | 0325 |
| 61W | 0112 |
| 66X | 1276 |
| 68M | 0285 0517 0558 0598 0600 0743 1316 1345 2268 2281 4382 |
| 69X | 0219 0300 0328 |
| 72T | 2027 3043 |
| 73W | 0087 |
| 76W | 0140 0157 |
| 78X | 1081 |
| 80X | 2748 |
| 82M | 0925 1934 2771 3077 3157 3390 3585 |
| 82U | 0279 0677 |
| 83O | 0316 |
| 83Q | 0477 0495 |
| 83V | 0739 0908 2236 |
| 84M | 3216 3635 |
| 85T | 0234 |
| 86P | 0913 |
| 86Z | 1368 4891 4913 4941 4942 5193 5278 5754 5841 |
| 87Q | 0052 |
| 89Q | 0142 0835 0891 1017 |
| 91X | 2837 |
| 93M | 9104 9292 |
| 95V | 3379 |
| 95W | 2949 4199 |
| 96O | 0864 1706 1750 |
| 96Q | 5182 |



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

| OPERATOR | MSN |
|---|---|
| 96U | 0883 0914 |
| 98W | 0434 0516 0524 1093 1108 |
| 98X | 0551 |
| 99W | 1141 |
| A1L | 4392 4414 |
| AAF | 2180 3289 4589 4675 4758 4767 6012 |
| AAL | 1980 1997 2012 2019 2198 2209 2836 4127 5327 5678 5698 5704 5745 5753 5761 5781 5786 5788 5789 5798 5810 5827 5834 5842 5860 5884 5895 5904 5932 5938 5946 5955 5975 5983 5991 6020 6040 6046 6063 6070 6085 6094 6150 6154 6162 6222 6227 6238 6252 6256 6263 6271 6272 6277 6310 6313 6334 6346 6349 6384 6393 6401 6407 6429 6437 6456 6472 6473 6482 6491 6495 6520 6532 6552 6595 6621 6644 6647 6650 6656 6667 6687 6711 6723 6745 6761 6783 6790 6802 6812 6828 6840 6866 6887 6908 6909 6928 6940 6956 6973 6983 6998 7009 7013 7034 7046 7069 7079 7085 7131 7154 7157 7188 7301 7307 7310 7336 7349 7407 7419 7500 7509 7515 7519 7525 7539 7541 7564 7566 7613 7617 7636 7651 7700 7732 7756 7775 7876 |
| AAR | 1174 1356 1511 2397 2459 3437 3483 3496 3641 3873 5169 5173 5287 5382 5462 5500 5636 6299 6395 6768 6796 7052 7133 7266 7422 |
| AAV | 1411 2016 2331 2340 |
| AAW | 3224 3236 3615 3657 4004 4203 4489 4521 5414 5448 |
| AAY | 0706 0714 0716 0730 0745 1130 1171 1208 1210 1221 1229 1255 1262 1288 1292 1318 1347 1372 1396 1430 1461 1467 1530 1540 1550 1694 2001 2170 2176 2224 2265 2271 2289 2300 2319 2360 2387 2398 2412 2420 2427 2450 2477 2481 2492 2503 2514 2527 2528 2538 2556 2586 2625 2638 2702 2709 2729 2786 2790 2807 2821 2831 2852 2875 2876 2920 2932 2995 3076 3079 3084 4015 4057 4104 4115 4122 5250 5320 7664 7704 7743 7766 7781 7838 7868 7900 7913 7989 8220 8329 8671 |
| ABL | 1227 1636 1670 1734 1970 2041 2045 2110 2226 2247 2290 2422 2430 2732 2808 2840 2927 2933 2943 3297 3862 4990 5011 7754 7915 7923 |
| ABN | 3142 |
| ABQ | 3974 4393 4394 5891 5943 5966 6016 6067 6119 7171 |
| ABY | 3246 4468 4524 5017 5276 5307 5423 5452 5502 5576 5718 5772 5889 5903 5984 6000 6054 6080 6166 6176 6234 6293 6430 6444 6481 6553 6665 6737 7225 7226 7315 7425 7614 7767 7797 7886 8149 8211 8343 |



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

| OPERATOR | MSN |
|---|---|
| ACA | 0059 0073 0084 0122 0126 0127 0141 0149 0150 0154 0159 0174 0175 0183 0210 0231 0232 0242 0248 0253 0254 0255 0265 0277 0284 0290 0309 0324 0330 0341 0378 0403 0404 0546 0572 0634 0656 0670 0672 0682 0688 0691 0693 0695 0697 0711 0719 0721 0728 0732 0736 0740 0742 0752 0757 0769 0773 0779 0785 0800 0813 0817 0829 0831 0840 0845 1299 1562 1577 1602 1611 1623 1632 1638 1673 1691 1719 1726 1742 1748 1772 1783 1787 1811 1853 1864 1874 1940 1975 2018 2145 3051 3123 3160 3286 3401 3884 5038 5681 5733 6210 6232 6844 6873 6884 6905 7117 7433 7650 8104 8232 |
| ACI | 2152 3547 |
| ADR | 1000 4282 4301 |
| AEE | 1428 1433 1856 1996 2468 2553 2610 2828 3033 3066 3074 3162 3302 3316 3322 3365 3392 3423 3439 3462 3478 3484 3519 3526 3527 3546 3709 3714 3745 3748 3753 3773 3785 3812 3820 3829 3850 3878 3990 4065 4094 4165 6611 6643 6655 6832 6961 6989 7014 |
| AFL | 2106 2116 2133 2144 3511 3545 3574 3699 3711 3778 3786 3835 3923 3954 4058 4074 4116 4133 4160 4453 4498 4579 4625 4649 4656 4684 4692 4712 4835 5044 5059 5421 5536 5565 5572 5578 5580 5585 5614 5720 5755 5790 5873 5881 5913 5921 5967 5970 5974 5982 5989 6017 6022 6043 6044 6060 6071 6090 6678 6726 6756 6817 6945 6954 6963 7037 7038 7071 7072 7084 7137 7193 7202 7215 7240 7255 7275 7279 7295 7300 7561 7593 7645 7646 7653 7667 7678 7749 7782 7801 7806 7836 7843 7846 7863 7878 7902 7932 7934 8067 8073 8133 8147 8188 8201 8205 8234 8276 8319 8363 8378 8418 8452 |
| AFR | 0498 0509 0521 0529 0544 0618 0777 0796 0985 1020 1025 1036 1133 1151 1169 1176 1190 1201 1216 1267 1271 1344 1404 1415 1444 1449 1471 1476 1502 1505 1524 1616 1622 1640 1645 1658 1677 1699 1733 1859 1879 1894 1900 1924 1938 1949 2035 2059 2071 2081 2100 2109 2140 2317 2344 2350 2456 2582 2601 2686 2705 2716 2721 2750 2918 2938 2951 2961 2967 2972 3008 3009 3098 3372 3399 3419 3420 3441 3470 3777 3795 3814 3825 3859 3930 4063 4084 4105 4137 4139 4241 4251 4267 4295 4298 4335 4402 4601 4604 4664 4714 4747 4800 4820 4901 4908 5084 5129 5719 5802 5869 7713 7873 8127 |
| AHY | 0331 2487 2516 2588 2685 2788 2846 2853 2865 2991 3006 6285 |
| AIC | 0045 0046 0049 0050 0051 0056 0057 0398 0416 0423 0431 0432 0486 0490 0499 2593 2624 2629 2907 3130 3146 3212 3271 3288 3300 3305 3326 3340 3344 3367 3498 3551 3557 3573 3619 3620 3687 3752 3792 3822 3874 3918 3955 3970 4002 4009 4020 4029 4052 4078 4089 4096 4121 4138 4155 4164 4201 4212 4236 4237 4280 6446 6690 6715 6724 6803 |
| AIJ | 0169 1132 1162 1179 1244 1259 1308 1322 1780 2048 2227 2539 2930 2964 3021 3044 3149 3304 3312 3374 3508 3514 3631 3644 3667 3690 4235 4304 4411 4730 4733 4924 4933 5163 5221 5358 5372 5653 5665 5867 5878 5933 7238 7264 7311 7345 7348 7358 7784 7792 7833 7879 7903 |
| ALK | 2345 2731 3397 3636 4694 4869 4915 |



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

| OPERATOR | MSN |
|---|---|
| AMC | 2186 2189 2291 2665 3056 3068 5086 |
| AMU | 1790 1850 1912 1926 1962 4197 4317 5352 5459 5523 5600 6324 6517 6693 6827 6912 6934 6938 7497 |
| AMV | 0178 0351 0366 |
| ANA | 0554 0658 0669 0685 7346 7382 7430 7493 |
| ANR | 0671 0765 |
| ANZ | 2090 2112 2130 2148 2153 2257 2297 2445 2533 4553 4584 4884 4926 5629 5682 5847 5962 5993 6182 6460 6471 6533 6694 6706 7086 7362 |
| APJ | 4887 4936 5015 5166 5304 5384 5440 5540 5640 5724 5874 6004 6107 6257 6335 6640 6674 6824 7370 7701 7816 7971 8396 8504 8646 8835 8847 8892 8986 9081 |
| ART | 0533 0566 1762 1823 1873 2211 2216 2233 2342 2903 2912 3191 4461 5271 |
| ARU | 0805 1583 2676 2975 |
| ASA | 2616 2674 2740 2773 2778 2800 2811 2830 2851 2993 3016 3037 3101 3135 3155 3181 3204 3230 3324 3347 3349 3359 3398 3417 3445 3460 3465 3503 3656 3670 3684 3686 4448 4480 4558 4559 4610 4616 4655 4805 4814 4851 4867 4894 4948 4959 4991 4999 5004 5034 5058 5179 5515 6669 6704 6787 6835 6889 6939 6965 7063 7138 7207 |
| ASL | 1140 1159 2032 2277 2296 2335 2587 2621 2645 3252 3317 |
| ASV | 4112 4142 5035 5350 5767 5774 7985 |
| ATR | 0314 0373 |
| AUA | 0552 0570 0581 0768 0776 0797 0920 0935 1137 1150 1189 1385 1387 1458 1478 1504 1553 1678 1735 1931 1937 2009 2131 2174 2262 2416 2494 2547 2652 3234 3268 3295 3482 3502 3515 3532 5122 5181 5299 |
| AUH | 2403 |
| AVA | 2328 2333 2358 2367 2377 2394 2523 2544 2552 2575 3647 3664 3691 3961 3980 3988 3992 4001 4011 4026 4046 4051 4167 4200 4281 4284 4345 4381 4567 4763 4821 4862 4939 5057 5119 5195 5360 5398 5454 5477 5622 5632 5944 6009 6068 6099 6132 6138 6153 6167 6174 6209 6219 6294 6399 6411 6511 6617 6692 6739 6746 6767 6861 6862 7120 7284 7318 7437 |
| AVJ | 0368 0406 |
| AWC | 2564 3708 3749 3830 4039 4701 |
| AWW | 0597 |



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

| OPERATOR | MSN |
|---|---|
| AXM | 0872 2162 2183 2425 2612 2633 2656 2683 2699 2760 2816 2826 2842 2881 2885 2956 2989 3000 3018 3052 3064 3117 3140 3154 3173 3182 3194 3201 3223 3232 3277 3291 3299 3327 3338 3353 3370 3394 3404 3427 3448 3477 3486 3489 3505 3521 3536 3549 3568 3576 3582 3610 3628 3679 3701 3715 3729 3758 3765 3776 3813 3875 3963 3997 4019 4035 4070 4079 4088 4098 4126 4147 4263 4278 4293 4302 4314 4333 4346 4361 4367 4379 4386 4390 4397 4404 4426 4458 4462 4477 4486 4557 4562 4571 4582 4641 4727 4793 4797 4807 4815 4882 4889 4917 4964 4969 4979 4980 4989 5098 5109 5137 5149 5153 5165 5200 5215 5272 5283 5325 5344 5347 5353 5359 5397 5420 5428 5430 5431 5468 5505 5547 5593 5619 5627 5657 5703 5706 5762 5812 5824 5839 5846 5851 5863 5866 5888 5897 5905 5908 5914 5959 6015 6034 6048 6064 6075 6084 6088 6145 6158 6170 6178 6240 6262 6405 6428 6676 6702 6972 7030 7057 7136 7164 7583 7624 7911 7958 7978 8022 8033 8252 8317 8324 8384 8391 8422 8424 8463 8477 8532 8746 8797 8871 9130 |
| AZA | 0513 0514 0526 0576 0583 0586 0593 0599 0819 0848 0940 0951 0959 1138 1168 1217 1220 1226 1448 1457 1473 1480 1489 1722 1740 1745 1770 1779 2033 2057 2074 2083 2086 2101 2127 2869 3115 3343 3563 3598 3609 3643 3666 3695 3732 3815 3846 3885 3906 3921 3956 3976 3978 4075 4108 4119 4143 4152 4195 4249 4520 4523 4536 4759 4764 4859 4875 4910 5018 5130 5294 5383 5424 |
| AZU | 6050 |
| B2V | 0185 |
| BAV | 2568 2934 3004 3010 3050 |
| BAW | 1014 1082 1115 1118 1142 1177 1193 1197 1222 1225 1232 1236 1239 1258 1261 1279 1295 1329 1338 1380 1384 1418 1423 1424 1440 1445 1466 1482 1509 1510 1513 1529 1537 1558 1574 1590 1594 1604 1606 1613 1661 1665 1672 1687 1689 1690 1696 1708 1711 1754 1760 1771 1782 1804 1814 1829 1834 1871 1883 1892 1899 1902 1907 1910 1958 1987 2038 2040 2098 2188 2190 2194 2305 2320 2323 2324 2351 2363 2389 2429 2441 2466 2536 2653 2694 2697 2799 2981 3049 3081 3089 3235 3254 3290 3301 3314 3351 3468 3499 3512 3550 3607 3649 3697 3703 3721 3726 3912 3926 4007 4185 4238 4265 4306 4464 4551 4725 4791 4975 5634 5784 5856 5948 5985 6028 6091 6129 6155 6290 |
| BEC | 3199 5538 |
| BEG | 3139 |
| BEL | 1086 1102 1160 1336 1388 1441 1493 1759 1797 1803 1838 1885 1929 1961 1963 1968 1983 2003 2030 2114 2196 2207 2230 2260 2287 2392 2400 2700 2763 2810 2925 3161 3255 3373 3790 3895 4243 4269 4275 |
| BGF | 3188 |
| BGH | 2457 2844 2863 2987 3125 |
| BJN | 3617 4956 |
| BKP | 2254 2273 2310 2362 2366 2383 2417 2467 2509 2531 2600 2634 2648 2660 2664 2783 3421 3424 3428 3454 3672 3685 3694 3759 3911 |



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

| OPERATOR | MSN |
|---|---|
| BRS | 2263 |
| BSX | 0648 0650 |
| BTK | 6164 6280 6309 6356 6361 6372 6505 6628 6695 6697 6722 6782 6823 6951 6962 6991 7002 7050 7160 7223 7231 7245 7289 7337 7365 7392 7421 7496 7574 7609 7622 7640 7644 7659 7673 7819 7905 8071 8082 8083 8354 8748 8798 8942 |
| BTN | 1551 4204 4254 |
| BUC | 0256 0259 0276 0296 0320 0321 0353 |
| BWJ | 3985 |
| C2C | 5023 5088 5907 |
| CBG | 4970 5260 5266 6096 6204 6215 |
| CBJ | 2557 2561 2611 2644 2733 3520 3548 3561 3578 3580 3638 3842 3851 3914 3958 3982 4388 4410 4412 4428 4440 4471 4483 4505 4513 4529 4540 4580 4602 4677 5008 5072 5114 5185 5216 5331 5471 5630 5656 5722 5848 5997 6041 6198 6206 6212 6229 6426 6480 6580 6664 6730 6759 6763 6769 6818 6853 6863 6913 7076 7144 7173 7191 7220 7288 7948 8045 8062 8223 8241 8336 8450 8534 |
| CCA | 2000 2007 2015 2172 2202 2205 2237 2269 2285 2293 2298 2454 2499 2508 2525 2532 2545 2551 2559 2614 2643 2805 2819 2839 2847 2890 3195 3200 3215 3221 3226 3250 3307 3329 3337 3461 3506 3523 3601 3623 3653 3655 3665 3678 3722 3725 3766 3806 3940 3973 4022 4031 4062 4091 4131 4180 4221 4283 4318 4348 4377 4472 4473 4494 4538 4566 4593 4617 4719 4771 4775 4803 4829 4834 4873 4895 4900 4949 4963 4985 4997 5014 5032 5054 5091 5124 5174 5199 5265 5346 5386 5419 5432 5435 5568 5573 5664 5690 5743 5771 6013 6159 6169 6196 6239 6251 6273 6283 6308 6319 6354 6466 6514 6567 6579 6603 6641 6699 6743 6882 6921 6932 7041 7134 7161 7234 7248 7324 7442 7468 7511 7557 7722 7741 7761 7774 8462 8509 |
| CCM | 1286 3325 3882 3952 5887 5906 |
| CDC | 6026 6055 6065 6157 6600 6648 6671 6679 6714 6764 6789 6805 6847 6941 7025 7027 7070 7178 7258 7542 7643 7657 7773 7916 7938 7954 7975 8011 |
| CEB | 3272 3762 3767 4447 4508 4537 4574 4852 4861 4870 4927 4993 5045 5067 5381 5442 5498 5669 5687 5917 5934 6021 6051 6317 6325 6418 6441 6741 6777 6925 6929 7066 8190 8245 8254 8269 8281 8549 8606 |
| CEF | 2801 3085 |



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

| OPERATOR | MSN |
|---|---|
| CES | 0665 0754 0838 0854 0897 0909 0939 1028 1030 1070 1072 1303 1312 1330 1357 1361 1377 1532 1542 1601 1639 1906 1911 1964 1981 2022 2034 2036 2049 2056 2068 2219 2221 2235 2239 2244 2309 2315 2437 2451 2478 2493 2498 2543 2549 2693 2757 2825 2882 2895 3168 3170 3186 3197 3233 3247 3249 3262 3471 3481 3559 3593 3611 3612 3613 3639 3650 3677 3682 3692 3716 3775 3793 3797 3870 3904 3929 3937 3965 3969 4027 4037 4043 4045 4111 4144 4186 4198 4209 4220 4239 4240 4252 4297 4309 4340 4342 4355 4374 4423 4627 4638 4659 4685 4702 4709 4711 4718 4722 4723 4729 4746 4748 4765 4769 4776 4799 4831 4844 4857 4877 4886 4903 4938 4946 4967 4987 5047 5048 5053 5063 5135 5136 5144 5156 5192 5210 5227 5242 5267 5273 5309 5326 5330 5338 5363 5376 5380 5402 5412 5439 5461 5481 5508 5516 5519 5524 5527 5558 5575 5623 5628 5668 5691 5700 5705 5710 5711 5726 5735 5759 5770 5823 5826 5852 5864 5886 5920 5942 5973 5998 6052 6062 6089 6111 6116 6127 6137 6144 6151 6160 6180 6191 6199 6203 6213 6228 6250 6258 6260 6269 6274 6284 6298 6305 6307 6323 6340 6355 6368 6373 6379 6396 6431 6453 6469 6499 6519 6578 6582 6593 6624 6630 6649 6661 6668 6688 6752 6762 6774 6792 6794 6814 6836 6850 6854 6872 6890 6900 6901 6915 6950 6957 6959 6960 6971 7004 7023 7049 7090 7113 7130 7168 7189 7194 7212 7244 7253 7254 7265 7306 7339 7360 7371 7374 7400 7413 7431 7446 7478 7551 7586 7628 7633 7641 7654 7685 7712 7745 7747 7758 7759 7787 7793 7823 7830 7832 7869 7883 7890 7893 7937 7976 7987 8019 8049 |
| CFG | 0774 0809 0884 0894 0905 0957 0971 5969 6053 6590 7127 |
| CGH | 3768 3849 4522 6142 6302 7356 8035 8053 8116 8132 8179 |
| CHB | 4231 4262 4452 4482 4569 4644 4686 4687 4995 5105 5246 5626 5679 5740 5912 6023 6076 6120 6237 6492 6870 6924 6931 6964 7325 7406 7447 7487 7605 |
| CLH | 0610 0717 0729 |
| CQH | 2939 3014 3023 3747 3819 4072 4093 4168 4244 4331 4366 4373 4375 4499 4586 4738 4750 4760 4809 4816 4909 4978 4983 5022 5051 5108 5378 5403 5434 5446 5466 5562 5778 5816 5911 6073 6117 6216 6218 6220 6231 6318 6329 6358 6403 6410 6452 6497 6524 6591 6765 6786 6815 6826 6846 6858 6874 6881 7016 7099 7122 7159 7219 7282 7308 7338 7385 7408 7556 7582 7619 7670 7740 7748 7935 8010 8057 8060 8313 8352 |
| CQN | 0696 0698 0704 0705 3828 3836 3876 3901 3903 3941 4140 4172 4696 5579 5645 5713 5875 5930 7630 |
| CRK | 5147 5189 5341 5416 5514 5544 6003 6246 6442 6776 7035 7077 |
| CSA | 3094 3406 3436 3452 3660 4713 |



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

| OPERATOR | MSN |
|---|---|
| CSC | 0919 1013 2313 2348 2431 2510 2534 2597 2639 3114 3116 3124 3158 3167 3196 3210 3386 3449 3583 3591 3680 3730 3893 3962 3996 4018 4068 4288 4326 4378 4420 4424 4525 4575 4619 4642 4660 4707 4731 4824 4830 4856 4905 4911 4923 5041 5121 5141 5160 5197 5208 5233 5286 5303 5389 5470 5543 5609 5646 5647 5650 5670 5765 5868 5896 5910 5937 5953 5964 5977 6008 6030 6148 6303 6316 6339 6367 6369 6386 6397 6402 6421 6475 6486 6540 6581 6635 6654 6677 6703 6710 6713 6732 6937 6982 7010 7073 7198 7227 7276 7320 7328 7350 7369 7456 7463 7473 7476 7481 7498 7601 7696 7720 7810 8296 8407 8437 8500 8550 8615 8664 |
| CSN | 0712 0718 0720 0722 0849 0859 0881 0895 0900 0950 0966 1035 1039 1057 1596 1614 1776 1788 1974 1986 1995 2004 2008 2067 2080 2354 2361 2371 2426 2435 2484 2505 2506 2511 2519 2521 2530 2541 2546 2554 2555 2558 2574 2579 2637 2701 2708 2713 2741 2743 2759 2767 2770 2772 2796 2809 2824 2834 2855 2861 2877 2899 2915 2936 2950 2960 2971 2986 3067 3075 3112 3217 3241 3251 3459 3493 3507 3552 3566 3587 3645 3681 3764 3784 3847 3860 3867 3890 3910 3920 3934 3938 3951 3959 3981 3983 3999 4003 4017 4036 4038 4071 4184 4189 4194 4205 4217 4224 4225 4230 4232 4248 4260 4266 4271 4274 4279 4290 4292 4299 4322 4325 4338 4341 4350 4362 4365 4369 4370 4387 4396 4416 4430 4456 4507 4550 4613 4671 4751 4782 4794 4808 4836 4854 4864 4880 4883 4912 4919 4928 4982 5061 5151 5168 5170 5183 5202 5214 5225 5237 5268 5279 5288 5410 5480 5484 5503 5506 5534 5561 5564 5602 5611 5655 5671 5693 5730 5736 5750 5756 5797 5817 5832 5837 5890 5945 5949 5976 6018 6049 6078 6104 6106 6146 6186 6205 6211 6233 6241 6261 6366 6385 6440 6461 6462 6504 6506 6530 6551 6556 6612 6645 6974 6996 7022 7039 7064 7142 7151 7187 7222 7250 7271 7332 7366 7424 7461 7464 7506 7558 7573 7652 7683 7726 7728 7769 7780 7818 7865 7970 8054 |
| CSZ | 2672 2684 2841 2909 2973 2980 3366 3383 3435 3440 3456 3528 3599 3696 3698 3756 3848 3855 3887 3898 3935 3971 4010 4028 4159 4176 4208 4214 4226 4300 4359 4407 4409 4435 4474 4514 4531 4620 4633 4666 4726 4845 4866 4876 4897 4920 4929 4977 4986 5002 5082 5110 5176 5369 5521 5550 5589 5639 5731 5766 5986 6019 6197 6217 6564 6686 6708 6721 6728 6742 6911 6984 7075 7190 7197 7232 7247 7270 7420 7711 7738 7814 7827 7880 |
| CTB | 1381 1402 1416 1437 1954 2142 |
| CTN | 0767 0833 1009 1029 1237 1252 |
| CTV | 0892 1635 2598 2692 3148 3861 4961 5351 5379 5394 5399 5415 5511 5541 5551 5556 5560 5571 5574 5597 5777 5830 6118 6207 6224 6243 6270 6322 6333 6408 6434 6503 6596 6753 6980 7091 7221 7297 7319 7450 7453 7469 7620 |
| CYP | 1091 1129 |



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

| OPERATOR | MSN |
|---|---|
| DAL | 0118 0152 0197 0208 0213 0262 0263 0272 0273 0281 0282 0297 0298 0306 0307 0318 0319 0329 0339 0340 0355 0358 0360 0367 0372 0380 0381 0387 0388 0399 0408 0410 0417 0418 0766 0778 0786 0801 0807 0818 0830 0832 0846 0903 0907 0911 0923 0962 0964 0981 0988 0996 1011 1037 1058 1062 1191 1230 1249 1324 1325 1346 1392 1414 1434 1453 1456 1483 1498 1501 1520 1535 1543 1549 1567 1570 1582 1633 1641 1646 1659 1662 1683 1685 1693 1709 1714 1738 1746 1752 1766 1774 1789 1796 1800 1810 1812 1815 1820 1824 1828 1833 1839 1875 1897 1923 1959 1976 1982 1990 2002 2013 2026 2039 2047 2082 2087 2092 2095 6923 7031 7061 7112 7149 7165 7214 7233 7268 7281 7293 7304 7327 7364 7373 7381 7436 7441 7479 7546 7592 7672 7707 7709 7765 7777 7840 7845 7885 7896 7943 7973 8026 8036 8040 8063 8078 8080 8128 8134 8159 8171 8180 8191 8200 8207 8227 8233 8250 8251 8258 8279 8283 8316 8322 8332 8339 8359 8370 8388 8423 8447 8502 8530 8536 8694 8695 8697 8713 8734 8763 8765 8809 8810 8812 8822 8854 8856 8858 8859 8914 8915 8916 8947 8974 8975 9025 9027 9028 9043 9057 9066 9067 9125 9126 9128 9176 9360 9409 9485 9538 9588 |
| DCS | 3243 4503 |
| DKH | 3368 3485 3596 3605 3967 3984 4064 4102 4154 4276 4401 4429 4573 4587 4652 4833 4840 4981 5013 5070 5071 5131 5226 5329 5339 5455 5491 5674 5737 5876 6172 6221 6315 6392 6433 6435 6477 6542 6627 6637 6701 6808 6843 6855 6879 6916 6944 7065 7116 7169 7199 7208 7229 7303 7322 7445 7492 7607 7752 7820 7882 7926 7955 8055 8582 8585 |
| DLH | 0069 0070 0071 0072 0078 0083 0086 0093 0094 0104 0110 0111 0116 0117 0161 0162 0172 0202 0216 0217 0401 0412 0458 0468 0473 0474 0484 0493 0502 0505 0518 0560 0563 0564 0567 0595 0609 0616 0623 0627 0636 0641 0651 0652 0679 0689 0692 0694 0699 0700 0723 0738 0744 0853 0860 0875 0887 0901 1080 1161 1188 1260 1273 1337 1365 1367 3265 3339 3360 3387 3434 3592 3625 3864 3936 3987 4005 4016 4047 4054 4073 4085 4097 4120 4141 4153 4182 4191 4261 4289 4324 4332 4360 4363 4398 4449 4455 4511 4545 4560 4585 4607 4626 4672 4710 4753 4792 4796 4819 4841 4881 4916 4976 4994 5028 5049 5087 5186 5203 5239 5284 5293 5413 5425 5441 5487 5694 5741 5769 5831 5935 5972 6006 6033 6092 6141 6202 6225 6265 6301 6415 6423 6451 6521 6549 6577 6636 6807 6947 6985 7024 7115 7158 7174 7251 7256 7355 7625 7681 7699 8667 8672 8680 8853 8902 8911 8951 9052 9058 |
| DNU | 0444 0839 0878 |
| DQA | 2347 2599 |
| DRK | 2306 2346 6496 |
| DTR | 0113 |
| EAF | 0308 0424 |
| EDW | 0942 0947 1026 1692 1951 2024 2134 2606 2627 4187 |



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

| OPERATOR | MSN |
|---|---|
| EIN | 0926 1023 1094 1242 1394 1443 2191 2206 2217 2250 2256 2272 2294 2364 2374 2399 2409 2411 2432 2486 2542 2583 2635 3129 3174 3318 3345 3501 3755 3781 3789 3823 3857 4572 4634 4678 4715 |
| ELB | 1615 1637 1703 3705 |
| ERN | 1362 2044 4493 8604 |
| ETD | 2167 3676 3693 3713 3902 4066 4077 4124 4934 5095 5348 5407 5714 5791 5821 5836 5882 5924 6108 6134 6143 6226 6382 6527 6534 6554 6731 6760 6821 6842 |
| ETJ | 0428 |
| EVA | 3886 5261 5328 5354 5377 5485 5792 5808 5849 6024 6042 6087 6179 6276 6312 6488 6545 6585 6653 6707 6747 6935 6999 7054 7101 7317 7344 |
| EVE | 5642 |
| EWE | 1717 1775 2813 3352 3358 4227 4256 4285 4368 4565 4606 4631 4998 5043 5535 6953 6992 7012 7019 7056 7148 |
| EWG | 1769 1852 2591 2749 2833 2867 2976 3011 3080 3121 3128 3172 3178 3193 3213 3328 3375 3422 3464 3504 3516 3534 3540 3594 3700 3728 5457 5467 5497 5525 5557 5569 5601 5635 5658 5941 5978 7087 7121 7210 7216 7259 7261 7263 7377 7393 7394 7398 7412 7439 7513 7534 7545 7615 |
| EZY | 2120 2181 2184 2245 2353 2370 2385 2402 2463 2471 2495 2512 2565 2578 2605 2636 2646 2677 2681 2691 2715 2727 2735 2742 2744 2754 2765 2769 2777 2779 2782 2795 2803 2812 2818 2827 2829 2854 2860 2866 2873 2884 2923 2946 2959 2968 3003 3036 3041 3053 3055 3059 3061 3082 3088 3090 3118 3122 3134 3137 3176 3184 3411 3413 3426 3432 3442 3466 3537 3544 3555 3569 3571 3608 3634 3675 3683 3702 3720 3735 3742 3746 3754 3763 3774 3788 3799 3805 3808 3810 3824 3843 3844 3845 3854 3871 3888 3909 3913 3922 3945 3946 3953 3975 3979 3991 3995 4006 4012 4013 4014 4033 4034 4040 4048 4056 4069 4076 4080 4087 4125 4129 4132 4157 4179 4196 4219 4233 4234 4250 4286 4313 4316 4327 4380 4385 4418 4425 4427 4437 4444 4451 4554 4556 4581 4588 4591 4594 4624 4635 4636 4640 4646 4667 4676 4680 4693 4705 4708 4717 4721 4740 4744 4749 4778 4781 4785 4787 4837 5019 5020 5046 5052 5056 5064 5104 5111 5113 5116 5138 5146 5150 5187 5201 5224 5236 5249 5289 5318 5319 5522 5542 5592 5638 5648 5688 5702 5739 5757 5785 5927 5981 6011 6047 6095 6177 6188 6192 6267 6353 6412 6416 6485 6502 6509 6525 6541 6546 6550 6562 6565 6568 6572 6587 6605 6606 6633 6651 6675 6680 6754 6788 6831 6834 6837 6856 6877 6885 6892 6902 6918 6927 6966 6970 6977 6981 7040 7044 7067 7093 7104 7132 7177 7183 7228 7235 7243 7340 7372 7410 7460 7490 7537 7549 7572 7580 7597 7632 7637 7660 7665 7687 7693 7730 7750 7762 7772 7779 7785 7904 8065 8068 8075 8119 8162 8165 8263 8299 8321 8344 8358 8381 8385 8390 |



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

| OPERATOR | MSN |
|---|---|
| F2I | 0082 0085 0099 0121 0125 0138 0148 0153 0160 0168 0203 0206 0220 0230 0237 0239 0243 0249 0251 0252 0287 0294 0301 0317 0347 0386 0409 0422 0441 0449 0460 0488 0491 0496 0497 0532 0535 0538 0540 0542 0555 0573 0642 0653 0657 0667 0684 0724 0731 0758 0787 0823 0877 0946 0949 0970 0976 0995 1007 1010 1012 1018 1053 1256 1320 1339 1413 1515 1541 1612 1625 1634 1654 1679 1715 1753 1758 1806 1846 1916 2010 2091 2103 2137 2308 2396 2666 2791 3175 3253 3279 |
| FAD | 7829 7867 7901 7910 8013 8213 8230 8285 8634 8652 8673 |
| FBS | 1808 1925 |
| FFT | 1781 2406 2448 2483 2518 2695 2857 3205 3389 3431 4253 4272 4307 4668 4688 4704 4745 5526 5581 5661 6184 6773 6793 6825 6838 6845 6891 6926 7042 7095 7097 7179 7184 7204 7272 7286 7294 7313 7389 7458 7524 7536 7575 7736 7852 7884 8579 8640 |
| FHM | 3025 |
| FHY | 2524 2922 3012 3852 3891 4207 4658 5096 5673 |
| FIA | 1618 3524 3543 3577 3581 |
| FIN | 0941 0961 1073 1107 1184 1185 1241 1309 1352 1364 1405 1470 1544 1588 1712 1913 1978 1989 2065 2124 2146 2154 2208 2266 5758 5803 5922 5961 6083 7552 7570 7611 7661 7981 8041 8069 8401 |
| FLI | 3905 5079 7465 |
| FOO | 1966 6454 6629 6719 |
| FRN | 0647 0660 |
| G4I | 1157 1795 2507 |
| G8E | 0068 1213 2141 2147 2718 6103 |
| GAF | 1212 1214 3897 4060 |
| GAP | 3087 3187 3273 3310 3455 3553 3652 3731 4777 4984 5007 5012 5103 5310 6201 6253 6539 6573 6623 7285 |
| GBB | 0053 0054 0064 0067 0076 0077 0081 |
| GCR | 2338 2475 4600 4739 4825 5006 5117 5264 5760 5799 5835 5850 5853 5894 5928 5971 6348 6449 6570 6820 6851 6898 6919 7068 7363 7783 7909 7922 7974 |
| GFA | 4030 4059 4083 4146 4158 4188 4218 4255 4502 4541 4780 4827 4860 4865 5025 5074 5171 5175 5180 5257 5321 5336 |
| GJT | 0415 0928 1087 2029 2077 2118 3950 4663 4691 |
| GLG | 1882 2078 3408 3467 3518 4100 4487 4547 4599 4789 |
| GMI | 1886 3019 3407 3892 4258 4268 |
| GOW | 3306 3597 3616 3900 3915 3972 5016 5112 5232 5463 5552 5675 5809 5811 5990 6072 |
| GSH | 1599 |
| GSW | 3024 3589 3818 |
| GWI | 0135 0137 0200 0201 0209 0218 0267 0268 0269 0346 0382 0646 0654 0794 1016 1077 1084 1089 1136 1147 1155 1170 1172 1209 1277 1889 2562 2607 2628 2632 3093 3202 3245 3415 3447 3500 3661 3839 3841 3908 4161 4166 4329 |
| GWR | 0876 1296 1349 |
| GZQ | 1878 |



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

| OPERATOR | MSN |
|---|---|
| HDA | 0633 0756 0784 0812 0930 0993 1024 1253 1695 1721 1984 2021 2229 2238 2428 3369 3669 4023 4247 5024 5030 5362 5429 |
| HES | 0811 |
| HFM | 2662 3689 5085 |
| HFY | 1004 |
| HIM | 6626 7503 7604 |
| HKE | 2299 2322 2717 4181 4445 5685 5725 5738 7403 7596 7729 7821 7831 7872 7929 7969 8163 8347 8410 |
| HKJ | 2706 3073 4878 |
| HVN | 2255 2261 2267 2303 2480 3315 3355 3600 3737 3964 3966 4136 4213 4277 4311 4315 4669 4703 4737 4783 4826 4863 4945 4971 5164 5241 5247 5251 5275 5297 5306 5340 5385 5392 5418 5427 5438 5456 5469 5495 5555 5699 5709 5916 5958 5994 6266 6344 6748 6810 6880 |
| HXA | 7805 7889 7906 8435 8522 8590 8663 8778 8808 8931 9009 |
| I2L | 0519 0556 0668 1497 |
| IAW | 4044 4067 |
| IBE | 0938 0998 1021 1027 1516 1572 1655 1674 1681 1716 1793 1809 1836 2220 2225 2242 2248 2264 2311 2365 2391 2472 2736 2756 2843 2889 2996 3209 3320 3380 3443 3651 3744 5486 5570 5692 6244 6328 |
| IBS | 1047 1059 1067 1099 1101 1119 1125 1198 1439 1450 1736 2104 2143 2357 2381 2488 2563 3278 3293 5501 5590 5729 5815 |
| IGO | 1767 1920 1957 2097 2108 2121 2135 2138 2139 2195 2204 2275 2334 2359 2388 2405 2443 2482 2584 2609 2626 2649 2670 2712 2737 2804 2908 2914 3071 3138 3264 3308 3330 3357 3414 3453 3457 3497 3541 3618 3750 3782 3863 3943 4008 4113 4156 4216 4294 4312 4328 4384 4399 4433 4438 4481 4488 4491 4506 4510 4518 4532 4535 4552 4603 4609 4614 4630 4637 4645 4752 4757 4762 4813 4818 4868 4888 4947 4954 4965 5027 5036 5076 5080 5090 5092 5094 5120 5155 5158 5190 5218 5230 5231 5259 5262 5291 5298 5313 5365 5411 5437 5460 5473 5476 5507 5537 5577 5641 5676 5683 5712 5727 5744 5807 5829 5893 5898 5923 5952 5992 6010 6036 6208 6247 6275 6287 6289 6336 |
| IND | 0343 |
| IRA | 0303 0312 0345 0575 0857 2054 7418 |
| IRB | 0393 |
| IRC | 0354 0376 0414 0430 0476 0480 |
| IRM | 0550 |
| ISR | 2728 4354 4413 7110 |
| IYE | 2102 4653 4690 |
| IZG | 0311 0395 0400 0407 0426 0644 0937 0999 1977 2055 |
| JAD | 0537 |
| JAT | 7502 7595 7691 8006 8028 8493 8539 8730 |
| JAV | 0029 2061 |



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

| OPERATOR | MSN |
|---|---|
| JBU | 1123 1156 1173 1235 1240 1257 1270 1280 1302 1327 1398 1446 1452 1506 1528 1546 1557 1610 1650 1705 1739 1784 1785 1849 1861 1898 1904 1915 1917 1927 1948 2006 2020 2031 2042 2063 2075 2099 2125 2132 2136 2149 2150 2159 2160 2177 2201 2215 2231 2246 2259 2280 2284 2286 2307 2314 2336 2352 2368 2384 2386 2415 2447 2449 2461 2489 2491 2504 2520 2535 2577 2580 2640 2647 2671 2710 2725 2755 2781 2802 2814 2832 2848 2871 2880 2900 2945 2970 2977 2992 3029 3039 3072 3091 3119 3150 3190 3228 3263 3287 3348 3381 3416 3451 3479 3488 3517 3554 3572 3622 3659 3707 3724 3760 3800 3811 4578 4612 4647 4904 5060 5142 5148 5302 5312 5349 5417 5677 5723 5782 5783 5854 5865 5909 5960 6031 6130 6185 6245 6279 6326 6359 6390 6425 6448 6512 6560 6575 6609 6663 6725 6757 6791 6809 6859 6903 6930 6988 7018 7230 7257 7305 7353 7390 7415 7448 7455 7520 7529 7584 7627 7631 7692 7739 7798 7815 7855 7874 7907 7924 7956 7993 7994 8143 8178 8185 8293 8342 8473 8525 8538 8581 8641 |
| JBW | 0445 |
| JCC | 4128 7224 7312 7404 7474 |
| JES | 8574 8599 8838 |
| JJP | 5093 5145 5161 5245 5274 5281 5355 5492 5499 5520 5598 5618 5649 5695 5701 5717 5732 5796 5877 5885 5940 6296 6381 8429 8842 |
| JOC | 1153 2496 3614 |
| JSA | 2316 2356 2453 2604 4443 4515 4772 4786 4872 4914 5305 5323 5390 5433 5472 5708 5813 6136 |
| JST | 1195 1408 2169 2185 2197 2292 2329 2423 2526 2537 2573 2608 2642 2651 2703 2766 2787 3474 3495 3668 3717 3783 3899 3916 3917 3948 4177 4178 4229 4245 4257 4303 4343 4356 4434 4460 4466 4495 4497 4527 4899 4922 5039 5211 5270 5311 5334 5482 5489 5532 5566 5631 5775 5780 5814 5858 5871 6362 7384 7438 |
| JZR | 3919 3939 4092 4162 4376 5033 5625 5833 6124 |
| KAC | 0181 0182 0195 2046 3957 4135 4349 4357 6350 6375 6458 6476 6500 6516 6538 |
| KAY | 3046 3363 4470 5963 |
| KHV | 5343 7434 7435 |
| KIS | 2957 2965 |
| KKK | 0675 0761 0806 0963 1008 1124 1438 1451 1503 1624 1950 1953 5115 5290 5464 |
| KME | 2806 3853 3872 8925 |
| KNE | 1866 1872 1942 1965 2171 2182 2199 2569 2776 3218 3238 3256 3356 3361 3396 3425 3475 3530 3787 3802 3809 3817 3868 3889 3894 3933 4055 4061 4699 4735 5716 |
| KZR | 1042 1204 3141 5357 5401 5404 5613 5734 5870 5968 6029 6037 |
| LAA | 4405 4490 4526 5373 5405 5494 |



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

| OPERATOR | MSN |
|---|---|
| LAN | 1304 1332 1351 1355 1491 1512 1526 1548 1568 1854 1858 1877 1903 2089 2096 2295 2304 2321 2572 2585 2845 2858 2864 2872 2886 2892 2894 3280 3319 3535 3556 3663 3671 3770 3772 3779 4383 4400 4439 4476 4509 4516 4543 4546 4549 4576 4597 4598 4605 4657 4697 4839 4871 4892 4896 4921 4943 4972 5005 5097 5125 5178 5213 5229 5234 5263 5316 5324 5364 5408 5443 5453 5483 5493 5548 5554 5583 5586 5654 5666 5686 5707 5748 5764 5801 5818 5859 5929 5965 6135 6183 6364 6398 6406 6484 6698 6780 6797 6894 6899 7036 7119 7128 7176 7239 7260 7287 7298 7379 |
| LAO | 4596 4639 5356 5396 |
| LBT | 1121 1175 1597 1744 2158 3480 3487 3798 3827 4623 |
| LDM | 1566 1988 1994 2161 2288 2502 2522 2838 2859 2928 2984 2994 3027 3048 3063 3105 3131 3132 3147 3153 3206 3259 3270 5126 5133 |
| LFO | 0659 |
| LGW | 3704 |
| LKE | 2581 2617 2746 3240 5100 5172 5220 6105 6149 7405 7467 |
| LLM | 1918 1956 1967 1969 1993 2337 2413 2419 2439 2571 2688 |
| LMJ | 1868 |
| LMU | 0852 0977 1561 |
| LUR | 0229 0260 0726 |
| LWA | 2878 2905 2935 2954 |
| LYX | 0973 |
| LZB | 2540 2596 3309 3564 3780 |
| MAC | 4539 4568 4806 4848 5143 5206 6365 6896 6942 7096 |
| MAU | 1592 1936 |
| MEA | 3736 3804 3837 4296 4339 4632 5000 5152 5162 5253 5746 6978 7006 |
| MJF | 4353 |
| MJN | 3723 4117 4795 |
| MKR | 1794 2529 2720 2764 3522 3743 4273 |
| MLD | 0622 0741 0808 1786 2849 |
| MLM | 4622 5478 |
| MMA | 1180 1247 1791 3242 |
| MMM | 3402 |
| MMO | 2768 |
| MRJ | 0530 1202 1300 1353 |
| MSC | 2937 2966 3282 3323 3626 3840 4320 |
| MSR | 0165 0166 0194 0198 0680 0687 0715 0725 2070 2073 2079 2094 |
| MXA | 0275 |
| MYX | 0888 0936 0984 1183 1578 1657 1725 1896 2123 |
| NIA | 2410 2476 2874 3183 3219 3925 4310 |



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

| OPERATOR | MSN |
|---|---|
| NKS | 2433 2470 2473 2485 2490 2560 2567 2603 2622 2673 2679 2698 2704 2711 2723 2797 2893 2898 2929 2942 2963 2978 2983 3007 3017 3026 3165 3393 3395 4206 4264 4270 4305 4321 4403 4422 4431 4548 4592 4595 4902 4951 4996 5029 5042 5132 5159 5370 5387 5458 5517 5624 5672 5804 5861 5880 5954 5999 6082 6193 6300 6304 6327 6331 6345 6370 6383 6424 6436 6463 6487 6507 6566 6586 6616 6672 6736 6770 6804 6867 6897 6994 7008 7021 7045 7058 7062 7106 7135 7156 7246 7296 7395 7462 7522 7635 7656 7668 7679 7690 7724 7734 7825 7857 7870 7908 7957 8012 8018 8021 8047 8114 8115 8141 8160 8176 8376 8400 8434 8611 8614 8632 8659 8696 8824 |
| NMA | 1697 1732 1952 |
| NMB | 3346 3586 5366 5400 |
| NUM | 2421 |
| NVD | 0211 0528 0561 0709 0902 0921 1005 1366 1370 1421 1571 1626 1757 1778 1909 1946 1998 2085 2115 2173 2234 3267 3334 3949 |
| NWK | 2455 2515 |
| NWS | 1219 1233 3034 3106 3120 3458 3575 7674 7686 |
| O8K | 0604 |
| OHY | 0364 0385 0543 0580 0661 0771 0792 0810 0912 0916 0968 0974 2594 2663 3570 |
| OLY | 0666 0983 1015 1060 |
| OMS | 3035 3047 3111 |
| ONE | 3001 3030 3062 3214 3371 3438 3469 3509 3602 3606 3642 4222 4287 4336 6057 6110 6125 6689 6712 6871 6876 |
| ORF | 2566 4992 |
| OTC | 5209 6156 6268 8042 8448 8457 8548 8616 8677 |
| OTF | 1407 1979 2479 2724 |
| OZW | 0429 1922 2906 2952 2982 |
| PAL | 3579 5081 5140 5315 5371 5715 5747 5787 5820 5825 5838 6074 6291 6295 6330 6363 6371 6493 6531 7015 7180 7357 7388 |
| PGT | 3831 4175 5879 5902 5950 5995 6465 6597 6619 6666 7145 7200 |
| PIA | 2155 2212 2274 2719 2758 2789 2926 2944 3031 3060 3097 |
| PIC | 2517 2974 3005 3013 3022 3198 3621 4459 4533 7213 7262 7378 7423 7725 7760 7771 7796 7808 7809 7988 |
| PKZ | 6069 |
| PTI | 1263 1598 |
| QAF | 0927 |
| QDA | 6061 6102 6259 6413 6547 6608 6681 6784 6893 6993 6995 7082 7569 7716 |
| QQE | 1335 3994 4114 4170 5255 |
| QSM | 0607 0611 0617 |
| QTR | 1648 1656 1773 1895 1928 2107 2341 3274 4110 4130 4173 4183 4406 4436 4479 4496 4530 4615 4700 4754 4784 4802 4810 4858 4930 4968 5010 5078 5127 5217 5361 5395 6347 6467 6494 6529 6622 6646 6717 6811 |
| R1T | 1908 6112 9313 |
| RBA | 6771 6816 |



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

| OPERATOR | MSN |
|---|---|
| RBG | 3152 4890 4958 |
| RIH | 0438 |
| RJA | 2497 2762 2774 2913 2953 3803 3832 4670 4817 4853 5099 5128 5177 5367 |
| RJD | 5277 |
| RNA | 6445 6555 |
| ROT | 2931 2955 3220 3225 |
| RSY | 2442 2446 |
| RWZ | 0802 1045 1487 1554 1707 1763 1843 2005 2084 2193 2372 2393 2730 2793 |
| RYL | 2784 3463 |
| RYW | 0569 |
| RZO | 2011 2325 2390 |
| SAA | 2326 2355 2375 2379 2418 2438 2469 5637 5680 5956 6007 6147 6189 6200 6306 6439 6478 |
| SAS | 1587 1619 1642 1675 1798 1807 1817 1848 2817 2850 2856 2883 2888 2911 2958 2990 3086 3159 3192 3227 3231 3292 3335 |
| SAW | 0322 0342 0427 0525 |
| SBI | 1071 1078 1090 1126 1131 1149 1164 1167 1819 1870 2028 2064 2076 2279 2369 2373 2464 2474 2618 2641 2726 3070 3446 3473 3490 3494 3866 3880 4032 4150 5001 5026 5031 5106 5134 5167 5559 5607 5779 5919 6066 6171 6734 |
| SDM | 0649 1200 1379 1488 1560 1630 1743 1761 1805 1841 1851 1863 1876 1890 2093 2151 2163 2179 2241 2465 3065 3179 3627 3640 3794 3942 3998 |
| SDR | 2119 2283 2619 2668 4953 4974 |
| SEK | 0357 |
| SEY | 1944 1945 |
| SFJ | 4555 4720 5102 5393 5512 5652 5773 5862 5931 7414 8334 8466 8964 |
| SFW | 0994 |
| SGQ | 6455 6474 6583 6733 |
| SHJ | 0910 6659 |
| SHU | 2052 2069 2072 2222 2243 3108 3281 3298 3336 3838 |
| SKU | 1523 2129 2214 2249 2251 2378 2380 2436 2460 2548 3171 3331 |
| SLK | 2252 2775 4118 4215 4259 4457 5050 5089 5296 5531 5794 |
| SMC | 3513 |
| SND | 1880 1999 3757 |
| SNG | 4611 4648 5918 |
| SOL | 0302 |
| SSG | 1485 2550 |
| SSV | 0466 0639 0814 2330 |
| SUD | 3040 |



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

| OPERATOR | MSN |
|---|---|
| SVA | 3932 4081 4090 4337 4364 4391 4408 4419 4432 4442 4454 4467 4484 4501 4517 4519 4542 4564 4577 4590 4811 4823 4838 4925 4955 4962 5009 5065 5223 5285 5314 5447 5509 5549 7383 7432 7444 7482 7550 7608 7666 7718 7789 7817 7927 8007 8009 8037 8064 8070 8072 8081 8124 8161 8177 8189 8298 8315 8346 8394 8427 8428 8438 8442 |
| SVR | 0735 0775 0815 0841 0991 1063 1152 1199 1484 1579 1603 1720 1751 1777 1905 1941 2105 2117 2166 2175 2187 2278 2327 2343 2349 2376 2590 2623 2707 2862 2947 2998 3099 3107 3189 3385 3388 3410 3433 3472 3834 4728 5055 7206 7375 |
| SVW | 2592 3100 3133 3542 4169 |
| SWM | 0986 1293 1595 1629 2689 |
| SWR | 0520 0522 0541 0553 0559 0574 0577 0578 0585 0596 0603 0612 0621 0635 0643 0664 0673 0681 0701 0703 0713 0727 0782 0987 1144 4534 4618 4673 5037 5069 5518 5567 7007 |
| SYR | 0886 0918 1032 1076 1085 1117 |
| SZN | 2897 3078 |
| TAE | 0934 1500 2659 |
| TAI | 1066 1334 2282 2301 2339 2434 2444 2687 2917 3042 3057 3103 3113 3248 3276 3378 3418 3510 3538 3869 4906 4944 5068 5219 5238 5243 5280 5333 5406 5840 5936 6002 6190 |
| TAM | 1092 1096 1103 1139 1143 1158 1215 1246 1251 1376 1459 1486 1518 1575 1580 1591 1593 1628 1652 1801 1802 1825 1826 1827 1831 1832 1835 1837 1855 1857 1888 1891 2014 2513 2734 2887 2896 2904 2924 3002 3032 3058 3156 3180 3211 3222 3229 3266 3284 3294 3313 3391 3565 3588 3595 3630 3658 3662 3710 3727 3733 3761 3816 4000 4163 4171 4192 4352 4358 4389 4441 4446 4465 4544 4563 4570 4662 4734 4756 4773 5066 5101 5107 5184 5222 5240 5342 5345 5528 5591 5621 5643 5749 5752 5845 5883 5947 5987 6097 6121 6139 6163 6165 6173 6409 6414 6528 6536 6561 6592 6598 6632 6634 6658 6670 6685 6718 6729 6798 6800 6806 6813 6895 6949 7005 7081 7098 |
| TAP | 0629 0750 0755 0763 0790 0821 0837 0906 0917 0933 0945 0960 0979 0982 1034 1100 1106 1120 1127 1165 1181 1206 1231 1307 1399 1667 1668 1713 1718 1756 1765 1799 1816 2178 2270 2792 2822 2870 3136 3769 3883 4021 4095 4106 4145 4742 |
| TAR | 0124 0205 0370 0390 0402 0511 0869 0880 0958 0975 1187 1479 1700 3096 4344 4689 5204 5474 5610 6338 |
| TBA | 4766 4801 4846 5157 5256 5451 5529 5563 5855 6380 6391 6404 6588 6716 6986 7059 7092 7302 7361 7527 7708 7790 7963 8029 8287 8499 8651 8841 9020 9033 9448 |
| TBJ | 5545 |
| TBZ | 0361 0362 0405 |
| TCI | 2921 |
| TCN | 4334 5843 6005 6432 6459 6501 6639 6979 |
| TCX | 1006 1238 1250 1887 1972 2060 5582 5603 5606 5872 6038 6056 6059 6114 6122 6126 6376 6515 6615 7237 |
| TDR | 0795 1454 |



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

| OPERATOR | MSN |
|---|---|
| TGW | 3801 4210 4421 4469 4561 4608 4812 4879 4918 4931 4973 5073 5188 5194 5228 5335 5375 5426 5449 5496 5596 5605 5662 5697 5721 5805 5915 |
| THD | 5198 5248 5258 5301 5436 5553 5806 5828 5857 5892 5951 5979 6113 6140 6254 6297 6374 6417 6775 6795 |
| THY | 1002 2156 2164 2395 2401 2602 2823 2868 2916 2919 2999 3015 3126 3185 3207 3208 3239 3257 3283 3303 3341 3350 3382 3405 3429 3525 3539 3558 3567 3603 3637 3654 3673 3688 3718 3719 3738 3751 4042 4629 4643 4654 4665 4682 4695 4698 4706 4755 4761 4774 4779 4788 4790 5077 5083 5118 5154 5205 5254 5388 5450 5465 5490 5546 5584 5633 5663 5667 5689 6508 6563 6599 6652 6657 6682 6709 6751 6758 6766 6781 6822 6869 6987 6990 7029 7089 7139 7146 7166 7242 7274 7299 7516 7518 |
| TJS | 3632 |
| TNA | 0746 0791 0822 |
| TSC | 1881 1921 4099 4103 4148 4500 6526 6548 6968 7003 7048 7055 |
| TTW | 4804 4874 6187 6522 6604 6700 6917 6943 7203 7491 7982 |
| U6A | 0171 0192 0733 1723 |
| UAL | 0435 0439 0442 0450 0452 0454 0456 0457 0462 0463 0464 0465 0470 0472 0475 0479 0483 0485 0487 0489 0500 0503 0504 0506 0508 0510 0512 0523 0539 0568 0571 0587 0589 0592 0613 0638 0655 0678 0683 0686 0690 0702 0748 0751 0759 0780 0783 0788 0798 0804 0820 0824 0825 0826 0834 0836 0842 0843 0847 0850 0851 0858 0862 0865 0867 0871 0873 0882 0893 0898 0944 0948 0952 0955 0965 0980 0989 1001 1022 1031 1104 1105 1128 1146 1163 1192 1211 1243 1248 1266 1272 1282 1290 1291 1321 1341 1343 1359 1363 1401 1409 1420 1426 1427 1432 1435 1460 1469 1474 1475 1477 1495 1507 1508 1514 1522 1533 1538 1545 1555 1559 1569 1573 1581 1584 1585 1586 1600 1609 1617 1620 1627 1647 1649 1653 1664 1669 1671 1680 1688 1702 1728 1731 1737 1741 1755 1821 1840 1842 1845 1847 1865 1971 2200 2203 2232 2404 2408 2631 2655 2667 2680 2714 2738 2739 2815 2901 2940 2948 2969 3020 3144 3258 3269 3311 3342 |
| UEA | 2654 2696 2820 2835 3706 4347 4743 4988 5003 5191 5252 5957 6248 6281 6292 6357 6830 6922 7111 7201 7211 7292 7314 7397 7452 7485 7531 7669 7964 7977 8046 8066 8222 8379 8398 8439 8597 8709 8784 8845 9185 9279 9304 9319 9329 |
| UJX | 1390 1663 |
| UKN | 3260 |
| UNA | 4228 4583 4732 |



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

| OPERATOR | MSN |
|---|---|
| USA | 0066 0448 0762 0803 0844 0856 0861 0863 0866 0868 0885 0889 0890 0896 0904 0922 0924 0929 0931 0953 0972 0997 1003 1019 1033 1038 1040 1043 1046 1049 1050 1051 1052 1055 1056 1061 1064 1065 1069 1075 1079 1083 1088 1095 1097 1109 1110 1111 1112 1114 1116 1122 1134 1135 1148 1166 1178 1182 1196 1203 1205 1223 1224 1234 1245 1254 1264 1265 1268 1269 1274 1275 1281 1284 1287 1289 1294 1297 1298 1301 1310 1311 1313 1314 1315 1317 1319 1323 1326 1328 1331 1340 1342 1348 1350 1354 1358 1360 1369 1371 1373 1375 1378 1382 1389 1391 1393 1395 1397 1403 1406 1410 1412 1417 1419 1425 1431 1436 1442 1447 1455 1462 1463 1465 1472 1481 1490 1492 1496 1499 1517 1519 1521 1525 1527 1531 1534 1536 1539 1547 1552 1563 1565 1576 1621 1643 1644 1651 1666 1701 1704 1710 1724 1764 1792 1844 1935 2302 2312 2458 2570 2595 2613 2615 2630 2669 2690 3584 3629 3633 3712 3740 3796 3858 3879 3881 3924 3928 3944 3960 3977 3989 3993 4025 4041 4050 4082 4086 4107 4123 4134 4149 4202 4242 4843 4847 4850 4885 4893 4898 4932 4935 4940 4957 4960 4966 5235 5244 5269 5282 5292 5300 5317 5332 5368 5374 5409 5422 5444 5475 5504 5513 5588 5594 5644 5659 5684 5696 5728 5751 5763 5795 5800 5899 5939 5980 6027 6035 6100 6133 6152 6175 6181 6194 6214 6230 6236 6249 6255 6264 6337 6387 6420 6427 6443 6479 6490 6523 6537 6543 6569 6613 6618 6625 |
| UZB | 4371 4395 4417 4485 4492 4528 4651 4724 4770 4952 8555 |
| VAW | 0879 1422 |
| VIP | 4151 |
| VIV | 2157 2210 2576 2661 2752 6574 6602 6750 6755 6857 6875 6886 6888 6955 7020 7043 7153 7717 8024 8027 |
| VJC | 2745 3646 3739 3791 4049 4190 4193 4415 4475 4504 4512 4907 5295 5742 5822 6025 6242 6341 6378 6457 6498 6584 6696 6738 6779 6852 6878 6936 6958 6997 7143 7167 7170 7241 7278 7342 7427 7454 7655 7658 7675 7684 7689 7888 7894 7898 7919 7933 7940 7953 7962 7998 8032 8034 8061 8076 8153 8215 8393 8577 8592 8605 8670 8676 |
| VKG | 1932 1960 6314 6342 6351 6389 6438 6468 |
| VLG | 1749 1862 1914 1933 2168 2223 2407 2589 2620 2658 2678 2747 2751 2753 2761 2785 2794 2798 2902 2962 2988 3028 3054 3083 3095 3102 3109 3145 3151 3169 3203 3237 3321 3376 3377 3400 3444 3476 3492 3529 3833 3907 4101 4291 4463 4478 4661 4674 4681 4849 4855 4937 5479 5530 5533 5587 5599 5612 5616 5620 5925 6039 6045 6079 6081 6123 6128 6377 6400 6450 6483 6510 6518 6535 6557 6571 6594 6607 6638 6660 6684 6691 6740 6841 6883 6933 7017 7026 7028 7105 7108 7109 7152 7218 7351 7402 7471 7585 7590 7599 7621 7714 8111 8130 8192 8238 8244 |
| VNL | 5844 5901 5926 6282 6320 6422 6447 7080 7411 7426 7543 7966 8125 |
| VOE | 1684 1884 1901 2037 2043 2050 2053 2062 2113 2122 2240 2253 2258 2318 2332 2382 2879 3364 3403 |



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

| OPERATOR | MSN |
|---|---|
| VOI | 2657 2979 2997 3045 3069 3450 3491 3590 3624 4741 4798 4828 4832 4950 5062 5207 5212 5308 5322 5337 5391 5488 5510 5595 5651 5776 5793 5819 5988 5996 6014 6109 6161 6288 6321 6332 6470 6558 6601 6610 6705 6778 6906 6948 6969 7000 7088 7118 7123 7125 7196 7326 7335 7368 7376 7416 7443 7451 7457 |
| VRE | 2066 2126 2213 2228 7742 7866 |
| VTI | 6223 6278 6311 6343 6388 6513 6735 6785 6865 7100 7163 7267 7347 |
| VVC | 1306 1564 1686 1867 3896 3931 8479 8481 8485 8519 8561 8595 8657 8716 8786 8891 8960 8994 9010 |
| WHT | 0548 1607 2440 2675 |
| WOW | 7680 7715 |
| WRC | 0645 0827 1207 1860 1869 2462 2682 |
| WZZ | 3127 3143 3166 3177 3354 3384 3409 3430 3531 3562 3741 3771 3807 3877 3927 3947 3968 4109 4174 4223 4246 4308 4323 4351 4372 4621 4628 4683 4716 4736 5021 5075 5123 5139 5196 5539 5604 5608 5615 5617 5660 6001 6058 6077 6086 6093 6098 6115 6131 6195 6235 6352 6360 6394 6489 6544 6559 6576 6589 6614 6631 6662 6683 6848 6910 6976 7032 7114 7155 7182 7217 7280 7316 7440 7488 7528 7532 7562 7578 7623 7647 7695 7702 7706 7763 7826 7947 8044 8097 8151 8169 8174 8183 8210 8216 8236 8271 8295 8305 8311 8325 8327 8328 8355 8362 8600 8625 8644 8724 8791 8879 8943 8950 |

(4) Configuration by MSN

| MSN | CONFIGURATION |
|---|---|
| 0029 0045 0046 0049 0050 0051 0052 0053 0054 0055 0056 0057 0059 0064 0065 0066 0067 0068 0069 0070 0071 0072 0073 0076 0077 0078 0081 0082 0083 0084 0085 0086 0087 0093 0094 0099 0104 0110 0111 0112 0113 0115 0116 0117 0118 0121 0122 0124 0125 0126 0127 0135 0137 0138 0140 0141 0142 0148 0149 0150 0152 0153 0154 0157 0159 0160 0161 0162 0164 0165 0166 0168 0169 0171 0172 0174 0175 0178 0181 0182 0183 0185 0192 0194 0195 0197 0198 0200 0201 0202 0203 0205 0206 0208 0209 0210 0211 0213 0216 0217 0218 0219 0220 0229 0230 0231 0232 0234 0237 0239 0242 0243 0248 0249 0251 0252 0253 0254 0255 0256 0259 0260 0262 0263 0265 0267 0268 0269 0272 0273 0275 0276 0277 0279 0281 0282 0284 0285 0287 0290 0291 0292 0293 0294 0296 0297 0298 0300 0301 0302 0303 0306 0307 0308 0309 0311 0312 0314 0316 0317 0318 0319 0320 0321 0322 0324 0325 0328 0329 0330 0331 0332 0339 0340 0341 0342 0343 0345 0346 0347 0351 0353 0354 0355 0357 0358 0360 0361 0362 0366 0367 0368 0370 0371 0372 0373 0376 0378 0380 0381 0382 0386 0387 0388 0390 0393 0395 0398 0399 0400 0401 0402 0403 0404 0405 0406 0407 0408 0409 0410 0414 0415 0416 0417 0418 0420 0421 0422 0423 0424 0426 0427 0428 0429 0430 0431 0432 0435 0436 0438 0439 0441 0442 0444 0445 0447 0448 0449 0450 0452 0454 0456 0457 | 001 |



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

| MSN | CONFIGURATION |
|---|---|
| 0364 0385 0412 0434 0458 0468 0473 0474 0477 0484 0488<br>0493 0495 0498 0502 0505 0509 0513 0514 0516 0517 0518<br>0519 0520 0521 0522 0524 0526 0529 0532 0535 0538 0541<br>0544 0550 0552 0555 0560 0563 0564 0567 0570 0576 0581<br>0583 0586 0591 0593 0595 0597 0599 0604 0614 0620 0631<br>0633 0642 0652 0664 0666 0668 0675 0677 0680 0684 0687<br>0692 0699 0715 0725 0731 0746 0761 0765 0771 0777 0781<br>0787 0792 0796 0806 0808 0810 0811 0819 0823 0827 0835<br>0848 0852 0855 0864 0878 0887 0891 0901 0908 0915 0920<br>0926 0935 0940 0941 0959 0961 0963 0968 0970 0974 0983<br>0987 0993 0995 1004 1006 1008 1015 1017 1021 1023 1024<br>1027 1042 1060 1080 1094 1133 1144 1153 1161 1174 1185<br>1188 1195 1202 1204 1207 1214 1220 1227 1238 1241 1250<br>1260 1273 1276 1293 1299 1307 1356 1366 1399 1403 1408<br>1412 1417 1421 1425 1428 1431 1433 1436 1438 1442 1447<br>1451 1455 1458 1462 1465 1472 1476 1481 1492 1496 1499<br>1503 1511 1517 1519 1521 1525 1531 1536 1539 1572 1587<br>1596 1602 1607 1611 1614 1619 1623 1629 1632 1636 1638<br>1642 1651 1658 1666 1670 1675 1681 1690 1691 1695 1701<br>1704 1711 1713 1716 1724 1726 1734 1748 1772 1776 1783<br>1788 1794 1798 1807 1811 1817 1836 1848 1850 1859 1869<br>1878 1881 1887 1921 1926 1928 1932 1946 1950 1953 1960<br>1966 1970 1972 1974 1977 1978 1984 1988 1994 1995 2021<br>2041 2045 2055 2060 2067 2080 2107 2110 2115 2190 2208<br>2211 2216 2220 2226 2234 2247 2255 2261 2267 2270 2290<br>2303 2305 2309 2315 2320 2323 2324 2351 2357 2363 2381<br>2410 2462 2472 2476 2480 2488 2521 2530 2536 2543 2549<br>2553 2563 2599 2610 2653 2682 2687 2713 2736 2741 2756<br>2759 2767 2799 2809 2823 2868 2882 2895 2916 2919 2927<br>2933 2936 2971 2974 2996 2999 3005 3013 3015 3022 3051<br>3067 3075 3081 3098 3112 3126 3130 3146 3198 3207 3212<br>3217 3222 3229 3233 | 008 |



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

| MSN | CONFIGURATION |
|---|---|
| 0460 0462 0463 0464 0465 0466 0470 0472 0475 0476 0479<br>0480 0483 0485 0486 0487 0489 0490 0491 0496 0497 0499<br>0500 0503 0504 0506 0508 0510 0511 0512 0523 0525 0527<br>0528 0530 0533 0537 0539 0540 0542 0543 0546 0548 0551<br>0553 0554 0556 0558 0559 0561 0565 0566 0568 0569 0571<br>0572 0573 0574 0575 0577 0578 0579 0580 0582 0584 0585<br>0587 0589 0592 0596 0598 0600 0603 0607 0609 0610 0611<br>0612 0613 0616 0617 0618 0619 0621 0622 0623 0625 0627<br>0629 0630 0634 0635 0636 0637 0638 0639 0641 0643 0644<br>0645 0646 0647 0648 0650 0651 0653 0654 0655 0656 0657<br>0658 0659 0660 0661 0662 0665 0667 0669 0670 0671 0672<br>0673 0678 0679 0681 0682 0683 0685 0686 0688 0689 0690<br>0691 0693 0694 0695 0696 0697 0698 0700 0701 0702 0703<br>0704 0705 0706 0709 0711 0712 0713 0714 0716 0717 0718<br>0719 0720 0721 0722 0723 0724 0726 0727 0728 0729 0730<br>0732 0733 0734 0736 0737 0738 0739 0740 0741 0742 0743<br>0744 0745 0748 0749 0750 0751 0752 0754 0755 0756 0757<br>0758 0759 0760 0762 0763 0764 0766 0767 0768 0769 0770<br>0773 0774 0776 0778 0779 0780 0782 0783 0784 0785 0786<br>0788 0790 0791 0794 0795 0797 0798 0800 0801 0803 0804<br>0805 0807 0809 0812 0813 0814 0816 0817 0818 0820 0821<br>0822 0824 0825 0826 0828 0829 0830 0831 0832 0833 0834<br>0836 0837 0838 0839 0840 0842 0843 0844 0845 0846 0847<br>0849 0850 0851 0853 0854 0856 0857 0858 0859 0860 0861<br>0862 0863 0865 0866 0867 0868 0869 0870 0871 0872 0873<br>0875 0876 0877 0879 0880 0881 0882 0883 0884 0885 0886<br>0888 0889 0890 0892 0893 0894 0895 0896 0897 0898 0900<br>0902 0903 0904 0905 0906 0907 0909 0910 0911 0912 0913<br>0914 0916 0917 0918 0919 0921 0922 0923 0924 0925 0927<br>0928 0929 0930 0931 0932 0933 0934 0936 0937 0938 0939<br>0942 0943 0944 0945 0946 0947 0948 0949 0950 0951 0952<br>0953 0955 0957 0958 0960 0962 0964 0965 0966 0967 0971<br>0972 0973 0975 0976 0977 0979 0980 0981 0982 0984 0985<br>0986 0988 0989 0990 0992 0994 0996 0997 0998 0999 1000<br>1001 1002 1003 1005 1007 1009 1010 1011 1013 1014 1016<br>1018 1019 1020 1022 1025 1026 1028 1029 1030 1031 1032<br>1033 1034 1035 1036 1037 1038 1039 1040 1041 1043 1046<br>1047 1048 1049 1050 1051 1052 1053 1054 1055 1056 1057<br>1058 1059 1061 1062 1064 1065 1066 1067 1069 1070 1072<br>1073 1075 1076 1077 1079 1081 1082 1083 1084 1085 1086<br>1087 1088 1089 1092 1093 1095 1096 1097 1099 1100 1101<br>1102 1103 1104 1105 1106 1107 1108 1109 1110 1111 1112<br>1114 1115 1116 1117 1118 1119 1120 1121 1122 1123 1124<br>1125 1127 1128 1130 1132 1134 1135 1136 1137 1138 1139<br>1140 1141 1142 1143 1146 1147 1148 1150 1151 1155 1156<br>1157 1158 1159 1160 1162 1163 1165 1166 1168 1169 1170<br>1171 1172 1173 1175 1176 1177 1178 1179 1180 1181 1182<br>1183 1184 1187 1189 1190 1191 1192 1193 1194 1196 1197<br>1198 1201 1203 1205 1206 1208 1209 1210 1211 1212 1213 | 004 |



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

| MSN | CONFIGURATION |
|---|---|
| 1215 1216 1217 1221 1222 1223 1224 1225 1226 1228 1229 | 004 |
| 1230 1231 1232 1234 1235 1236 1237 1239 1240 1242 1243 | |
| 1244 1245 1246 1247 1248 1249 1251 1252 1253 1254 1255 | |
| 1256 1257 1258 1259 1261 1262 1263 1264 1265 1266 1267 | |
| 1268 1269 1270 1271 1272 1274 1275 1277 1279 1280 1281 | |
| 1282 1283 1284 1285 1286 1287 1288 1289 1290 1291 1292 | |
| 1294 1295 1296 1297 1298 1300 1301 1302 1303 1304 1306 | |
| 1308 1309 1310 1311 1312 1313 1314 1315 1316 1317 1318 | |
| 1319 1320 1321 1322 1323 1324 1325 1326 1327 1328 1329 | |
| 1330 1331 1332 1334 1335 1336 1337 1338 1339 1340 1341 | |
| 1342 1343 1344 1345 1346 1347 1348 1349 1350 1351 1352 | |
| 1353 1354 1355 1357 1358 1359 1360 1361 1362 1363 1364 | |
| 1365 1367 1368 1369 1370 1371 1372 1373 1375 1376 1377 | |
| 1378 1380 1381 1382 1384 1385 1387 1388 1389 1390 1391 | |
| 1392 1393 1394 1395 1396 1397 1398 1400 1401 1402 1404 | |
| 1405 1406 1407 1409 1410 1411 1413 1414 1415 1416 1418 | |
| 1419 1420 1422 1423 1424 1426 1427 1429 1430 1432 1434 | |
| 1435 1437 1439 1440 1441 1443 1444 1445 1446 1448 1449 | |
| 1450 1452 1453 1454 1456 1457 1459 1460 1461 1463 1466 | |
| 1467 1468 1469 1470 1471 1473 1474 1475 1477 1478 1479 | |
| 1480 1482 1483 1485 1486 1489 1490 1491 1493 1494 1495 | |
| 1497 1498 1500 1501 1502 1504 1505 1506 1507 1508 1509 | |
| 1510 1512 1513 1514 1515 1516 1518 1520 1522 1523 1524 | |
| 1526 1527 1528 1529 1530 1532 1533 1534 1535 1537 1538 | |
| 1540 1541 1542 1543 1544 1545 1546 1547 1548 1549 1550 | |
| 1551 1552 1553 1555 1556 1557 1558 1559 1561 1562 1563 | |
| 1564 1565 1566 1567 1568 1569 1570 1571 1573 1574 1575 | |
| 1576 1577 1578 1580 1581 1582 1583 1584 1585 1586 1588 | |
| 1589 1590 1591 1592 1593 1594 1595 1597 1598 1599 1600 | |
| 1601 1604 1605 1606 1609 1610 1612 1613 1615 1616 1617 | |
| 1618 1620 1621 1622 1624 1625 1626 1627 1628 1633 1634 | |
| 1635 1637 1639 1640 1641 1643 1644 1645 1646 1647 1648 | |
| 1649 1650 1652 1653 1654 1655 1656 1657 1659 1661 1662 | |
| 1663 1664 1665 1667 1668 1669 1671 1672 1673 1674 1677 | |
| 1678 1679 1680 1683 1684 1685 1686 1687 1688 1689 1692 | |
| 1693 1694 1696 1697 1699 1700 1702 1703 1705 1706 1708 | |
| 1709 1710 1712 1714 1715 1717 1718 1719 1721 1722 1723 | |
| 1725 1728 1730 1731 1732 1733 1735 1736 1737 1738 1739 | |
| 1740 1741 1742 1744 1745 1746 1747 1749 1750 1752 1753 | |
| 1754 1755 1756 1757 1758 1759 1760 1762 1764 1765 1766 | |
| 1767 1769 1770 1771 1773 1774 1775 1778 1779 1780 1781 | |
| 1782 1784 1785 1786 1787 1789 1790 1791 1792 1793 1795 | |
| 1796 1797 1799 1800 1801 1802 1803 1804 1806 1808 1809 | |
| 1810 1812 1814 1815 1816 1818 1820 1821 1823 1824 1825 | |
| 1826 1827 1828 1829 1831 1832 1833 1834 1835 1837 1838 | |
| 1839 1840 1842 1844 1845 1846 1847 1849 1852 1853 1854 | |
| 1855 1856 1857 1858 1860 1861 1862 1864 1865 1866 1867 | |
| 1868 1871 1872 1873 1874 1875 1877 1879 1880 1882 1883 | |
| 1885 1886 1888 1889 1891 1892 1893 1894 1895 1896 1897 | |
| 1898 1899 1900 1902 1903 1904 1906 1907 1908 1909 1910 | |
| 1911 1912 1913 1914 1915 1916 1917 1920 1922 1923 1924 | |



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

| MSN | CONFIGURATION |
|---|---|
| 1925 1927 1929 1931 1933 1934 1935 1936 1937 1938 1940 | 004 |
| 1942 1944 1945 1947 1948 1949 1951 1952 1954 1955 1957 | |
| 1958 1959 1961 1962 1963 1964 1965 1968 1971 1973 1975 | |
| 1976 1979 1980 1981 1982 1983 1986 1987 1989 1990 1996 | |
| 1997 1998 1999 2000 2001 2002 2003 2004 2006 2007 2008 | |
| 2009 2010 2011 2012 2013 2014 2015 2016 2018 2019 2020 | |
| 2022 2023 2024 2026 2027 2029 2030 2031 2032 2033 2034 | |
| 2035 2036 2037 2038 2039 2040 2042 2043 2044 2046 2047 | |
| 2048 2049 2050 2053 2054 2056 2057 2059 2061 2062 2063 | |
| 2065 2066 2068 2070 2071 2073 2074 2075 2077 2078 2079 | |
| 2081 2082 2083 2085 2086 2087 2089 2090 2092 2094 2095 | |
| 2096 2097 2098 2099 2100 2101 2102 2103 2104 2108 2109 | |
| 2112 2113 2114 2118 2119 2120 2121 2122 2123 2124 2125 | |
| 2126 2127 2129 2130 2131 2132 2134 2135 2136 2137 2138 | |
| 2139 2140 2141 2142 2143 2145 2146 2147 2148 2149 2150 | |
| 2152 2153 2154 2155 2156 2157 2158 2159 2160 2161 2162 | |
| 2164 2165 2167 2168 2169 2170 2171 2172 2173 2174 2176 | |
| 2177 2178 2180 2181 2182 2183 2184 2185 2186 2188 2189 | |
| 2191 2192 2194 2195 2196 2197 2198 2199 2200 2201 2202 | |
| 2203 2204 2205 2206 2207 2209 2210 2212 2213 2214 2215 | |
| 2217 2219 2221 2223 2224 2225 2227 2228 2229 2230 2231 | |
| 2232 2235 2236 2237 2238 2239 2240 2242 2244 2245 2246 | |
| 2248 2249 2250 2251 2252 2253 2254 2256 2257 2258 2259 | |
| 2260 2262 2263 2264 2265 2266 2268 2269 2271 2272 2273 | |
| 2274 2275 2277 2280 2281 2282 2283 2284 2285 2286 2287 | |
| 2288 2289 2291 2292 2293 2294 2295 2296 2297 2298 2299 | |
| 2300 2301 2302 2304 2306 2307 2308 2310 2311 2312 2313 | |
| 2314 2316 2317 2318 2319 2321 2322 2325 2326 2328 2329 | |
| 2331 2332 2333 2334 2335 2336 2338 2339 2340 2341 2344 | |
| 2345 2346 2347 2348 2350 2352 2353 2354 2355 2356 2358 | |
| 2359 2360 2361 2362 2364 2365 2366 2367 2368 2370 2371 | |
| 2374 2375 2377 2378 2379 2380 2382 2383 2384 2385 2386 | |
| 2387 2388 2389 2390 2391 2392 2394 2395 2396 2397 2398 | |
| 2399 2400 2401 2402 2403 2404 2405 2406 2407 2408 2409 | |
| 2411 2412 2414 2415 2416 2417 2418 2420 2421 2422 2423 | |
| 2425 2426 2427 2428 2429 2430 2431 2432 2433 2434 2435 | |
| 2436 2437 2438 2440 2441 2443 2444 2445 2447 2448 2449 | |
| 2450 2451 2452 2453 2454 2455 2456 2457 2458 2459 2460 | |
| 2461 2463 2466 2467 2468 2469 2470 2471 2473 2475 2477 | |
| 2478 2479 2481 2482 2483 2484 2485 2486 2487 2489 2490 | |
| 2491 2492 2493 2494 2495 2496 2497 2498 2499 2502 2503 | |
| 2504 2505 2506 2507 2508 2509 2510 2511 2512 2513 2514 | |
| 2515 2516 2517 2518 2519 2520 2522 2523 2524 2525 2526 | |
| 2527 2528 2529 2531 2532 2533 2534 2535 2537 2538 2539 | |
| 2540 2541 2542 2544 2545 2546 2547 2548 2550 2551 2552 | |
| 2554 2555 2556 2557 2558 2559 2560 2561 2562 2564 2565 | |
| 2566 2567 2568 2569 2570 2572 2573 2574 2575 2576 2577 | |
| 2578 2579 2580 2581 2582 2583 2584 2585 2586 2587 2588 | |
| 2589 2591 2592 2593 2594 2595 2596 2597 2598 2600 2601 | |
| 2602 2603 2604 2605 2606 2607 2608 2609 2611 2612 2613 | |
| 2614 2615 2616 2617 2619 2620 2621 2622 2624 2625 2626 | |



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

| MSN | CONFIGURATION |
|---|---|
| 2627 2628 2629 2630 2631 2632 2633 2634 2635 2636 2637<br>2638 2639 2640 2642 2643 2644 2645 2646 2647 2648 2649<br>2651 2652 2654 2655 2656 2657 2658 2659 2660 2661 2662<br>2663 2664 2665 2666 2667 2668 2669 2670 2671 2672 2673<br>2674 2675 2676 2677 2678 2679 2680 2681 2683 2684 2685<br>2686 2689 2690 2691 2692 2693 2694 2695 2696 2697 2698<br>2699 2700 2701 2702 2703 2704 2705 2706 2708 2709 2710<br>2711 2712 2714 2715 2716 2717 2718 2719 2720 2721 2723<br>2724 2725 2727 2728 2729 2731 2732 2733 2734 2735 2737<br>2738 2739 2740 2742 2743 2744 2745 2746 2747 2748 2749<br>2750 2751 2752 2753 2754 2755 2757 2758 2760 2761 2762<br>2763 2764 2765 2766 2768 2769 2770 2771 2772 2773 2774<br>2775 2776 2777 2778 2779 2780 2781 2782 2783 2784 2785<br>2786 2787 2788 2789 2790 2791 2792 2794 2795 2796 2797<br>2798 2800 2801 2802 2803 2804 2805 2806 2807 2808 2810<br>2811 2812 2813 2814 2815 2816 2817 2818 2819 2820 2821<br>2822 2824 2825 2826 2827 2828 2829 2830 2831 2832 2833<br>2834 2836 2837 2839 2841 2843 2845 2847 2849 2850 2852<br>2854 2857 2858 2860 2864 | 004 |
| 0649 0735 1063 1071 1078 1090 1091 1126 1129 1131 1149<br>1152 1164 1167 1200 1484 1488 1560 1579 1603 1630 1743<br>1751 1761 1777 1819 1851 1863 1870 1876 1884 1890 1901<br>2028 2052 2069 2072 2084 2091 2093 2106 2116 2133 2144<br>2151 2163 2166 2175 2179 2187 2193 2222 2233 2241 2243<br>2278 2279 2327 2343 2349 2369 2372 2373 2376 2393 2413<br>2442 2446 2464 2465 2474 2571 2618 2623 2641 | 013 |
| 0775 0802 0815 0841 0991 1045 1199 1487 1554 1707 1720<br>1763 1843 1905 1941 2064 2076 2105 2117 2330 2337 2342<br>2590 2707 2726 2793 2862 2903 2912 2957 2965 3070 3191 | 014 |
| 1012 1219 1233 1956 1967 2005 2730 3034 3106 3120 | 008 014 |
| 1379 1805 1841 1918 1969 1993 2419 2439 2688 | 004 013 |



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

| MSN | CONFIGURATION |
|---|---|
| 2835 2838 2840 2842 2844 2846 2848 2851 2853 2855 2856<br>2859 2861 2863 2865 2866 2867 2869 2870 2871 2872 2873<br>2874 2876 2877 2878 2879 2880 2881 2883 2884 2885 2886<br>2887 2888 2889 2890 2892 2893 2894 2896 2897 2898 2899<br>2900 2901 2902 2904 2905 2906 2907 2908 2909 2910 2911<br>2913 2914 2915 2917 2918 2921 2922 2923 2924 2925 2926<br>2928 2929 2930 2931 2932 2934 2935 2937 2938 2939 2940<br>2942 2943 2944 2945 2946 2948 2949 2950 2951 2952 2953<br>2954 2955 2956 2958 2959 2960 2961 2962 2963 2964 2966<br>2967 2968 2969 2970 2972 2973 2975 2976 2977 2978 2979<br>2980 2981 2982 2983 2984 2985 2986 2987 2988 2989 2990<br>2991 2992 2993 2994 2995 2997 3000 3001 3002 3003 3004<br>3006 3007 3008 3009 3010 3011 3012 3014 3016 3017 3018<br>3019 3020 3021 3023 3024 3025 3026 3027 3028 3029 3030<br>3031 3032 3033 3035 3036 3037 3039 3040 3041 3042 3043<br>3044 3045 3046 3047 3048 3049 3050 3053 3054 3055 3056<br>3057 3058 3059 3060 3061 3062 3064 3066 3068 3069 3071<br>3072 3073 3074 3076 3077 3078 3079 3080 3082 3083 3084<br>3085 3086 3087 3088 3089 3090 3091 3093 3094 3095 3096<br>3097 3100 3101 3102 3103 3105 3109 3111 3113 3114 3115<br>3116 3117 3118 3119 3121 3122 3123 3124 3125 3127 3128<br>3129 3131 3132 3133 3134 3135 3136 3137 3138 3139 3140<br>3141 3142 3143 3144 3145 3147 3148 3149 3150 3151 3152<br>3153 3154 3155 3156 3158 3159 3160 3161 3162 3164 3165<br>3166 3167 3168 3169 3170 3171 3172 3173 3174 3175 3176<br>3177 3178 3180 3181 3182 3183 3184 3185 3186 3187 3188<br>3190 3192 3193 3195 3196 3200 3202 3204 3208 3209 3210<br>3214 3216 3219 3220 3226 3227 3228 3231 3239 3248 3250<br>3252 3253 3257 3258 3259 3263 3264 3269 3270 3275 3276<br>3279 3280 3287 3292 3296 3301 3303 3304 3308 3311 3314<br>3316 3317 3318 3319 3330 3332 3335 3341 3342 3345 3348<br>3351 3352 3354 3357 3358 3365 3374 3375 3378 3379 3381<br>3384 3386 3392 3393 3395 3409 3414 3416 3418 3421 3423<br>3424 3428 3430 3437 3439 3449 3450 3451 3453 3454 3457<br>3463 3468 3474 3478 3479 3481 3483 3484 3488 3491 3495<br>3496 3497 3499 3500 3501 3510 3517 3519 3520 3524 3526<br>3531 3534 3535 3538 3541 3543 3547 3548 3550 3554 3556<br>3558 3561 3562 3567 3570 3572 3577 3578 3580 3581 3588<br>3590 3591 3595 3603 3607 3613 3614 3618 3621 3622 3624<br>3638 3641 3649 3650 3654 3659 3663 3668 3671 3672 3674<br>3676 3677 3680 3685 3692 3693 3694 3697 3703 3705 3707<br>3709 3710 3713 3714 3716 3718 3719 3721 3724 3726 3734<br>3736 3741 3743 3745 3748 3753 3757 3759 3760 3768 3770<br>3771 3772 3773 3775 3779 3782 3783 3785 3793 3797 3800<br>3801 3803 3804 3807 3811 3812 3829 3832 3836 3837 3839<br>3841 3842 3849 3850 3851 3857 3860 3863 3870 3873 3876<br>3877 3890 3897 3901 3902 3904 3910 3911 3912 3914 3917<br>3927 3929 3935 3937 3941 3943 3947 3958 3959 3962 3965<br>3968 3982 3986 3990 3999 4000 4003 4008 4017 4018 4023<br>4027 4036 4037 4042 4043 4053 4060 4065 4066 4068 4077<br>4094 4109 4110 4111 4113 4114 4118 4124 4130 4140 4144 | 005 |



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

| MSN | CONFIGURATION |
|---|---|
| 4151 4156 4163 4165 4166 4170 4171 4174 4176 4177 4178<br>4181 4183 4185 4186 4192 4197 4206 4210 4214 4215 4216<br>4220 4223 4225 4227 4229 4232 4238 4239 4240 4245 4246<br>4247 4248 4252 4256 4257 4259 4260 4262 4264 4265 4270<br>4279 4282 4285 4288 4290 4296 4297 4300 4301 4303 4305<br>4306 4308 4309 4312 4317 4319 4321 4323 4326 4328 4339<br>4340 4342 4343 4348 4350 4351 4354 4355 4356 4359 4370<br>4372 4378 4383 4384 4388 4389 4400 4403 4407 4409 4410<br>4412 4413 4421 4422 4423 4424 4428 4431 4434 4435 4436<br>4439 4440 4443 4445 4452 4457 4459 4460 4464 4466 4469<br>4471 4473 4474 4476 4479 4481 4482 4483 4488 4491 4493<br>4495 4496 4497 4505 4506 4509 4513 4514 4515 4516 4518<br>4522 4525 4527 4529 4531 4532 4533 4535 4540 4543 4546<br>4548 4549 4551 4552 4553 4561 4563 4566 4569 4572 4575<br>4576 4578 4580 4583 4584 4592 4593 4595 4597 4598 4602<br>4603 4605 4608 4609 4612 4614 4615 4619 4620 4621 4628<br>4629 4630 4632 4633 4634 4637 4642 4644 4645 4647 4653<br>4657 4660 4665 4666 4670 4677 4678 4683 4686 4687 4690<br>4695 4696 4697 4700 4701 4707 4715 4716 4725 4726 4736<br>4739 4741 4751 4752 4754 4755 4757 4762 4772 4773 4774<br>4775 4782 4784 4786 4790 4791 4798 4802 4804 4810 4812<br>4813 4817 4818 4825 4828 4832 4836 4842 4845 4853 4858<br>4864 4866 4868 4872 4874 4879 4883 4884 4888 4897 4899<br>4902 4904 4905 4906 4911 4912 4914 4918 4919 4920 4922<br>4926 4929 4930 4931 4934 4944 4947 4950 4951 4954 4961<br>4965 4968 4973 4975 4977 4982 4986 4990 4992 4995 4996<br>4997 4998 5000 5002 5010 5011 5021 5024 5027 5029 5030<br>5036 5039 5041 5042 5043 5050 5053 5060 5061 5062 5068<br>5073 5075 5076 5078 5080 5089 5090 5091 5092 5093 5094<br>5095 5105 5120 5121 5123 5127 5128 5132 5135 5139 5141<br>5142 5144 5145 5148 5151 5155 5156 5158 5159 5161 5168<br>5170 5176 5182 5183 5185 5188 5190 5194 5196 5198 5202<br>5207 5208 5211 5212 5214 5217 5218 5219 5225 5228 5230<br>5231 5242 5245 5248 5255 5258 5259 5261 5262 5267 5268<br>5270 5274 5280 5281 5286 5288 5291 5296 5298 5301 5302<br>5305 5308 5311 5312 5313 5322 5323 5326 5334 5335 5337<br>5345 5348 5349 5352 5355 5361 5362 5363 5365 5367 5370<br>5375 5376 5387 5389 5390 5391 5395 5406 5407 5410 5411<br>5417 5426 5429 5433 5436 5437 5439 5449 5457 5458 5460<br>5461 5467 5472 5473 5476 5479 5480 5482 5484 5488 5489<br>5492 5496 5499 5503 5506 5507 5508 5510 5516 5517 5520<br>5524 5530 5531 5532 5535 5537 5539 5553 5561 5564 5566<br>5569 5577 5579 5595 5596 5598 5599 5600 5602 5604 5605<br>5608 5609 5611 5612 5615 5617 5618 5620 5623 5624 5628<br>5629 5631 5634 5637 5641 5645 5646 5649 5650 5651 5660<br>5662 5671 5672 5676 5677 5680 5682 5683 5685 5695 5697<br>5700 5701 5708 5711 5712 5713 5714 5717 5721 5723 5725<br>5727 5732 5738 5744 5750 5756 5765 5775 5776 5780 5782<br>5784 5791 5793 5794 5796 5797 5804 5805 5806 5807 5813<br>5814 5817 5819 5821 5823 5826 5828 5829 5832 5835 5837<br>5840 5847 5850 5852 5853 5856 5857 5858 5861 5864 5868 | 005 |



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

| MSN | CONFIGURATION |
|---|---|
| 5871 5875 5877 5880 5882 5885 5892 5893 5894 5896 5898<br>5900 5910 5915 5920 5923 5924 5928 5930 5937 5940 5941<br>5942 5944 5948 5951 5952 5953 5954 5956 5962 5964 5971<br>5977 5978 5979 5985 5986 5988 5992 5993 5996 5999 6001<br>6007 6008 6010 6014 6018 6019 6023 6028 6030 6032 6036<br>6052 6058 6062 6068 6076 6077 6078 6082 6086 6091 6093<br>6098 6099 6106 6109 6113 6115 6120 6123 6128 6129 6131<br>6132 6134 6136 6137 6140 6142 6147 6155 6161 6180 6182<br>6187 6189 6191 6193 6195 6197 6198 6200 6208 6212 6217<br>6223 6226 6228 6229 6235 6237 6247 6254 6275 6278 6284<br>6287 6288 6289 6290 6296 6297 6298 6300 6302 6304 6306<br>6311 6321 6327 6331 6332 6336 6340 6343 6345 6352 6360<br>6362 6370 6374 6377 6381 6383 6388 6394 6400 6402 6417<br>6421 6424 6426 6431 6436 6439 6445 6449 6450 6455 6460<br>6462 6463 6470 6471 6474 6478 6480 6483 6486 6487 6489<br>6506 6507 6510 6513 6518 6522 6527 6530 6533 6535 6544<br>6551 6555 6557 6559 6566 6571 6574 6576 6578 6580 6583<br>6586 6589 6593 6594 6602 6604 6607 6610 6611 6612 6614<br>6616 6624 6631 6635 6643 6645 6655 6659 6662 6668 6683<br>6688 6694 6700 6705 6706 6733 6735 6749 6750 6752 6755<br>6771 6775 6778 6785 6792 6794 6795 6816 6820 6832 6841<br>6851 6854 6857 6865 6875 6882 6883 6886 6888 6898 6900<br>6901 6906 6917 6919 6921 6932 6934 6943 6948 6955 6961<br>6969 6971 6978 6984 6989 7000 7006 7008 7014 7017 7020<br>7026 7028 7041 7043 7062 7075 7086 7088 7100 7109 7110<br>7118 7123 7134 7153 7156 7163 7190 7197 7203 7213 7232<br>7234 7247 7262 7267 7270 7347 7351 7356 7362 7376 7378<br>7402 7420 7423 7434 7435 7442 7457 7491 7497 7502 7585<br>7595 7635 7656 7679 7691 7695 7711 7717 7724 7725 7738<br>7760 7761 7771 7796 7808 7809 7814 7827 7880 7909 7922<br>7974 7982 7988 8006 8012 8018 8021 8024 8027 8028 8097<br>8111 8130 8151 8176 8183 8192 8210 8238 8244 8311 8327<br>8355 8362 8376 8400 8429 8434 8493 8539 8574 8599 8611<br>8614 8632 8659 8696 8730 8824 8838 8842 | 005 |
| 2875 2920 2947 2998 3052 3063 3065 3099 3107 3108 3157<br>3179 3189 3402 5055 5401 5613 5734 5870 5968 6029 6037 | 011 |



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

| MSN | CONFIGURATION |
|---|---|
| 3194 3197 3199 3201 3203 3205 3206 3211 3213 3215 3218<br>3221 3223 3224 3225 3230 3232 3234 3236 3237 3238 3240<br>3242 3243 3245 3246 3255 3256 3260 3261 3266 3268 3271<br>3272 3273 3277 3278 3282 3284 3285 3286 3288 3289 3291<br>3293 3295 3299 3300 3305 3306 3309 3310 3312 3313 3320<br>3321 3323 3324 3325 3327 3328 3331 3333 3337 3338 3343<br>3344 3346 3347 3349 3353 3356 3359 3361 3362 3363 3364<br>3366 3368 3370 3371 3376 3377 3380 3383 3389 3390 3391<br>3394 3396 3398 3400 3403 3404 3406 3407 3408 3411 3412<br>3413 3415 3417 3420 3422 3425 3426 3427 3431 3432 3435<br>3436 3438 3440 3442 3443 3444 3445 3447 3448 3452 3455<br>3456 3460 3461 3464 3465 3466 3467 3469 3470 3475 3476<br>3477 3480 3482 3485 3486 3487 3489 3492 3502 3503 3505<br>3506 3508 3509 3513 3514 3515 3516 3518 3521 3528 3529<br>3530 3532 3533 3536 3537 3540 3542 3544 3549 3551 3553<br>3555 3559 3560 3563 3564 3565 3568 3569 3571 3576 3579<br>3582 3585 3586 3589 3594 3596 3597 3598 3599 3601 3602<br>3604 3605 3606 3608 3609 3610 3611 3615 3616 3617 3620<br>3626 3628 3630 3632 3634 3635 3642 3643 3646 3647 3651<br>3652 3656 3657 3658 3660 3661 3662 3664 3666 3667 3670<br>3675 3679 3683 3684 3686 3687 3689 3690 3691 3695 3696<br>3698 3700 3701 3702 3704 3706 3715 3720 3723 3727 3728<br>3729 3731 3732 3733 3735 3739 3742 3744 3746 3747 3750<br>3751 3754 3755 3756 3758 3762 3763 3765 3767 3769 3774<br>3776 3777 3780 3781 3787 3788 3790 3791 3795 3798 3799<br>3802 3805 3808 3809 3810 3813 3815 3817 3818 3819 3822<br>3824 3825 3826 3827 3828 3831 3833 3840 3843 3844 3845<br>3846 3848 3852 3853 3854 3855 3856 3859 3861 3865 3868<br>3871 3872 3874 3875 3882 3883 3885 3886 3887 3888 3889<br>3891 3892 3894 3895 3896 3898 3900 3903 3905 3906 3907<br>3908 3909 3913 3915 3918 3919 3921 3922 3925 3931 3932<br>3933 3939 3945 3946 3949 3950 3952 3953 3956 3957 3961<br>3963 3967 3970 3971 3972 3974 3975 3976 3978 3979 3980<br>3983 3984 3985 3988 3991 3992 3994 3995 3997 4001 4004<br>4006 4007 4010 4011 4012 4013 4014 4015 4019 4020 4021<br>4026 4028 4029 4030 4033 4034 4035 4038 4039 4040 4046<br>4048 4049 4051 4052 4055 4056 4057 4059 4061 4063 4064<br>4069 4070 4071 4072 4075 4076 4079 4080 4081 4083 4084<br>4086 4087 4088 4089 4090 4092 4093 4095 4097 4098 4100<br>4101 4102 4104 4105 4106 4108 4115 4117 4119 4120 4121<br>4122 4125 4126 4127 4128 4129 4132 4135 4137 4139 4141<br>4143 4145 4146 4147 4149 4152 4153 4154 4157 4158 4159<br>4161 4162 4164 4167 4168 4169 4172 4175 4179 4182 4187<br>4188 4190 4191 4193 4195 4196 4199 4200 4201 4202 4203<br>4204 4205 4207 4208 4211 4212 4218 4219 4222 4226 4228<br>4231 4233 4234 4235 4236 4237 4241 4242 4243 4244 4249<br>4250 4253 4254 4255 4258 4261 4263 4267 4268 4269 4272<br>4273 4275 4276 4278 4281 4284 4286 4287 4289 4291 4293<br>4294 4295 4298 4302 4304 4307 4310 4313 4314 4316 4320<br>4322 4324 4325 4327 4329 4331 4332 4333 4335 4336 4337<br>4344 4345 4346 4347 4349 4353 4357 4361 4362 4363 4364 | 002 |



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

| MSN | CONFIGURATION |
|---|---|
| 4365 4366 4367 4368 4371 4373 4375 4376 4379 4380 4381 | 002 |
| 4385 4386 4390 4391 4392 4393 4394 4395 4396 4397 4398 | |
| 4399 4401 4402 4404 4405 4408 4411 4414 4415 4417 4418 | |
| 4419 4425 4426 4427 4429 4432 4433 4437 4438 4441 4442 | |
| 4444 4446 4447 4448 4449 4451 4454 4455 4456 4458 4462 | |
| 4463 4465 4468 4470 4475 4477 4478 4480 4484 4485 4486 | |
| 4487 4489 4490 4492 4499 4501 4502 4503 4504 4507 4508 | |
| 4510 4511 4512 4517 4519 4520 4521 4523 4524 4526 4528 | |
| 4536 4537 4539 4541 4544 4547 4550 4554 4555 4556 4557 | |
| 4558 4559 4562 4564 4565 4567 4568 4571 4573 4574 4581 | |
| 4582 4586 4587 4588 4589 4591 4594 4596 4599 4600 4601 | |
| 4604 4606 4610 4613 4616 4618 4622 4623 4624 4627 4631 | |
| 4635 4636 4639 4640 4641 4646 4650 4651 4652 4655 4658 | |
| 4659 4661 4663 4664 4667 4668 4671 4673 4674 4675 4676 | |
| 4680 4681 4685 4688 4689 4691 4693 4694 4699 4702 4704 | |
| 4705 4708 4709 4711 4713 4714 4717 4718 4720 4721 4722 | |
| 4723 4724 4727 4729 4730 4732 4733 4734 4735 4738 4740 | |
| 4742 4743 4744 4745 4747 4748 4749 4750 4756 4758 4759 | |
| 4760 4763 4764 4765 4766 4767 4768 4769 4770 4776 4777 | |
| 4778 4780 4781 4785 4787 4789 4793 4794 4795 4796 4797 | |
| 4799 4800 4801 4803 4805 4806 4807 4808 4809 4814 4815 | |
| 4816 4820 4821 4823 4827 4829 4831 4833 4837 4839 4840 | |
| 4841 4844 4846 4848 4849 4851 4852 4854 4855 4857 4859 | |
| 4860 4861 4862 4865 4867 4869 4870 4871 4875 4876 4877 | |
| 4878 4880 4882 4886 4887 4889 4890 4891 4892 4894 4895 | |
| 4896 4900 4903 4907 4908 4909 4910 4913 4915 4917 4921 | |
| 4924 4927 4928 4933 4936 4937 4938 4939 4941 4942 4943 | |
| 4946 4948 4952 4953 4955 4956 4958 4959 4963 4964 4967 | |
| 4969 4970 4972 4974 4978 4979 4980 4981 4983 4984 4985 | |
| 4987 4988 4989 4991 4993 4999 5003 5004 5005 5006 5007 | |
| 5008 5012 5013 5014 5015 5016 5017 5018 5019 5020 5022 | |
| 5023 5032 5033 5034 5037 5040 5045 5046 5047 5048 5051 | |
| 5052 5056 5057 5058 5063 5064 5066 5067 5069 5070 5071 | |
| 5072 5079 5081 5082 5084 5085 5086 5088 5096 5097 5098 | |
| 5100 5101 5102 5103 5104 5107 5108 5109 5110 5111 5112 | |
| 5113 5114 5115 5116 5117 5119 5122 5125 5129 5130 5131 | |
| 5136 5137 5138 5140 5143 5146 5147 5149 5150 5152 5153 | |
| 5157 5162 5163 5165 5166 5171 5172 5174 5175 5178 5179 | |
| 5181 5184 5187 5189 5191 5193 5195 5200 5201 5203 5204 | |
| 5206 5209 5213 5215 5216 5220 5221 5222 5223 5224 5226 | |
| 5229 5232 5234 5236 5238 5239 5240 5243 5246 5249 5250 | |
| 5252 5253 5256 5260 5263 5264 5266 5272 5273 5276 5277 | |
| 5278 5283 5284 5289 5290 5293 5294 5299 5304 5307 5310 | |
| 5315 5316 5318 5319 5320 5324 5325 5327 5329 5330 5331 | |
| 5333 5338 5339 5341 5342 5344 5347 5351 5353 5356 5358 | |
| 5359 5360 5364 5366 5369 5371 5372 5373 5378 5379 5380 | |
| 5381 5383 5384 5386 5393 5394 5396 5397 5398 5399 5400 | |
| 5403 5405 5408 5412 5414 5415 5416 5419 5420 5423 5424 | |
| 5425 5428 5430 5431 5434 5440 5441 5442 5443 5445 5446 | |
| 5448 5451 5452 5453 5454 5455 5463 5464 5466 5468 5471 | |
| 5474 5477 5486 5550 5563 5568 5639 5656 5664 5679 5722 | |



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

| MSN | CONFIGURATION |
|---|---|
| 5731 5740 | 002 |



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

| MSN | CONFIGURATION |
|---|---|
| 3235 3241 3247 3249 3251 3254 3262 3265 3274 3283 3290<br>3294 3297 3302 3307 3315 3322 3326 3329 3339 3340 3350<br>3355 3360 3367 3369 3372 3382 3387 3397 3399 3401 3405<br>3419 3429 3434 3441 3459 3462 3471 3493 3498 3504 3507<br>3512 3522 3523 3525 3527 3539 3546 3552 3557 3566 3573<br>3583 3584 3587 3592 3593 3600 3619 3625 3636 3637 3645<br>3669 3673 3681 3688 3712 3717 3730 3737 3738 3740 3752<br>3761 3764 3784 3792 3796 3816 3820 3847 3858 3862 3864<br>3867 3869 3878 3881 3893 3899 3916 3920 3924 3926 3934<br>3936 3938 3944 3948 3951 3955 3960 3964 3966 3969 3977<br>3981 3987 3989 3993 3996 4002 4005 4009 4016 4025 4041<br>4044 4045 4047 4050 4054 4067 4073 4078 4082 4085 4096<br>4107 4112 4123 4134 4136 4138 4142 4155 4173 4184 4189<br>4198 4209 4213 4217 4224 4230 4266 4271 4277 4280 4292<br>4299 4311 4315 4341 4352 4358 4360 4374 4382 4387 4406<br>4420 4430 4530 4545 4560 4570 4585 4607 4617 4626 4638<br>4643 4654 4662 4669 4672 4682 4698 4703 4706 4710 4719<br>4731 4737 4746 4753 4761 4771 4779 4783 4788 4792 4819<br>4824 4826 4830 4834 4843 4847 4850 4856 4863 4873 4881<br>4885 4893 4898 4916 4923 4932 4935 4940 4945 4949 4957<br>4960 4966 4971 4976 4994 5025 5028 5035 5049 5054 5074<br>5077 5083 5087 5099 5118 5124 5154 5160 5164 5169 5173<br>5177 5180 5186 5192 5197 5199 5205 5210 5227 5233 5235<br>5237 5241 5244 5247 5251 5254 5257 5265 5269 5275 5279<br>5282 5287 5292 5297 5300 5303 5306 5309 5317 5321 5332<br>5336 5340 5343 5346 5350 5368 5374 5382 5385 5388 5392<br>5402 5409 5413 5418 5422 5427 5432 5438 5450 5456 5459<br>5462 5465 5469 5470 5481 5490 5495 5500 5519 5523 5528<br>5534 5543 5546 5555 5558 5575 5582 5584 5606 5633 5636<br>5647 5655 5663 5667 5670 5689 5699 5705 5709 5715 5728<br>5736 5747 5751 5758 5763 5767 5770 5774 5783 5787 5795<br>5800 5803 5820 5825 5834 5836 5838 5854 5860 5865 5884<br>5890 5895 5899 5904 5909 5916 5922 5932 5936 5938 5939<br>5946 5947 5949 5955 5958 5960 5961 5975 5980 5983 5987<br>5991 5994 5998 6002 6009 6020 6027 6031 6035 6046 6049<br>6059 6063 6070 6074 6083 6089 6094 6097 6100 6104 6108<br>6121 6126 6130 6133 6138 6143 6146 6148 6152 6159 6162<br>6163 6165 6175 6181 6185 6186 6190 6194 6199 6201 6203<br>6205 6211 6214 6219 6222 6227 6230 6233 6236 6238 6241<br>6245 6249 6252 6253 6255 6256 6261 6264 6266 6271 6272<br>6273 6279 6291 6294 6295 6299 6303 6305 6308 6313 6316<br>6324 6326 6330 6334 6337 6344 6346 6354 6359 6363 6366<br>6371 6382 6385 6387 6390 6395 6396 6399 6401 6407 6415<br>6420 6425 6427 6440 6443 6448 6451 6461 6472 6473 6475<br>6479 6482 6490 6493 6495 6499 6504 6508 6512 6517 6520<br>6523 6531 6532 6534 6537 6539 6543 6554 6556 6558 6560<br>6563 6569 6573 6575 6581 6599 6601 6609 6613 6618 6621<br>6623 6625 6630 6638 6647 6649 6650 6652 6656 6657 6660<br>6663 6667 6672 6682 6684 6687 6691 6693 6703 6709 6711<br>6723 6725 6731 6736 6740 6745 6748 6751 6757 6758 6760<br>6761 6763 6766 6768 6770 6774 6781 6783 6790 6791 6796 | 009 |



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

| MSN | CONFIGURATION |
|---|---|
| 6802 6804 6809 6810 6812 6818 6821 6822 6827 6828 6840 6842 6848 6850 6853 6859 6861 6863 6866 6867 6869 6879 6880 6887 6897 6903 6908 6909 6910 6912 6913 6915 6916 6928 6930 6933 6938 6940 6956 6973 6976 6983 6987 6988 6990 6994 6998 7009 7013 7015 7018 7021 7029 7032 7034 7045 7046 7052 7058 7065 7069 7076 7079 7085 7089 7105 7106 7108 7114 7125 7131 7133 7135 7139 7144 7146 7152 7154 7155 7157 7161 7166 7173 7180 7182 7188 7191 7196 7199 7208 7217 7218 7220 7229 7230 7242 7246 7248 7257 7266 7274 7280 7285 7288 7296 7299 7301 7303 7305 7307 7310 7316 7322 7324 7326 7335 7336 7349 7353 7357 7363 7368 7384 7388 7390 7395 7403 7407 7415 7416 7419 7422 7438 7440 7443 7445 7448 7451 7455 7462 7468 7471 7488 7492 7500 7509 7511 7515 7516 7518 7519 7520 7522 7525 7528 7529 7532 7539 7541 7552 7557 7562 7564 7566 7570 7578 7584 7590 7596 7599 7607 7611 7613 7617 7621 7623 7627 7631 7636 7647 7651 7661 7668 7690 7692 7700 7702 7706 7714 7722 7729 7732 7734 7739 7741 7752 7754 7756 7763 7774 7775 7783 7798 7815 7820 7821 7825 7826 7831 7855 7857 7870 7872 7874 7876 7882 7907 7908 7915 7923 7924 7926 7929 7947 7948 7955 7956 7957 7969 7981 7985 7993 7994 8041 8044 8045 8047 8055 8062 8069 8114 8115 8141 8143 8160 8163 8169 8174 8178 8185 8216 8223 8236 8241 8271 8293 8295 8296 8305 8325 8328 8336 8342 8347 8401 8407 8410 8437 8450 8473 8500 8525 8534 8538 8550 8581 8600 8615 8625 8641 8644 8664 8724 8791 8879 8943 8950 | 009 |
| 3267 3334 3458 3575 4728 5357 5404 6734 7206 7375 7674 7686 | 015 |
| 3281 3298 3336 3373 3385 3388 3410 3433 3446 3472 3473 3490 3494 3511 3545 3574 3627 3631 3640 3644 3699 3711 3778 3786 3789 3794 3823 3834 3835 3838 3866 3880 3923 3942 3954 3998 4024 4032 4133 4150 4160 4453 4498 4579 4625 4649 4656 4679 4684 4692 4712 4835 5001 5026 5031 5106 5134 5167 5421 | 016 |
| 3612 3623 3629 3633 3639 3653 3655 3665 3678 3682 3708 3722 3725 3749 3766 3806 3814 3830 3879 3884 3928 3930 3940 3973 4022 4031 4062 4091 4131 4180 4194 4221 4251 4274 4283 4318 4334 4338 4369 4377 4416 4467 4472 4494 4534 4538 4542 4577 4590 4611 4648 4811 4838 4901 4925 4962 5009 5038 5065 5126 5133 5285 5295 5314 5328 5354 5377 5435 5444 5447 5475 5504 5513 | 006 |
| 4058 4074 4099 4103 4116 4148 4461 4500 5044 5059 5271 | 017 |



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

| MSN | CONFIGURATION |
|---|---|
| 5478 5483 5487 5491 5493 5494 5497 5498 5501 5502 5505<br>5511 5512 5514 5515 5518 5521 5522 5525 5526 5527 5529<br>5533 5540 5541 5542 5544 5545 5547 5548 5551 5552 5554<br>5556 5557 5560 5562 5570 5571 5574 5576 5581 5583 5586<br>5587 5589 5590 5591 5592 5593 5597 5601 5610 5616 5619<br>5621 5622 5625 5626 5627 5630 5632 5635 5638 5640 5642<br>5643 5648 5652 5653 5654 5657 5658 5661 5665 5666 5668<br>5669 5673 5675 5678 5686 5687 5688 5690 5691 5692 5693<br>5694 5698 5702 5703 5704 5706 5707 5710 5716 5718 5719<br>5724 5726 5729 5730 5735 5737 5739 5741 5742 5745 5746<br>5748 5749 5752 5753 5754 5757 5759 5760 5761 5762 5764<br>5766 5768 5769 5771 5772 5773 5777 5778 5781 5785 5786<br>5788 5789 5792 5798 5799 5801 5802 5809 5810 5811 5812<br>5815 5816 5818 5822 5824 5827 5830 5831 5833 5839 5841<br>5842 5844 5845 5846 5848 5851 5855 5859 5862 5863 5866<br>5867 5869 5874 5878 5879 5883 5886 5887 5888 5889 5891<br>5897 5901 5902 5903 5905 5906 5907 5908 5911 5912 5914<br>5917 5918 5925 5926 5927 5929 5931 5933 5934 5935 5943<br>5945 5950 5957 5959 5963 5965 5972 5973 5976 5981 5984<br>5990 5995 5997 6000 6003 6004 6006 6011 6012 6015 6021<br>6025 6026 6033 6034 6039 6040 6041 6045 6047 6048 6050<br>6051 6054 6055 6057 6061 6064 6065 6069 6072 6073 6075<br>6079 6080 6081 6084 6085 6088 6092 6095 6096 6102 6103<br>6105 6107 6110 6111 6112 6116 6117 6118 6124 6125 6127<br>6135 6139 6141 6144 6145 6149 6150 6151 6153 6154 6157<br>6158 6160 6164 6166 6167 6169 6170 6173 6174 6176 6177<br>6178 6183 6184 6188 6192 6202 6204 6206 6207 6209 6213<br>6215 6216 6218 6220 6224 6225 6231 6234 6239 6240 6242<br>6243 6244 6246 6248 6250 6251 6257 6258 6259 6260 6262<br>6263 6265 6267 6269 6270 6274 6277 6280 6281 6282 6283<br>6285 6292 6293 6301 6307 6309 6310 6315 6317 6318 6320<br>6322 6323 6325 6328 6329 6333 6335 6338 6339 6341 6347<br>6348 6349 6350 6353 6355 6356 6357 6358 6361 6365 6367<br>6368 6369 6372 6373 6375 6378 6379 6380 6384 6386 6391<br>6392 6393 6397 6403 6404 6405 6408 6410 6411 6412 6413<br>6416 6418 6422 6423 6428 6429 6430 6434 6437 6441 6442<br>6444 6446 6447 6452 6453 6456 6457 6458 6465 6466 6467<br>6469 6476 6481 6485 6491 6492 6494 6496 6497 6498 6500<br>6502 6503 6505 6509 6514 6516 6519 6521 6524 6525 6528<br>6529 6536 6538 6540 6541 6542 6546 6547 6549 6550 6552<br>6553 6561 6562 6564 6565 6568 6570 6572 6577 6582 6584<br>6587 6588 6591 6595 6596 6597 6598 6600 6603 6605 6606<br>6608 6617 6619 6622 6626 6628 6633 6634 6636 6637 6640<br>6644 6646 6648 6651 6654 6661 6664 6665 6666 6669 6671<br>6674 6675 6676 6677 6679 6680 6681 6686 6689 6690 6692<br>6695 6697 6699 6702 6704 6708 6710 6712 6713 6714 6715<br>6716 6717 6721 6722 6724 6727 6728 6730 6732 6737 6738<br>6739 6741 6742 6743 6746 6753 6754 6759 6764 6765 6769<br>6773 6776 6777 6779 6782 6784 6786 6787 6788 6789 6800<br>6803 6805 6806 6807 6808 6811 6813 6815 6823 6824 6826<br>6830 6831 6834 6835 6836 6837 6838 6843 6846 6847 6856 | 003 |



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

| MSN | CONFIGURATION |
|---|---|
| 6858 6862 6870 6871 6874 6876 6877 6878 6881 6885 6889<br>6890 6892 6893 6896 6902 6911 6918 6922 6924 6925 6927<br>6929 6931 6937 6939 6941 6942 6944 6947 6950 6951 6953<br>6958 6959 6962 6964 6965 6966 6970 6972 6974 6977 6980<br>6981 6982 6985 6986 6991 6992 6993 6995 6996 6997 7002<br>7004 7012 7016 7019 7022 7024 7025 7027 7030 7035 7039<br>7040 7044 7049 7050 7056 7057 7059 7063 7066 7067 7068<br>7070 7077 7080 7082 7087 7091 7092 7093 7095 7096 7099<br>7104 7111 7113 7115 7116 7120 7121 7122 7132 7136 7138<br>7145 7148 7151 7158 7159 7160 7164 7167 7168 7169 7170<br>7174 7177 7178 7183 7189 7200 7201 7207 7210 7211 7216<br>7219 7221 7223 7224 7225 7226 7228 7231 7235 7238 7243<br>7245 7251 7253 7256 7258 7259 7261 7263 7264 7272 7282<br>7284 7289 7292 7297 7302 7308 7312 7314 7315 7318 7319<br>7325 7328 7337 7338 7340 7345 7350 7355 7361 7365 7370<br>7372 7374 7377 7383 7385 7389 7392 7393 7394 7397 7398<br>7404 7405 7406 7408 7410 7411 7412 7414 7421 7425 7426<br>7431 7432 7437 7439 7444 7447 7450 7452 7453 7456 7458<br>7460 7463 7464 7465 7467 7469 7473 7474 7476 7482 7485<br>7487 7490 7496 7503 7513 7527 7531 7534 7537 7542 7543<br>7545 7549 7550 7556 7569 7572 7574 7580 7582 7583 7597<br>7604 7605 7608 7609 7614 7615 7619 7620 7622 7624 7625<br>7630 7632 7633 7637 7640 7643 7644 7654 7657 7659 7660<br>7664 7665 7666 7669 7670 7673 7681 7683 7685 7687 7693<br>7696 7699 7701 7704 7708 7712 7713 7716 7718 7728 7730<br>7740 7742 7743 7745 7747 7748 7750 7762 7766 7767 7772<br>7773 7779 7780 7781 7784 7785 7789 7790 7792 7797 7805<br>7816 7817 7819 7823 7829 7832 7838 7866 7867 7868 7869<br>7873 7883 7886 7889 7890 7893 7900 7901 7904 7905 7906<br>7910 7911 7913 7916 7927 7935 7937 7938 7954 7958 7963<br>7964 7966 7971 7975 7977 7978 7987 7989 8007 8009 8010<br>8011 8013 8019 8022 8029 8033 8035 8037 8042 8046 8053<br>8057 8060 8064 8065 8066 8068 8070 8071 8072 8075 8081<br>8082 8083 8116 8119 8124 8125 8127 8132 8149 8161 8162<br>8165 8177 8179 8189 8211 8213 8220 8222 8230 8252 8263<br>8285 8287 8298 8299 8313 8315 8317 8321 8324 8329 8334<br>8343 8344 8346 8352 8354 8358 8379 8381 8384 8385 8390<br>8391 8394 8396 8398 8422 8424 8427 8428 8435 8438 8439<br>8442 8448 8457 8462 8463 8466 8477 8479 8481 8485 8499<br>8504 8509 8519 8522 8532 8548 8561 8582 8585 8590 8595<br>8597 8604 8616 8634 8646 8651 8652 8657 8663 8667 8671<br>8672 8673 8677 8680 8709 8716 8746 8748 8778 8784 8786<br>8797 8798 8808 8835 8841 8845 8847 8853 8871 8891 8892<br>8902 8911 8925 8931 8942 8951 8960 8964 8986 8994 9009<br>9010 9020 9033 9037 9052 9058 9081 9104 9122 9130 9185<br>9279 9292 9304 9313 9319 9329 9448 | 003 |



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

| MSN | CONFIGURATION |
|---|---|
| 5485 5509 5538 5549 5567 5573 5588 5594 5603 5644 5659<br>5674 5684 5696 5743 5808 5843 5849 5872 5876 5969 6005<br>6013 6024 6038 6042 6053 6056 6087 6114 6122 6168 6172<br>6179 6196 6221 6276 6312 6314 6319 6342 6351 6364 6376<br>6389 6398 6406 6409 6414 6432 6433 6435 6438 6454 6459<br>6468 6477 6484 6488 6501 6511 6515 6526 6545 6548 6567<br>6579 6585 6590 6592 6615 6627 6629 6632 6639 6641 6653<br>6658 6670 6685 6696 6698 6701 6707 6718 6719 6729 6747<br>6762 6767 6780 6793 6797 6798 6814 6825 6844 6845 6852<br>6855 6872 6873 6884 6891 6894 6895 6899 6905 6923 6926<br>6935 6936 6949 6957 6960 6968 6979 6999 7003 7005 7007<br>7010 7023 7031 7036 7042 7048 7054 7055 7061 7064 7073<br>7081 7090 7097 7098 7101 7112 7117 7119 7127 7128 7130<br>7142 7143 7149 7165 7171 7176 7179 7184 7187 7194 7198<br>7204 7212 7214 7222 7227 7233 7237 7239 7241 7244 7250<br>7254 7260 7265 7268 7271 7276 7278 7281 7286 7287 7293<br>7294 7298 7304 7306 7311 7313 7317 7320 7327 7332 7339<br>7342 7344 7346 7348 7358 7360 7364 7366 7369 7371 7373<br>7379 7381 7382 7400 7413 7418 7424 7427 7430 7433 7436<br>7441 7446 7454 7461 7478 7479 7481 7493 7498 7506 7524<br>7536 7546 7551 7558 7573 7575 7586 7592 7601 7628 7641<br>7650 7652 7655 7658 7672 7675 7680 7684 7689 7707 7709<br>7715 7720 7726 7736 7758 7759 7765 7769 7777 7787 7793<br>7810 7818 7830 7833 7840 7845 7852 7865 7879 7884 7885<br>7888 7894 7896 7898 7903 7919 7933 7940 7943 7953 7962<br>7970 7973 7976 7998 8026 8032 8034 8036 8040 8049 8054<br>8061 8063 8076 8078 8080 8104 8128 8134 8153 8159 8171<br>8180 8190 8191 8200 8207 8215 8227 8232 8233 8245 8250<br>8251 8254 8258 8269 8279 8281 8283 8316 8322 8332 8339<br>8359 8370 8388 8393 8423 8447 8502 8530 8536 8549 8577<br>8579 8592 8605 8606 8640 8670 8676 8694 8695 8697 8713<br>8734 8763 8765 8809 8810 8812 8822 8854 8856 8858 8859<br>8914 8915 8916 8947 8974 8975 9025 9027 9028 9043 9057<br>9066 9067 9125 9126 9128 9176 9360 9409 9485 9538 9588 | 007 |
| 5536 5559 5565 5572 5578 5580 5585 5607 5614 5873 5921<br>5967 5970 5974 5982 5989 6017 6022 6043 6044 6060 6066<br>6071 6090 6171 6954 6963 7038 7071 7215 7240 7275 7279<br>7295 7561 7593 7646 7653 7806 7836 7843 7846 7863 7902<br>7932 8067 8073 8133 8188 8201 8234 8276 8319 8418 8452<br>8555 | 010 |
| 5681 5720 5733 5755 5779 5790 5881 5913 5919 5966 6016<br>6067 6119 6156 6210 6232 6268 6678 6726 6756 6817 6945<br>7037 7072 7084 7137 7193 7202 7255 7300 7645 7667 7678<br>7749 7782 7801 7878 7934 8147 8205 8363 8378 | 012 |

(5) Configuration definition

**CONF 001
Config. 001 is valid for A318, A319 and A320 aircraft in the effectivity of this Service Bulletin on which:
- Modification No. 22688J0871 is not embodied



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

- Modification No. 35806J2705 is not embodied
- Modification No. 37331J2816 is not embodied
- Modification No. 37332J2817 is not embodied
- Modification No. 155374K17141 is not embodied or Service Bulletin No. A320-00-1260 is not accomplished
- Modification No. 34650P8752 is not embodied or Service Bulletin No. A320-32-1308 is not accomplished
- Modification No. 152970J3375 is not embodied or Service Bulletin No. A320-32-1422 is not accomplished.

NOTE: If your aircraft is in this configuration and you have or are transferring to CIS and accomplishing one or more of the Service Bulletins, A320-00-1260, A320-32-1308 or A320-32-1422, the embodiment of this modification should be completed by the timescales (Flight Cycles (FC) or Flight Hours (FH)) contained in Config. 010, 011, 013 or 016 for legacy aircraft. The Modification kit and work instructions for Config. 001 are still applicable.

**CONF 002
Config. 002 is valid for A318, A319 and A320 aircraft in the effectivity of this Service Bulletin on which:
- Modification No. 37331J2816 is embodied
and on which:
- Modification No. 154484J3292 is not embodied
- Modification No. 155374K17141 is not embodied or Service Bulletin No. A320-00-1260 is not accomplished
- Modification No. 34650P8752 is not embodied or Service Bulletin No. A320-32-1308 is not accomplished
- Modification No. 152970J3375 is not embodied or Service Bulletin No. A320-32-1422 is not accomplished.

**CONF 003
Config. 003 is valid for A318, A319 and A320 aircraft in the effectivity of this Service Bulletin on which:
- Modification No. 154484J3292 is embodied
- Modification No. 37331J2816 is embodied
and on which:
- Modification No. 37332J2817 is not embodied
- Modification No. 155374K17141 is not embodied or Service Bulletin No. A320-00-1260 is not accomplished
- Modification No. 34650P8752 is not embodied or Service Bulletin No. A320-32-1308 is not accomplished
- Modification No. 152970J3375 is not embodied or Service Bulletin No. A320-32-1422 is not accomplished.

**CONF 004
Config. 004 is valid for A318, A319 and A320 aircraft in the effectivity of this Service Bulletin on which:
- Modification No. 22688J0871 is embodied
and on which:
- Modification No. 154484J3292 is not embodied
- Modification No. 35806J2705 is not embodied
- Modification No. 37331J2816 is not embodied



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

- Modification No. 37332J2817 is not embodied
- Modification No. 155374K17141 is not embodied or Service Bulletin No. A320-00-1260 is not accomplished
- Modification No. 34650P8752 is not embodied or Service Bulletin No. A320-32-1308 is not accomplished
- Modification No. 152970J3375 is not embodied or Service Bulletin No. A320-32-1422 is not accomplished.

**CONF 005
Config. 005 is valid for A318, A319 and A320 aircraft in the effectivity of this Service Bulletin on which:
- Modification No. 35806J2705 is embodied
- Modification No. 22688J0871 is embodied
and on which:
Modification No. 155374K17141 is not embodied or Service Bulletin No. A320-00-1260 is not accomplished
- Modification No. 34650P8752 is not embodied or Service Bulletin No. A320-32-1308 is not accomplished
- Modification No. 152970J3375 is not embodied or Service Bulletin No. A320-32-1422 is not accomplished
OR
on which:
- Modification No. 37322J2817 is embodied
and on which:
- Modification No. 155374K17141 is not embodied or Service Bulletin No. A320-00-1260 is not accomplished
- Modification No. 34650P8752 is not embodied or Service Bulletin No. A320-32-1308 is not accomplished
- Modification No. 152970J3375 is not embodied or Service Bulletin No. A320-32-1422 is not accomplished.

**CONF 006
Config. 006 is valid for A321 aircraft in the effectivity of this Service Bulletin on which:
- Modification No. No. 38616J2887 is embodied
and on which:
- Modification No. 154484J3292 is not embodied
- Modification No. 155374K17141 is not embodied or Service Bulletin No. A320-00-1260 is not accomplished
- Modification No. 34650P8752 is not embodied or Service Bulletin No. A320-32-1308 is not accomplished
- Modification No. 152970J3375 is not embodied or Service Bulletin No. A320-32-1422 is not accomplished.

**CONF 007
Config. 007 is valid for A321 aircraft in the effectivity of this Service Bulletin that have embodied:
- Modification No. 154484J3292 is embodied
- Modification No. 38616J2887 is embodied
and on which:
- Modification No. 38617J2888 is not embodied
- Modification No. 155374K17141 is not embodied or Service Bulletin No. A320-00-1260 is not accomplished



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

- Modification No. 34650P8752 is not embodied or Service Bulletin No. A320-32-1308 is not accomplished
- Modification No. 152970J3375 is not embodied or Service Bulletin No. A320-32-1422 is not accomplished.

**CONF 008
Config. 008 is valid for A321 aircraft in the effectivity of this Service Bulletin on which:
- Modification No. 37532J2815 is not embodied
- Modification No. 38617J2888 is not embodied
- Modification No. 155374K17141 is not embodied or Service Bulletin No. A320-00-1260 is not accomplished
- Modification No. 34650P8752 is not embodied or Service Bulletin No. A320-32-1308 is not accomplished
- Modification No. 152970J3375 is not embodied or Service Bulletin No. A320-32-1422 is not accomplished.

**CONF 009
Config. 009 is valid for A321 aircraft in the effectivity of this Service Bulletin on which:
- Modification No. 37532J2815 is embodied
and on which:
- Modification No. 154484J3292 is not embodied
- Modification No. 38617J2888 is not embodied
- Modification No. 155374K17141 is not embodied or Service Bulletin No. A320-00-1260 is not accomplished
- Modification No. 34650P8752 is not embodied or Service Bulletin No. A320-32-1308 is not accomplished
- Modification No. 152970J3375 is not embodied or Service Bulletin No. A320-32-1422 is not accomplished
OR
on which:
- Modification No. 38617J2888 is embodied
and on which:
- Modification No. 155374K17141 is not embodied or Service Bulletin No. A320-00-1260 is not accomplished
- Modification No. 34650P8752 is not embodied or Service Bulletin No. A320-32-1308 is not accomplished
- Modification No. 152970J3375 is not embodied or Service Bulletin No. A320-32-1422 is not accomplished.

**CONF 010
Config. 010 is valid for A318, A319 and A320 aircraft in the effectivity of this Service Bulletin on which:
- Modification No. 154484J3292 is embodied
and on which:
- Modification No. 155374K17141 is embodied or Service Bulletin No. A320-00-1260 is accomplished
OR
- Modification No. 34650P8752 is embodied or Service Bulletin No. A320-32-1308 is accomplished
OR
- Modification No. 152970J3375 is embodied or Service Bulletin No. A320-32-1422 is accomplished.



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

**CONF 011
Config. 011 is valid for A318, A319 and A320 aircraft in the effectivity of this Service Bulletin on which:
- Modification No. 35806J2705 or
- Modification No. 37332J2817 is embodied
and on which:
- Modification No. 155374K17141 is embodied or Service Bulletin No. A320-00-1260 is accomplished
OR
- Modification No. 34650P8752 is embodied or Service Bulletin No. A320-32-1308 is accomplished
OR
- Modification No. 152970J3375 is embodied or Service Bulletin No. A320-32-1422 is accomplished
OR
- Modification No. 155374K17141 is embodied or Service Bulletin No. A320-00-1260 is accomplished and
- Modification No. 152970J3375 is embodied or Service Bulletin No. A320-32-1422 is accomplished.

**CONF 012
Config. 012 is valid for A321 aircraft in the effectivity of this Service Bulletin on which:
- Modification No. 154484J3292 is embodied
and on which:
- Modification No. 155374K17141 is embodied or Service Bulletin No. A320-00-1260 is accomplished
- Modification No. 34650P8752 is embodied or Service Bulletin No. A320-32-1308 is accomplished
OR
- Modification No. 152970J3375 is embodied or Service Bulletin No. A320-32-1422 is accomplished.

**CONF 013
Config. 013 is valid for A318, A319 and A320 aircraft in the effectivity of this Service Bulletin on which:
- Modification No. 22688J0871 is embodied
- Modification No. 155374K17141 is embodied or Service Bulletin No. A320-00-1260 is accomplished
OR
- Modification No. 34650P8752 is embodied or Service Bulletin No. A320-32-1308 is accomplished
OR
- Modification No. 152970J3375 is embodied or Service Bulletin No. A320-32-1422 is accomplished
and on which:
- Modification No. 35806J2705 is not embodied.

**CONF 014
Config. 014 is valid for A321 aircraft in the effectivity of this Service Bulletin on which:
- Modification No. 155374K17141 is embodied or Service Bulletin No. A320-00-1260 is accomplished
and on which:
- Modification No. 37532J2815 is not embodied



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

OR
on which:
- Modification No. 34650P8752 is embodied or Service Bulletin No. A320-32-1308 is accomplished
and on which:
- Modification No. 37532J2815 is not embodied
OR
on which:
- Modification No. 152970J3375 is embodied or Service Bulletin No. A320-32-1422 is accomplished
and on which:
- Modification No. 37532J2815 is not embodied.

**CONF 015
Config. 015 is valid for A321 aircraft in the effectivity of this Service Bulletin on which:
- Modification No. 37532J2815 is embodied
- Modification No. 34650P8752 is embodied or Service Bulletin No. A320-32-1308 is accomplished
OR
- Modification No. 37532J2815 is embodied
- Modification No. 155374K17141 is embodied or Service Bulletin No. A320-00-1260 is accomplished
OR
- Modification No. 37532J2815 is embodied
- Modification No. 152970J3375 is embodied or Service Bulletin No. A320-32-1422 is accomplished
OR
- Modification No. 37532J2815 is embodied
- Modification No. 38617J2888 is embodied
- Modification No. 34650P8752 is embodied or Service Bulletin No. A320-32-1308 is accomplished
OR
- Modification No. 37532J2815 is embodied
- Modification No. 38617J2888 is embodied
- Modification No. 155374K17141 is embodied or Service Bulletin No. A320-00-1260 is accomplished
OR
- Modification No. 37532J2815 is embodied
- Modification No. 38617J2888 is embodied
- Modification No. 152970J3375 is embodied or Service Bulletin No. A320-32-1422 is accomplished.

**CONF 016
Config. 016 is valid for A318, A319 and A320 aircraft in the effectivity of this Service Bulletin on which:
- Modification No. 37331J2816 is embodied
- Modification No. 34650P8752 is embodied or Service Bulletin No. A320-32-1308 is accomplished
and on which:
- Modification No. 154484J3292 is not embodied
OR
- Modification No. 37331J2816 is embodied



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

- Modification No. 152970J3375 is embodied or Service Bulletin No. A320-32-1422 is accomplished
and on which:
- Modification No. 154484J3292 is not embodied
OR
- Modification No. 37331J2816 is embodied
- Modification No. 155374K17141 is embodied or Service Bulletin No. A320-00-1260 is accomplished
and on which:
- Modification No. 154484J3292 is not embodied.

**CONF 017
Config. 017 is valid for A321 aircraft in the effectivity of this Service Bulletin on which:
- Modification No. 38616J2887 is embodied
- Modification No. 34650P8752 is embodied or Service Bulletin No. A320-32-1308 is accomplished
and on which:
- Modification No. 154484J3292 is not embodied
OR
- Modification No. 38616J2887 is embodied
- Modification No. 152970J3375 is embodied or Service Bulletin No. A320-32-1422 is accomplished
and on which:
- Modification No. 154484J3292 is not embodied
OR
- Modification No. 38616J2887 is embodied
- Modification No. 155374K17141 is embodied or Service Bulletin No. A320-00-1260 is accomplished
and on which:
- Modification No. 154484J3292 is not embodied.

(6) Material Effectivity

****CONF 001**

| MATERIAL | QTY PER A/C | SEE NOTES |
|---|---|---|
| Kit 571208B01R03 | 1 | |
| Kit 571208B03R02 | 1 | |
| Kit 571208B06R02 | 1 | |
| Kit 571208B08R02 | 1 | |
| Kit 571208B17R03 | 1 | |
| Kit 571208B26R01 | 1 | |
| Kit 571208B29R02 | 1 | |
| Consumable CMLB01 | 1 | |

****CONF 002, 016**

| MATERIAL | QTY PER A/C | SEE NOTES |
|---|---|---|
| Kit 571208B02R01 | 1 | |
| Kit 571208B04R01 | 1 | |
| Kit 571208B07R01 | 1 | |



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

| MATERIAL | QTY PER A/C | SEE NOTES |
|---|---|---|
| Kit 571208B09R01 | 1 | |
| Kit 571208B18R01 | 1 | |
| Kit 571208B30R01 | 1 | |
| Consumable CMLB01 | 1 | |

****CONF 003, 010**

| MATERIAL | QTY PER A/C | SEE NOTES |
|---|---|---|
| Kit 571208B02R01 | 1 | |
| Kit 571208B04R01 | 1 | |
| Kit 571208B07R01 | 1 | |
| Kit 571208B10R01 | 1 | |
| Kit 571208B19R01 | 1 | |
| Kit 571208B30R01 | 1 | |
| Consumable CMLB01 | 1 | |

****CONF 004, 013**

| MATERIAL | QTY PER A/C | SEE NOTES |
|---|---|---|
| Kit 571208B02R01 | 1 | |
| Kit 571208B04R01 | 1 | |
| Kit 571208B07R01 | 1 | |
| Kit 571208B11R01 | 1 | |
| Kit 571208B20R01 | 1 | |
| Kit 571208B26R01 | 1 | |
| Kit 571208B30R01 | 1 | |
| Consumable CMLB01 | 1 | |

****CONF 005, 011**

| MATERIAL | QTY PER A/C | SEE NOTES |
|---|---|---|
| Kit 571208B02R01 | 1 | |
| Kit 571208B04R01 | 1 | |
| Kit 571208B07R01 | 1 | |
| Kit 571208B12R04 | 1 | |
| Kit 571208B21R03 | 1 | |
| Kit 571208B27R01 | 1 | |
| Kit 571208B30R01 | 1 | |
| Consumable CMLB01 | 1 | |

****CONF 006, 017**

| MATERIAL | QTY PER A/C | SEE NOTES |
|---|---|---|
| Kit 571208B02R01 | 1 | |
| Kit 571208B05R02 | 1 | |
| Kit 571208B07R01 | 1 | |
| Kit 571208B13R01 | 1 | |
| Kit 571208B22R01 | 1 | |



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

| MATERIAL | QTY PER A/C | SEE NOTES |
|---|---|---|
| Kit 571208B31R01 | 1 | |
| Consumable CMLB01 | 1 | |

****CONF 007, 012**

| MATERIAL | QTY PER A/C | SEE NOTES |
|---|---|---|
| Kit 571208B02R01 | 1 | |
| Kit 571208B05R02 | 1 | |
| Kit 571208B07R01 | 1 | |
| Kit 571208B14R01 | 1 | |
| Kit 571208B23R01 | 1 | |
| Kit 571208B31R01 | 1 | |
| Consumable CMLB01 | 1 | |

****CONF 008, 014**

| MATERIAL | QTY PER A/C | SEE NOTES |
|---|---|---|
| Kit 571208B02R01 | 1 | |
| Kit 571208B05R02 | 1 | |
| Kit 571208B07R01 | 1 | |
| Kit 571208B15R01 | 1 | |
| Kit 571208B24R01 | 1 | |
| Kit 571208B28R02 | 1 | |
| Kit 571208B31R01 | 1 | |
| Consumable CMLB01 | 1 | |

****CONF 009, 015**

| MATERIAL | QTY PER A/C | SEE NOTES |
|---|---|---|
| Kit 571208B02R01 | 1 | |
| Kit 571208B05R02 | 1 | |
| Kit 571208B07R01 | 1 | |
| Kit 571208B16R04 | 1 | |
| Kit 571208B25R03 | 1 | |
| Kit 571208B28R02 | 1 | |
| Kit 571208B31R01 | 1 | |
| Consumable CMLB01 | 1 | |

****CONF ALL**

**B. CONCURRENT REQUIREMENTS**

None



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

## C. REASON

(1) History

FAR26.21 requirements determine the necessity to have a solution to achieve the Limit of Validity (LoV) in all structures, to demonstrate wide spread fatigue damage is unlikely to occur. To delay the onset of WFD a structural modification is required allowing the aircraft to continue operations up to the LoV. Upper Cleat to Upper Stringer attachments, at Ribs 2-7 inclusive, are to have the fatigue life in the holes restored by oversizing to demonstrate the LoV can be achieved.

(2) Objective/Action

This Service Bulletin details the procedure to oversize affected fastener position holes through cleats and stringer webs, between ribs 2-7 inclusive. Pre and post mod holes are clearance fit.

This modification applies to all legacy A320 family aircraft (Pre-Mod 160001J3282/160021J3446), Forward Fit Sharklet modification embodiment (Post-Mod 160001J3282/160021J3446 and Pre-Mod 161139J3572/161345J3834) and In-Service Retrofitted Sharklet Aircraft (Post-Mod 160080J3705).

The operator must always use the CONFIG definitions to identify the correct CONFIG for their MSN, not the CONFIG dictated by the MSN allocation shown in the Service Bulletin.

(3) Advantages

Original design intent will be restored.

(4) Operational/Maintenance Consequences

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

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

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

AIRBUS disclaims any liability for the effect which the Service Bulletin may have on repairs performed on the aircraft before embodiment of the Service Bulletin.

If the post Service Bulletin repair status is not covered by the SRM and for repairs outside of the SRM covered by an RAS issued by AIRBUS, AIRBUS Customer Services Repair Engineering Support department should be contacted. Repair review will be done by AIRBUS at conditions of the Customer Services Catalogue.



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

## D. DESCRIPTION

To accomplish this Service Bulletin it is necessary to :

****CONF 001**

Task 571208-831-895-001: Modification

(1) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH

(2) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH

(3) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH

(4) Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH

(5) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH

(6) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH

(7) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH

(8) Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH

(9) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH

(10) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH

(11) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH

(12) Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH

(13) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH

(14) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH

(15) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH

(16) Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH

(17) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH

(18) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH

(19) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH

(20) Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH

(21) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH



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

(22) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH

(23) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH

(24) Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH

(25) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH

(26) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH

(27) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH

(28) Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH

(29) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH

(30) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH

(31) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH

(32) Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH

(33) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH

(34) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH

(35) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH

(36) Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH

(37) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH

(38) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH

(39) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH

(40) Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH

(41) Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH

(42) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH

(43) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH

(44) Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH

(45) Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH



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

(46) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH

(47) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH

(48) Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH

(49) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH

(50) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH

(51) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH

(52) Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH

(53) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH

(54) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH

(55) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH

(56) Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH

(57) Replace the LP Fuel Filters

****CONF 002**

Task 571208-831-895-001: Modification

(1) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH

(2) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH

(3) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH

(4) Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH

(5) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH

(6) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH

(7) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH

(8) Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH

(9) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH

(10) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH

(11) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer



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

Webs RIB 3 LH

(12) Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH

(13) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH

(14) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH

(15) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH

(16) Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH

(17) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH

(18) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH

(19) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH

(20) Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH

(21) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH

(22) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH

(23) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH

(24) Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH

(25) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH

(26) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH

(27) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH

(28) Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH

(29) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH

(30) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH

(31) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH

(32) Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH

(33) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH

(34) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH

(35) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer



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

Webs RIB 6 LH

(36) Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH

(37) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH

(38) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH

(39) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH

(40) Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH

(41) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH

(42) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH

(43) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH

(44) Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH

(45) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH

(46) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH

(47) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH

(48) Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH

(49) Replace the LP Fuel Filters

****CONF 003**

Task 571208-831-895-001: Modification

(1) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH

(2) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH

(3) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH

(4) Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH

(5) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH

(6) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH

(7) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH

(8) Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH



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

(9) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH

(10) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH

(11) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH

(12) Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH

(13) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH

(14) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH

(15) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH

(16) Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH

(17) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH

(18) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH

(19) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH

(20) Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH

(21) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH

(22) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH

(23) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH

(24) Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH

(25) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH

(26) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH

(27) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH

(28) Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH

(29) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH

(30) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH

(31) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH

(32) Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH



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

(33) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH

(34) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH

(35) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH

(36) Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH

(37) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH

(38) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH

(39) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH

(40) Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH

(41) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH

(42) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH

(43) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH

(44) Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH

(45) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH

(46) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH

(47) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH

(48) Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH

(49) Replace the LP Fuel Filters

****CONF 004**

Task 571208-831-895-001: Modification

(1) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH

(2) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH

(3) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH

(4) Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH

(5) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH

(6) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH



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

(7) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH

(8) Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH

(9) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH

(10) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH

(11) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH

(12) Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH

(13) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH

(14) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH

(15) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH

(16) Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH

(17) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH

(18) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH

(19) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH

(20) Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH

(21) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH

(22) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH

(23) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH

(24) Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH

(25) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH

(26) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH

(27) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH

(28) Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH

(29) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH

(30) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH



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

(31) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH

(32) Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH

(33) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH

(34) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH

(35) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH

(36) Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH

(37) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH

(38) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH

(39) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH

(40) Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH

(41) Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH

(42) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH

(43) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH

(44) Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH

(45) Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH

(46) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH

(47) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH

(48) Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH

(49) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH

(50) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH

(51) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH

(52) Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH

(53) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH

(54) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH



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

(55) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH

(56) Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH

(57) Replace the LP Fuel Filters

****CONF 005**

Task 571208-831-895-001: Modification

(1) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH

(2) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH

(3) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH

(4) Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH

(5) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH

(6) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH

(7) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH

(8) Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH

(9) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH

(10) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH

(11) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH

(12) Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH

(13) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH

(14) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH

(15) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH

(16) Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH

(17) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH

(18) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH

(19) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH



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

(20) Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH

(21) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH

(22) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH

(23) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH

(24) Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH

(25) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH

(26) Oversize the Holes of the Metallic Packer Rib 5 LH (On Bench)

(27) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH

(28) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH

(29) Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH

(30) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH

(31) Oversize the Fastener Holes of the Metallic Packer Rib 5 RH (On Bench)

(32) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH

(33) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH

(34) Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH

(35) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH

(36) Oversize the Fastener Holes of the Metallic Packer Rib 6 LH (On Bench)

(37) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH

(38) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH

(39) Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH

(40) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH

(41) Oversize the Fastener Holes of the Metallic Packer Rib 6 RH (On Bench)

(42) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH

(43) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH

(44) Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH



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

(45) Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH

(46) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH

(47) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH

(48) Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH

(49) Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH

(50) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH

(51) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH

(52) Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH

(53) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH

(54) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH

(55) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH

(56) Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH

(57) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH

(58) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH

(59) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH

(60) Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH

(61) Replace the LP Fuel Filters

****CONF 006**

Task 571208-831-895-001: Modification

(1) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH

(2) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH

(3) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH

(4) Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH

(5) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH

(6) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH



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

(7) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH

(8) Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH

(9) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH

(10) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH

(11) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH

(12) Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH

(13) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH

(14) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH

(15) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH

(16) Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH

(17) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH

(18) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH

(19) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH

(20) Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH

(21) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH

(22) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH

(23) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH

(24) Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH

(25) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH

(26) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH

(27) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH

(28) Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH

(29) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH

(30) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH



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

(31) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH

(32) Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH

(33) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH

(34) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH

(35) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH

(36) Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH

(37) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH

(38) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH

(39) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH

(40) Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH

(41) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH

(42) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH

(43) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH

(44) Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH

(45) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH

(46) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH

(47) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH

(48) Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH

(49) Replace the LP Fuel Filters

****CONF 007**

Task 571208-831-895-001: Modification

(1) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH

(2) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH

(3) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH



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

(4) Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH

(5) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH

(6) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH

(7) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH

(8) Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH

(9) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH

(10) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH

(11) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH

(12) Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH

(13) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH

(14) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH

(15) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH

(16) Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH

(17) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH

(18) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH

(19) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH

(20) Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH

(21) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH

(22) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH

(23) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH

(24) Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH

(25) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH

(26) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH

(27) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH



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

(28) Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH

(29) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH

(30) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH

(31) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH

(32) Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH

(33) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH

(34) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH

(35) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH

(36) Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH

(37) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH

(38) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH

(39) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH

(40) Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH

(41) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH

(42) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH

(43) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH

(44) Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH

(45) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH

(46) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH

(47) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH

(48) Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH

(49) Replace the LP Fuel Filters

****CONF 008**

Task 571208-831-895-001: Modification

(1) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH



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

(2) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH

(3) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH

(4) Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH

(5) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH

(6) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH

(7) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH

(8) Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH

(9) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH

(10) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH

(11) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH

(12) Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH

(13) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH

(14) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH

(15) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH

(16) Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH

(17) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH

(18) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH

(19) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH

(20) Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH

(21) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH

(22) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH

(23) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH

(24) Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH

(25) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH



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

(26) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH

(27) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH

(28) Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH

(29) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH

(30) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH

(31) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH

(32) Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH

(33) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH

(34) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH

(35) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH

(36) Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH

(37) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH

(38) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH

(39) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH

(40) Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH

(41) Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH

(42) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH

(43) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH

(44) Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH

(45) Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH

(46) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH

(47) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH

(48) Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH

(49) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH



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

(50) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH

(51) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH

(52) Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH

(53) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH

(54) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH

(55) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH

(56) Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH

(57) Replace the LP Fuel Filters

****CONF 009**

Task 571208-831-895-001: Modification

(1) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH

(2) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH

(3) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH

(4) Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH

(5) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH

(6) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH

(7) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH

(8) Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH

(9) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH

(10) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH

(11) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH

(12) Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH

(13) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH

(14) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH

(15) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer



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

Webs RIB 3 RH

(16) Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH

(17) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH

(18) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH

(19) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH

(20) Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH

(21) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH

(22) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH

(23) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH

(24) Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH

(25) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH

(26) Oversize the Holes of the Metallic Packer Rib 5 LH (On Bench)

(27) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH

(28) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH

(29) Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH

(30) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH

(31) Oversize the Fastener Holes of the Metallic Packer Rib 5 RH (On Bench)

(32) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH

(33) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH

(34) Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH

(35) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH

(36) Oversize the Fastener Holes of the Metallic Packer Rib 6 LH (On Bench)

(37) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH

(38) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH

(39) Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH



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

(40) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH

(41) Oversize the Fastener Holes of the Metallic Packer Rib 6 RH (On Bench)

(42) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH

(43) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH

(44) Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH

(45) Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH

(46) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH

(47) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH

(48) Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH

(49) Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH

(50) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH

(51) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH

(52) Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH

(53) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH

(54) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH

(55) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH

(56) Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH

(57) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH

(58) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH

(59) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH

(60) Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH

(61) Replace the LP Fuel Filters

****CONF 010**

Task 571208-831-895-001: Modification

(1) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH



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

(2) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH

(3) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH

(4) Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH

(5) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH

(6) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH

(7) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH

(8) Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH

(9) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH

(10) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH

(11) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH

(12) Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH

(13) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH

(14) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH

(15) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH

(16) Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH

(17) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH

(18) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH

(19) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH

(20) Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH

(21) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH

(22) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH

(23) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH

(24) Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH

(25) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH



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

(26) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH

(27) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH

(28) Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH

(29) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH

(30) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH

(31) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH

(32) Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH

(33) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH

(34) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH

(35) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH

(36) Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH

(37) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH

(38) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH

(39) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH

(40) Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH

(41) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH

(42) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH

(43) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH

(44) Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH

(45) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH

(46) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH

(47) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH

(48) Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH

(49) Replace the LP Fuel Filters



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

**CONF 011

Task 571208-831-895-001: Modification

(1) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH

(2) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH

(3) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH

(4) Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH

(5) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH

(6) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH

(7) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH

(8) Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH

(9) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH

(10) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH

(11) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH

(12) Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH

(13) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH

(14) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH

(15) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH

(16) Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH

(17) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH

(18) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH

(19) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH

(20) Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH

(21) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH

(22) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH

(23) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer



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

Webs RIB 4 RH

(24) Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH

(25) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH

(26) Oversize the Holes of the Metallic Packer Rib 5 LH (On Bench)

(27) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH

(28) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH

(29) Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH

(30) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH

(31) Oversize the Fastener Holes of the Metallic Packer Rib 5 RH (On Bench)

(32) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH

(33) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH

(34) Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH

(35) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH

(36) Oversize the Fastener Holes of the Metallic Packer Rib 6 LH (On Bench)

(37) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH

(38) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH

(39) Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH

(40) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH

(41) Oversize the Fastener Holes of the Metallic Packer Rib 6 RH (On Bench)

(42) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH

(43) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH

(44) Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH

(45) Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH

(46) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH

(47) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH



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

(48) Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH

(49) Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH

(50) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH

(51) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH

(52) Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH

(53) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH

(54) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH

(55) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH

(56) Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH

(57) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH

(58) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH

(59) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH

(60) Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH

(61) Replace the LP Fuel Filters

****CONF 012**

Task 571208-831-895-001: Modification

(1) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH

(2) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH

(3) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH

(4) Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH

(5) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH

(6) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH

(7) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH

(8) Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH

(9) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH



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

(10) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH

(11) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH

(12) Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH

(13) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH

(14) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH

(15) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH

(16) Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH

(17) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH

(18) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH

(19) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH

(20) Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH

(21) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH

(22) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH

(23) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH

(24) Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH

(25) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH

(26) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH

(27) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH

(28) Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH

(29) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH

(30) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH

(31) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH

(32) Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH

(33) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH



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

(34) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH

(35) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH

(36) Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH

(37) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH

(38) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH

(39) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH

(40) Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH

(41) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH

(42) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH

(43) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH

(44) Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH

(45) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH

(46) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH

(47) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH

(48) Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH

(49) Replace the LP Fuel Filters

****CONF 013**

Task 571208-831-895-001: Modification

(1) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH

(2) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH

(3) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH

(4) Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH

(5) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH

(6) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH

(7) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer



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

Webs RIB 2 RH

(8) Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH

(9) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH

(10) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH

(11) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH

(12) Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH

(13) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH

(14) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH

(15) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH

(16) Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH

(17) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH

(18) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH

(19) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH

(20) Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH

(21) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH

(22) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH

(23) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH

(24) Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH

(25) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH

(26) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH

(27) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH

(28) Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH

(29) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH

(30) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH

(31) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer



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

Webs RIB 5 RH

(32) Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH

(33) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH

(34) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH

(35) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH

(36) Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH

(37) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH

(38) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH

(39) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH

(40) Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH

(41) Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH

(42) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH

(43) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH

(44) Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH

(45) Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH

(46) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH

(47) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH

(48) Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH

(49) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH

(50) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH

(51) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH

(52) Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH

(53) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH

(54) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH

(55) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer



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

Webs RIB 7 RH

(56) Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH

(57) Replace the LP Fuel Filters

****CONF 014**

Task 571208-831-895-001: Modification

(1) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH

(2) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH

(3) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH

(4) Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH

(5) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH

(6) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH

(7) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH

(8) Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH

(9) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH

(10) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH

(11) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH

(12) Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH

(13) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH

(14) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH

(15) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH

(16) Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH

(17) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH

(18) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH

(19) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH

(20) Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH



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

(21) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH

(22) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH

(23) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH

(24) Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH

(25) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH

(26) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH

(27) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH

(28) Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH

(29) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH

(30) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH

(31) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH

(32) Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH

(33) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH

(34) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH

(35) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH

(36) Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH

(37) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH

(38) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH

(39) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH

(40) Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH

(41) Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH

(42) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH

(43) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH

(44) Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH



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

(45) Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH

(46) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH

(47) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH

(48) Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH

(49) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH

(50) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH

(51) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH

(52) Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH

(53) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH

(54) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH

(55) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH

(56) Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH

(57) Replace the LP Fuel Filters

****CONF 015**

Task 571208-831-895-001: Modification

(1) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH

(2) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH

(3) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH

(4) Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH

(5) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH

(6) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH

(7) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH

(8) Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH

(9) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH

(10) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH



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

(11) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH

(12) Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH

(13) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH

(14) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH

(15) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH

(16) Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH

(17) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH

(18) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH

(19) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH

(20) Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH

(21) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH

(22) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH

(23) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH

(24) Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH

(25) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH

(26) Oversize the Holes of the Metallic Packer Rib 5 LH (On Bench)

(27) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH

(28) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH

(29) Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH

(30) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH

(31) Oversize the Fastener Holes of the Metallic Packer Rib 5 RH (On Bench)

(32) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH

(33) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH

(34) Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH



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

(35) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH

(36) Oversize the Fastener Holes of the Metallic Packer Rib 6 LH (On Bench)

(37) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH

(38) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH

(39) Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH

(40) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH

(41) Oversize the Fastener Holes of the Metallic Packer Rib 6 RH (On Bench)

(42) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH

(43) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH

(44) Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH

(45) Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH

(46) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH

(47) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH

(48) Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH

(49) Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH

(50) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH

(51) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH

(52) Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH

(53) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH

(54) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH

(55) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH

(56) Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH

(57) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH

(58) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH

(59) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer



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

Webs RIB 7 RH

(60) Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH

(61) Replace the LP Fuel Filters

****CONF 016**

Task 571208-831-895-001: Modification

(1) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH

(2) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH

(3) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH

(4) Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH

(5) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH

(6) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH

(7) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH

(8) Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH

(9) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH

(10) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH

(11) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH

(12) Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH

(13) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH

(14) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH

(15) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH

(16) Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH

(17) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH

(18) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH

(19) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH

(20) Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH



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

(21) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH

(22) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH

(23) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH

(24) Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH

(25) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH

(26) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH

(27) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH

(28) Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH

(29) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH

(30) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH

(31) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH

(32) Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH

(33) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH

(34) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH

(35) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH

(36) Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH

(37) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH

(38) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH

(39) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH

(40) Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH

(41) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH

(42) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH

(43) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH

(44) Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH



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

(45) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH

(46) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH

(47) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH

(48) Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH

(49) Replace the LP Fuel Filters

****CONF 017**

Task 571208-831-895-001: Modification

(1) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH

(2) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH

(3) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH

(4) Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH

(5) Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH

(6) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH

(7) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH

(8) Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH

(9) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH

(10) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH

(11) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH

(12) Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH

(13) Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH

(14) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH

(15) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH

(16) Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH

(17) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH

(18) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH



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

(19) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH

(20) Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH

(21) Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH

(22) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH

(23) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH

(24) Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH

(25) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH

(26) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH

(27) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH

(28) Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH

(29) Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH

(30) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH

(31) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH

(32) Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH

(33) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH

(34) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH

(35) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH

(36) Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH

(37) Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH

(38) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH

(39) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH

(40) Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH

(41) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH

(42) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH



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

(43) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH

(44) Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH

(45) Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH

(46) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH

(47) Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH

(48) Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH

(49) Replace the LP Fuel Filters

****CONF ALL**

## E. COMPLIANCE

(1) Classification

MANDATORY: Service Bulletin must be accomplished.

(2) Accomplishment Timescale

****CONF 001 thru 005**

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

This Service Bulletin must be accomplished before the Structural Modification Point (upper limits of the Window of Embodiment (WoE)) and not before the earliest embodiment point (lower limits of the WoE) given below, whichever occurs first between Flight Cycles (FC) and Flying Hours (FH) from Entry Into Service (EIS):

NOTE: If your aircraft is in this configuration and you have or are transferring to CIS and accomplishing one or more of the Service Bulletins, A320-00-1260, A320-32-1308 or A320-32-1422, the embodiment of this modification should be completed by the timescales (Flight Cycles (FC) or Flight Hours (FH)) contained in Config. 010, 011, 013 or 016 for legacy aircraft. The Modification kit and work instructions for Config. 001 thru 005 are still applicable.

| Aircraft | Window of Embodiment | | Modification Applicability |
|---|---|---|---|
| | Flight Cycles (FC) | Flying Hours (FH) | |
| A318-100 | 47000 - 79600 | 94000 - 159200 | LEGACY, PRE-MOD 160001 |
| A319-100 | 47000 - 79600 | 94000 - 159200 | |
| A320-200 | 47000 - 79600 | 94000 - 159200 | |



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

| Aircraft | Window of Embodiment | | Modification Applicability |
|---|---|---|---|
| | Flight Cycles (FC) | Flying Hours (FH) | |
| A319-100 | 26200 - 50800 | 52300 - 101600 | SHARKLET FORWARD FIT, POST-MOD 160001 |
| A320-200 | 26200 - 50800 | 52300 - 101600 | |
| A320-200<br>A319-100 | 26200 - 50800 | 52300 - 101600 | SHARKLET RETROFIT, POST-MOD 160080 |

****CONF 006 thru 009**

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

This Service Bulletin must be accomplished before the Structural Modification Point (upper limits of the Window of Embodiment (WoE)) and not before the earliest embodiment point (lower limits of the WoE) given below, whichever occurs first between Flight Cycles (FC) and Flying Hours (FH) from Entry Into Service (EIS):

| Aircraft | Window of Embodiment | | Modification Applicability |
|---|---|---|---|
| | Flight Cycles (FC) | Flying Hours (FH) | |
| A321-100/200 | 50600 - 74100 | 101200 - 148300 | LEGACY, PRE-MOD 160021 |
| A321-200 | 22400 - 56400 | 44800 - 112800 | SHARKLET FORWARD FIT, POST-MOD 160021 |

****CONF 010 thru 011, 013, 016**

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

This Service Bulletin must be accomplished before the Structural Modification Point (upper limits of the Window of Embodiment (WoE)) and not before the earliest embodiment point (lower limits of the WoE) given below, whichever occurs first between Flight Cycles (FC) and Flying Hours (FH) from Entry Into Service (EIS):

| Aircraft | Window of Embodiment | | Modification Applicability |
|---|---|---|---|
| | Flight Cycles (FC) | Flying Hours (FH) | |
| A319-100 | 47000 - 79600 | 93900 - 159200 | LEGACY, PRE-MOD 160001 |
| A320-200 | 58200 - 62800 | 116300 - 125600 | |
| A319-100 | 26100 - 50900 | 52100 - 101800 | SHARKLET FORWARD FIT, POST-MOD 160001 |
| A320-200 | 33300 - 40100 | 66500 - 80300 | |



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

| Aircraft | Window of Embodiment | | Modification Applicability |
|---|---|---|---|
| | Flight Cycles (FC) | Flying Hours (FH) | |
| A319-100 | 26200 - 50800 | 52300 - 101600 | SHARKLET RETROFIT, POST-MOD 160080 |
| A320-200 | 33300 - 40000 | 66600 - 80100 | |

****CONF 012, 014 thru 015, 017**

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

This Service Bulletin must be accomplished before the Structural Modification Point (upper limits of the Window of Embodiment (WoE)) and not before the earliest embodiment point (lower limits of the WoE) given below, whichever occurs first between Flight Cycles (FC) and Flying Hours (FH) from Entry Into Service (EIS):

| Aircraft | Window of Embodiment | | Modification Applicability |
|---|---|---|---|
| | Flight Cycles (FC) | Flying Hours (FH) | |
| A321-100/200 | 38000 - 46700 | 76000 - 93400 | LEGACY, PRE-MOD 160021 |
| A321-200 | 30600 - 35500 | 61100 - 71000 | SHARKLET FORWARD FIT, POST-MOD 160021 |

****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 571208-831-895-001: Modification | |
|---|---|
| Get Access | 1.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| **On Aircraft** | |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH | 2.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH | 0.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Replace the LP Fuel Filters | 1.00 |
| **On Bench** | |
| Tests | 1.00 |
| Close-Up | 1.50 |
| TOTAL MANHOURS | 125.00 |
| ELAPSED TIME (HOURS) | 34.50 |

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

****CONF 002**

| Task 571208-831-895-001: Modification | |
|---|---|
| Get Access | 1.50 |
| **On Aircraft** | |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH | 3.00 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH | 2.00 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Replace the LP Fuel Filters | 1.00 |
| **On Bench** | |
| Tests | 1.00 |
| Close-Up | 1.50 |
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

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

****CONF 003**

| Task 571208-831-895-001: Modification | |
|---|---|
| Get Access | 1.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| **On Aircraft** | |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH | 2.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH | 2.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Replace the LP Fuel Filters | 1.00 |
| **On Bench** | |
| Tests | 1.00 |
| Close-Up | 1.50 |
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

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

****CONF 004**

| Task 571208-831-895-001: Modification | |
|---|---|
| Get Access | 1.50 |
| **On Aircraft** | |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH | 2.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH | 2.00 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Replace the LP Fuel Filters | 1.00 |
| **On Bench** | |
| Tests | 1.00 |
| Close-Up | 1.50 |
| TOTAL MANHOURS | 125.00 |
| ELAPSED TIME (HOURS) | 34.50 |

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

****CONF 005**

| Task 571208-831-895-001: Modification | |
|---|---|
| Get Access | 1.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| **On Aircraft** | |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH | 2.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH | 0.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Replace the LP Fuel Filters | 1.00 |
| **On Bench** | |
| Oversize the Holes of the Metallic Packer Rib 5 LH (On Bench) | 0.50 |
| Oversize the Fastener Holes of the Metallic Packer Rib 5 RH (On Bench) | 0.50 |
| Oversize the Fastener Holes of the Metallic Packer Rib 6 LH (On Bench) | 0.50 |
| Oversize the Fastener Holes of the Metallic Packer Rib 6 RH (On Bench) | 0.50 |
| Tests | 1.00 |
| Close-Up | 1.50 |
| TOTAL MANHOURS | 127.00 |
| ELAPSED TIME (HOURS) | 35.50 |

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

****CONF 006**

| Task 571208-831-895-001: Modification | |
|---|---|
| Get Access | 1.50 |
| **On Aircraft** | |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH | 3.00 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH | 2.00 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Replace the LP Fuel Filters | 1.00 |
| **On Bench** | |
| Tests | 1.00 |
| Close-Up | 1.50 |
| TOTAL MANHOURS | 121.00 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| ELAPSED TIME (HOURS) | 33.50 |

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

****CONF 007**

| Task 571208-831-895-001: Modification | |
|---|---|
| Get Access | 1.50 |
| **On Aircraft** | |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH | 2.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH | 2.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Replace the LP Fuel Filters | 1.00 |
| **On Bench** | |
| Tests | 1.00 |
| Close-Up | 1.50 |
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

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

****CONF 008**

| Task 571208-831-895-001: Modification | |
|---|---|
| Get Access | 1.50 |
| **On Aircraft** | |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH | 2.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH | 2.00 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Replace the LP Fuel Filters | 1.00 |
| **On Bench** | |
| Tests | 1.00 |
| Close-Up | 1.50 |
| TOTAL MANHOURS | 125.00 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| ELAPSED TIME (HOURS) | 34.50 |

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

****CONF 009**

| Task 571208-831-895-001: Modification | |
|---|---|
| Get Access | 1.50 |
| **On Aircraft** | |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH | 2.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH | 0.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Replace the LP Fuel Filters | 1.00 |
| **On Bench** | |
| Oversize the Holes of the Metallic Packer Rib 5 LH (On Bench) | 0.50 |
| Oversize the Fastener Holes of the Metallic Packer Rib 5 RH (On Bench) | 0.50 |
| Oversize the Fastener Holes of the Metallic Packer Rib 6 LH (On Bench) | 0.50 |
| Oversize the Fastener Holes of the Metallic Packer Rib 6 RH (On Bench) | 0.50 |
| Tests | 1.00 |
| Close-Up | 1.50 |
| TOTAL MANHOURS | 127.00 |
| ELAPSED TIME (HOURS) | 35.50 |

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



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

**CONF 010

| Task 571208-831-895-001: Modification | |
|---|---|
| Get Access | 1.50 |
| **On Aircraft** | |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH | 2.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH | 2.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Replace the LP Fuel Filters | 1.00 |
| **On Bench** | |
| Tests | 1.00 |
| Close-Up | 1.50 |
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

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

****CONF 011**

| Task 571208-831-895-001: Modification | |
|---|---|
| Get Access | 1.50 |
| **On Aircraft** | |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH | 2.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH | 2.00 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Replace the LP Fuel Filters | 1.00 |
| **On Bench** | |
| Oversize the Holes of the Metallic Packer Rib 5 LH (On Bench) | 0.50 |
| Oversize the Fastener Holes of the Metallic Packer Rib 5 RH (On Bench) | 0.50 |
| Oversize the Fastener Holes of the Metallic Packer Rib 6 LH (On Bench) | 0.50 |
| Oversize the Fastener Holes of the Metallic Packer Rib 6 RH (On Bench) | 0.50 |
| Tests | 1.00 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Close-Up | 1.50 |
| TOTAL MANHOURS | 127.00 |
| ELAPSED TIME (HOURS) | 35.50 |

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

****CONF 012**

| Task 571208-831-895-001: Modification | |
|---|---|
| Get Access | 1.50 |
| **On Aircraft** | |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH | 2.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH | 2.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Replace the LP Fuel Filters | 1.00 |
| **On Bench** | |
| Tests | 1.00 |
| Close-Up | 1.50 |
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

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

****CONF 013**

| Task 571208-831-895-001: Modification | |
|---|---|
| Get Access | 1.50 |
| **On Aircraft** | |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH | 2.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH | 2.00 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Replace the LP Fuel Filters | 1.00 |
| **On Bench** | |
| Tests | 1.00 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Close-Up | 1.50 |
| TOTAL MANHOURS | 125.00 |
| ELAPSED TIME (HOURS) | 34.50 |

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

****CONF 014**

| Task 571208-831-895-001: Modification | |
|---|---|
| Get Access | 1.50 |
| **On Aircraft** | |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH | 2.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH | 0.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Replace the LP Fuel Filters | 1.00 |
| **On Bench** | |
| Tests | 1.00 |
| Close-Up | 1.50 |
| TOTAL MANHOURS | 125.00 |
| ELAPSED TIME (HOURS) | 34.50 |

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

****CONF 015**

| Task 571208-831-895-001: Modification | |
|---|---|
| Get Access | 1.50 |
| **On Aircraft** | |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH | 3.00 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH | 2.00 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH | 0.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH | 0.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH | 2.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Replace the LP Fuel Filters | 1.00 |
| **On Bench** | |
| Oversize the Holes of the Metallic Packer Rib 5 LH (On Bench) | 0.50 |
| Oversize the Fastener Holes of the Metallic Packer Rib 5 RH (On Bench) | 0.50 |
| Oversize the Fastener Holes of the Metallic Packer Rib 6 LH (On Bench) | 0.50 |
| Oversize the Fastener Holes of the Metallic Packer Rib 6 RH (On Bench) | 0.50 |
| Tests | 1.00 |
| Close-Up | 1.50 |
| TOTAL MANHOURS | 127.00 |
| ELAPSED TIME (HOURS) | 35.50 |

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

****CONF 016**

| Task 571208-831-895-001: Modification | |
|---|---|
| Get Access | 1.50 |
| **On Aircraft** | |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH | 3.00 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH | 2.00 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Replace the LP Fuel Filters | 1.00 |
| **On Bench** | |
| Tests | 1.00 |
| Close-Up | 1.50 |
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

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



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

**CONF 017

| Task 571208-831-895-001: Modification | |
|---|---|
| Get Access | 1.50 |
| **On Aircraft** | |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH | 3.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH | 2.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH | 2.00 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH | 2.50 |
| Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH | 2.50 |



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

| Task 571208-831-895-001: Modification | |
|---|---|
| Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH | 2.50 |
| Replace the LP Fuel Filters | 1.00 |
| **On Bench** | |
| Tests | 1.00 |
| Close-Up | 1.50 |
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

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

****CONF ALL**

## H. WEIGHT AND BALANCE

****CONF 001 thru 005**

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

A318-100

| | | |
|---|---|---|
| Manufacturer's Empty Weight | + 0.4 KG | (+ 0.9 LB) |
| Effect on Balance | + 6.3 KGM | (+ 45.6 LB.FT) |

A319-100

| | | |
|---|---|---|
| Manufacturer's Empty Weight | + 0.4 KG | (+ 0.9 LB) |
| Effect on Balance | + 6.6 KGM | (+ 47.7 LB.FT) |

A320-200

| | | |
|---|---|---|
| Manufacturer's Empty Weight | + 0.4 KG | (+ 0.9 LB) |
| Effect on Balance | + 7.2 KGM | (+ 52.1 LB.FT) |

****CONF 006 thru 009, 012, 014 thru 015, 017**

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

A321-100

| | | |
|---|---|---|
| Manufacturer's Empty Weight | + 0.4 KG | (+ 0.9 LB) |
| Effect on Balance | + 8.9 KGM | (+ 64.4 LB.FT) |

A321-200

| | | |
|---|---|---|
| Manufacturer's Empty Weight | + 0.4 KG | (+ 0.9 LB) |



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

| | | |
|---|---|---|
| Effect on Balance | + 8.9 KGM | (+ 64.4 LB.FT) |

**CONF 010 thru 011, 013, 016

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

| | | |
|---|---|---|
| A319-100 | | |
| Manufacturer's Empty Weight | + 0.4 KG | (+ 0.9 LB) |
| Effect on Balance | + 6.6 KGM | (+ 47.7 LB.FT) |
| A320-200 | | |
| Manufacturer's Empty Weight | + 0.4 KG | (+ 0.9 LB) |
| Effect on Balance | + 7.2 KGM | (+ 52.1 LB.FT) |

**CONF ALL

## I. ELECTRICAL LOAD DATA

Not Changed

## J. REFERENCES

**CONF 001

| | | | |
|---|---|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00<br>07-11-00<br>28-00-00<br>28-25-00<br>73-11-10 | 06-31-57<br>12-11-28<br>28-10-00<br>32-00-00<br>73-12-42 | 06-41-57<br>12-34-24<br>28-11-00<br>57-27-11 |
| Consumable Material List (CML) | | | |
| Elec. Std. Practices Manual (ESPM) | 20-55-00 | | |
| Non Destructive Test Manual (NTM) | 51-10-01 | | |
| Standards Manual (SM) | | | |
| Structural Repair Manual (SRM) | 51-23-11<br>51-42-00<br>51-44-00<br>51-75-12 | 51-23-12<br>51-42-11<br>51-44-11<br>51-76-12 | 51-40-00<br>51-43-00<br>51-49-00 |
| Weight and Balance Manual (WBM) | | | |

**CONF 002

| | | | |
|---|---|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00<br>07-11-00<br>28-00-00<br>28-25-00<br>73-11-10 | 06-31-57<br>12-11-28<br>28-10-00<br>32-00-00<br>73-12-42 | 06-41-57<br>12-34-24<br>28-11-00<br>57-27-11 |
| Consumable Material List (CML) | | | |
| Elec. Std. Practices Manual (ESPM) | 20-55-00 | | |
| Non Destructive Test Manual (NTM) | 51-10-01 | | |



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

| | |
|---|---|
| Standards Manual (SM) | |
| Structural Repair Manual (SRM) | 51-23-11 51-23-12 51-40-00<br>51-42-00 51-42-11 51-43-00<br>51-44-00 51-44-11 51-49-00<br>51-75-12 51-76-12 |
| Weight and Balance Manual (WBM) | |

****CONF 003**

| | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00 06-31-57 06-41-57<br>07-11-00 12-11-28 12-34-24<br>28-00-00 28-10-00 28-11-00<br>28-25-00 32-00-00 57-27-11<br>73-11-10 73-12-42 |
| Consumable Material List (CML) | |
| Elec. Std. Practices Manual (ESPM) | 20-55-00 |
| Non Destructive Test Manual (NTM) | 51-10-01 |
| Standards Manual (SM) | |
| Structural Repair Manual (SRM) | 51-23-11 51-23-12 51-40-00<br>51-42-00 51-42-11 51-43-00<br>51-44-00 51-44-11 51-49-00<br>51-75-12 51-76-12 |
| Weight and Balance Manual (WBM) | |

****CONF 004**

| | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00 06-31-57 06-41-57<br>07-11-00 12-11-28 12-34-24<br>28-00-00 28-10-00 28-11-00<br>28-25-00 32-00-00 57-27-11<br>73-11-10 73-12-42 |
| Consumable Material List (CML) | |
| Elec. Std. Practices Manual (ESPM) | 20-55-00 |
| Non Destructive Test Manual (NTM) | 51-10-01 |
| Standards Manual (SM) | |
| Structural Repair Manual (SRM) | 51-23-11 51-23-12 51-40-00<br>51-42-00 51-42-11 51-43-00<br>51-44-00 51-44-11 51-49-00<br>51-75-12 51-76-12 |
| Weight and Balance Manual (WBM) | |

****CONF 005**

| | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00 06-31-57 06-41-57<br>07-11-00 12-11-28 12-34-24<br>28-00-00 28-10-00 28-11-00<br>28-25-00 32-00-00 57-27-11<br>73-11-10 73-12-42 |
| Consumable Material List (CML) | |
| Elec. Std. Practices Manual (ESPM) | 20-55-00 |
| Non Destructive Test Manual (NTM) | 51-10-01 |
| Standards Manual (SM) | |



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

| | | | |
|---|---|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-42-00<br>51-44-00<br>51-75-12 | 51-23-12<br>51-42-11<br>51-44-11<br>51-76-12 | 51-40-00<br>51-43-00<br>51-49-00 |
| Weight and Balance Manual (WBM) | | | |

****CONF 006**

| | | | |
|---|---|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00<br>07-11-00<br>28-00-00<br>28-25-00<br>73-11-10 | 06-31-57<br>12-11-28<br>28-10-00<br>32-00-00<br>73-12-42 | 06-41-57<br>12-34-24<br>28-11-00<br>57-27-11 |
| Consumable Material List (CML) | | | |
| Elec. Std. Practices Manual (ESPM) | 20-55-00 | | |
| Non Destructive Test Manual (NTM) | 51-10-01 | | |
| Standards Manual (SM) | | | |
| Structural Repair Manual (SRM) | 51-23-11<br>51-42-00<br>51-44-00<br>51-75-12 | 51-23-12<br>51-42-11<br>51-44-11<br>51-76-12 | 51-40-00<br>51-43-00<br>51-49-00 |
| Weight and Balance Manual (WBM) | | | |

****CONF 007**

| | | | |
|---|---|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00<br>07-11-00<br>28-00-00<br>28-25-00<br>73-11-10 | 06-31-57<br>12-11-28<br>28-10-00<br>32-00-00<br>73-12-42 | 06-41-57<br>12-34-24<br>28-11-00<br>57-27-11 |
| Consumable Material List (CML) | | | |
| Elec. Std. Practices Manual (ESPM) | 20-55-00 | | |
| Non Destructive Test Manual (NTM) | 51-10-01 | | |
| Standards Manual (SM) | | | |
| Structural Repair Manual (SRM) | 51-23-11<br>51-42-00<br>51-44-00<br>51-75-12 | 51-23-12<br>51-42-11<br>51-44-11<br>51-76-12 | 51-40-00<br>51-43-00<br>51-49-00 |
| Weight and Balance Manual (WBM) | | | |

****CONF 008**

| | | | |
|---|---|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00<br>07-11-00<br>28-00-00<br>28-25-00<br>73-11-10 | 06-31-57<br>12-11-28<br>28-10-00<br>32-00-00<br>73-12-42 | 06-41-57<br>12-34-24<br>28-11-00<br>57-27-11 |
| Consumable Material List (CML) | | | |
| Elec. Std. Practices Manual (ESPM) | 20-55-00 | | |
| Non Destructive Test Manual (NTM) | 51-10-01 | | |
| Standards Manual (SM) | | | |



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

| | | | |
|---|---|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-42-00<br>51-44-00<br>51-75-12 | 51-23-12<br>51-42-11<br>51-44-11<br>51-76-12 | 51-40-00<br>51-43-00<br>51-49-00 |
| Weight and Balance Manual (WBM) | | | |

****CONF 009**

| | | | |
|---|---|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00<br>07-11-00<br>28-00-00<br>28-25-00<br>73-11-10 | 06-31-57<br>12-11-28<br>28-10-00<br>32-00-00<br>73-12-42 | 06-41-57<br>12-34-24<br>28-11-00<br>57-27-11 |
| Consumable Material List (CML) | | | |
| Elec. Std. Practices Manual (ESPM) | 20-55-00 | | |
| Non Destructive Test Manual (NTM) | 51-10-01 | | |
| Standards Manual (SM) | | | |
| Structural Repair Manual (SRM) | 51-23-11<br>51-42-00<br>51-44-00<br>51-75-12 | 51-23-12<br>51-42-11<br>51-44-11<br>51-76-12 | 51-40-00<br>51-43-00<br>51-49-00 |
| Weight and Balance Manual (WBM) | | | |

****CONF 010**

| | | | |
|---|---|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00<br>07-11-00<br>28-00-00<br>28-25-00<br>73-11-10 | 06-31-57<br>12-11-28<br>28-10-00<br>32-00-00<br>73-12-42 | 06-41-57<br>12-34-24<br>28-11-00<br>57-27-11 |
| Consumable Material List (CML) | | | |
| Elec. Std. Practices Manual (ESPM) | 20-55-00 | | |
| Non Destructive Test Manual (NTM) | 51-10-01 | | |
| Standards Manual (SM) | | | |
| Structural Repair Manual (SRM) | 51-23-11<br>51-42-00<br>51-44-00<br>51-75-12 | 51-23-12<br>51-42-11<br>51-44-11<br>51-76-12 | 51-40-00<br>51-43-00<br>51-49-00 |
| Weight and Balance Manual (WBM) | | | |

****CONF 011**

| | | | |
|---|---|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00<br>07-11-00<br>28-00-00<br>28-25-00<br>73-11-10 | 06-31-57<br>12-11-28<br>28-10-00<br>32-00-00<br>73-12-42 | 06-41-57<br>12-34-24<br>28-11-00<br>57-27-11 |
| Consumable Material List (CML) | | | |
| Elec. Std. Practices Manual (ESPM) | 20-55-00 | | |
| Non Destructive Test Manual (NTM) | 51-10-01 | | |
| Standards Manual (SM) | | | |



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

| | | | |
|---|---|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-42-00<br>51-44-00<br>51-75-12 | 51-23-12<br>51-42-11<br>51-44-11<br>51-76-12 | 51-40-00<br>51-43-00<br>51-49-00 |
| Weight and Balance Manual (WBM) | | | |

****CONF 012**

| | | | |
|---|---|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00<br>07-11-00<br>28-00-00<br>28-25-00<br>73-11-10 | 06-31-57<br>12-11-28<br>28-10-00<br>32-00-00<br>73-12-42 | 06-41-57<br>12-34-24<br>28-11-00<br>57-27-11 |
| Consumable Material List (CML) | | | |
| Elec. Std. Practices Manual (ESPM) | 20-55-00 | | |
| Non Destructive Test Manual (NTM) | 51-10-01 | | |
| Standards Manual (SM) | | | |
| Structural Repair Manual (SRM) | 51-23-11<br>51-42-00<br>51-44-00<br>51-75-12 | 51-23-12<br>51-42-11<br>51-44-11<br>51-76-12 | 51-40-00<br>51-43-00<br>51-49-00 |
| Weight and Balance Manual (WBM) | | | |

****CONF 013**

| | | | |
|---|---|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00<br>07-11-00<br>28-00-00<br>28-25-00<br>73-11-10 | 06-31-57<br>12-11-28<br>28-10-00<br>32-00-00<br>73-12-42 | 06-41-57<br>12-34-24<br>28-11-00<br>57-27-11 |
| Consumable Material List (CML) | | | |
| Elec. Std. Practices Manual (ESPM) | 20-55-00 | | |
| Non Destructive Test Manual (NTM) | 51-10-01 | | |
| Standards Manual (SM) | | | |
| Structural Repair Manual (SRM) | 51-23-11<br>51-42-00<br>51-44-00<br>51-75-12 | 51-23-12<br>51-42-11<br>51-44-11<br>51-76-12 | 51-40-00<br>51-43-00<br>51-49-00 |
| Weight and Balance Manual (WBM) | | | |

****CONF 014**

| | | | |
|---|---|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00<br>07-11-00<br>28-00-00<br>28-25-00<br>73-11-10 | 06-31-57<br>12-11-28<br>28-10-00<br>32-00-00<br>73-12-42 | 06-41-57<br>12-34-24<br>28-11-00<br>57-27-11 |
| Consumable Material List (CML) | | | |
| Elec. Std. Practices Manual (ESPM) | 20-55-00 | | |
| Non Destructive Test Manual (NTM) | 51-10-01 | | |
| Standards Manual (SM) | | | |



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

| | | | |
|---|---|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-42-00<br>51-44-00<br>51-75-12 | 51-23-12<br>51-42-11<br>51-44-11<br>51-76-12 | 51-40-00<br>51-43-00<br>51-49-00 |
| Weight and Balance Manual (WBM) | | | |

****CONF 015**

| | | | |
|---|---|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00<br>07-11-00<br>28-00-00<br>28-25-00<br>73-11-10 | 06-31-57<br>12-11-28<br>28-10-00<br>32-00-00<br>73-12-42 | 06-41-57<br>12-34-24<br>28-11-00<br>57-27-11 |
| Consumable Material List (CML) | | | |
| Elec. Std. Practices Manual (ESPM) | 20-55-00 | | |
| Non Destructive Test Manual (NTM) | 51-10-01 | | |
| Standards Manual (SM) | | | |
| Structural Repair Manual (SRM) | 51-23-11<br>51-42-00<br>51-44-00<br>51-75-12 | 51-23-12<br>51-42-11<br>51-44-11<br>51-76-12 | 51-40-00<br>51-43-00<br>51-49-00 |
| Weight and Balance Manual (WBM) | | | |

****CONF 016**

| | | | |
|---|---|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00<br>07-11-00<br>28-00-00<br>28-25-00<br>73-11-10 | 06-31-57<br>12-11-28<br>28-10-00<br>32-00-00<br>73-12-42 | 06-41-57<br>12-34-24<br>28-11-00<br>57-27-11 |
| Consumable Material List (CML) | | | |
| Elec. Std. Practices Manual (ESPM) | 20-55-00 | | |
| Non Destructive Test Manual (NTM) | 51-10-01 | | |
| Standards Manual (SM) | | | |
| Structural Repair Manual (SRM) | 51-23-11<br>51-42-00<br>51-44-00<br>51-75-12 | 51-23-12<br>51-42-11<br>51-44-11<br>51-76-12 | 51-40-00<br>51-43-00<br>51-49-00 |
| Weight and Balance Manual (WBM) | | | |

****CONF 017**

| | | | |
|---|---|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00<br>07-11-00<br>28-00-00<br>28-25-00<br>73-11-10 | 06-31-57<br>12-11-28<br>28-10-00<br>32-00-00<br>73-12-42 | 06-41-57<br>12-34-24<br>28-11-00<br>57-27-11 |
| Consumable Material List (CML) | | | |
| Elec. Std. Practices Manual (ESPM) | 20-55-00 | | |
| Non Destructive Test Manual (NTM) | 51-10-01 | | |
| Standards Manual (SM) | | | |



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

| | | | |
|---|---|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-42-00<br>51-44-00<br>51-75-12 | 51-23-12<br>51-42-11<br>51-44-11<br>51-76-12 | 51-40-00<br>51-43-00<br>51-49-00 |
| Weight and Balance Manual (WBM) | | | |

****CONF ALL**

**K. PUBLICATION AFFECTED**

None

**L. INTERCHANGEABILITY/MIXABILITY**

Not Applicable

**M. SPARES**

None



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

This Page Intentionally Left Blank



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

## 2. MATERIAL INFORMATION

****CONF ALL**

### A. MATERIAL - PRICE AND AVAILABILITY

(1) Procurement Addresses

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

| | |
|---|---|
| Kit 571208B01R03<br>Kit 571208B02R01<br>Kit 571208B03R02<br>Kit 571208B04R01<br>Kit 571208B05R02<br>Kit 571208B06R02<br>Kit 571208B07R01<br>Kit 571208B08R02<br>Kit 571208B09R01<br>Kit 571208B10R01<br>Kit 571208B11R01<br>Kit 571208B12R04<br>Kit 571208B13R01<br>Kit 571208B14R01<br>Kit 571208B15R01<br>Kit 571208B16R04<br>Kit 571208B17R03<br>Kit 571208B18R01<br>Kit 571208B19R01<br>Kit 571208B20R01<br>Kit 571208B21R03<br>Kit 571208B22R01<br>Kit 571208B23R01<br>Kit 571208B24R01<br>Kit 571208B25R03<br>Kit 571208B26R01<br>Kit 571208B27R01<br>Kit 571208B28R02<br>Kit 571208B29R02<br>Kit 571208B30R01<br>Kit 571208B31R01 | AIRBUS Material, Logistics and Suppliers<br>ATP II B,<br>Hein-Sass-Weg 24<br>21129 HAMBURG<br>GERMANY<br>For ordering by internet: http://spares.airbus.com<br>For ordering by E-mail: airbus.kit@airbus.com<br>Telephone Hotline: +49 40 743 51660 |

(2) Price and Availability

| Kit 571208B01R03 | |
|---|---|
| Cost | 3,050.00 USD |
| Availability | 250 calendar days from receipt of order |

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



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

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

| Kit 571208B02R01 | |
|---|---|
| Cost | 2,960.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B03R02 | |
|---|---|
| Cost | 2,390.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B04R01 | |
|---|---|
| Cost | 2,320.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B05R02 | |
|---|---|
| Cost | 2,460.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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



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

| Kit 571208B06R02 | |
|---|---|
| Cost | 2,520.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B07R01 | |
|---|---|
| Cost | 2,450.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B08R02 | |
|---|---|
| Cost | 2,660.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B09R01 | |
|---|---|
| Cost | 2,870.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B10R01 | |
|---|---|
| Cost | 2,660.00 USD |
| Availability | 250 calendar days from receipt of order |



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

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

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

| Kit 571208B11R01 | |
|---|---|
| Cost | 2,660.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B12R04 | |
|---|---|
| Cost | 2,560.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B13R01 | |
|---|---|
| Cost | 2,660.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B14R01 | |
|---|---|
| Cost | 2,660.00 USD |
| Availability | 250 calendar days from receipt of order |

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



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

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

| Kit 571208B15R01 | |
|---|---|
| Cost | 2,370.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B16R04 | |
|---|---|
| Cost | 2,530.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B17R03 | |
|---|---|
| Cost | 2,190.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B18R01 | |
|---|---|
| Cost | 2,100.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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



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

| Kit 571208B19R01 | |
|---|---|
| Cost | 2,100.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B20R01 | |
|---|---|
| Cost | 2,100.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B21R03 | |
|---|---|
| Cost | 2,130.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B22R01 | |
|---|---|
| Cost | 2,010.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B23R01 | |
|---|---|
| Cost | 2,100.00 USD |
| Availability | 250 calendar days from receipt of order |



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

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

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

| Kit 571208B24R01 | |
|---|---|
| Cost | 2,100.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B25R03 | |
|---|---|
| Cost | 2,100.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B26R01 | |
|---|---|
| Cost | 50.00 USD |
| Availability | 236 calendar days from receipt of order |

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

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

| Kit 571208B27R01 | |
|---|---|
| Cost | 50.00 USD |
| Availability | 236 calendar days from receipt of order |

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



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

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

| Kit 571208B28R02 | |
|---|---|
| Cost | 50.00 USD |
| Availability | 236 calendar days from receipt of order |

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

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

| Kit 571208B29R02 | |
|---|---|
| Cost | 2,160.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B30R01 | |
|---|---|
| Cost | 2,090.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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

| Kit 571208B31R01 | |
|---|---|
| Cost | 2,020.00 USD |
| Availability | 250 calendar days from receipt of order |

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

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



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

## B. INDUSTRY SUPPORT INFORMATION

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

## C. LIST OF COMPONENTS

Kit 571208B01R03

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 7 | EN6115V4Y6 | 52 | BOLT | | | | |
| 8 | EN6115V4Y7 | 4 | BOLT | | | | |
| 12 | NAS1751-4L5 | 8 | BOLT BLN | | | | |
| 15 | ASNA2531-4 | 56 | NUT HEX | | | | |
| 16 | NSA5372-416B | 112 | 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: Kit B01 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

Kit 571208B02R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 7 | EN6115V4Y6 | 52 | BOLT | | | | |
| 8 | EN6115V4Y7 | 4 | BOLT | | | | |
| 15 | ASNA2531-4 | 56 | NUT HEX | | | | |
| 16 | NSA5372-416B | 112 | 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: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

Kit 571208B03R02

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 7 | EN6115V4Y6 | 40 | BOLT | | | | |
| 9 | EN6115V4Y8 | 8 | BOLT | | | | |
| 13 | NAS1751-4L6 | 8 | BOLT BLN | | | | |
| 15 | ASNA2531-4 | 48 | NUT HEX | | | | |
| 16 | NSA5372-416B | 96 | WASHER | | | | |



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

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: Kit B03 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

Kit 571208B04R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 7 | EN6115V4Y6 | 40 | BOLT | | | | |
| 9 | EN6115V4Y8 | 8 | BOLT | | | | |
| 15 | ASNA2531-4 | 48 | NUT HEX | | | | |
| 16 | NSA5372-416B | 96 | 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: Kit B04 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

Kit 571208B05R02

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 7 | EN6115V4Y6 | 44 | BOLT | | | | |
| 9 | EN6115V4Y8 | 4 | BOLT | | | | |
| 15 | ASNA2531-4 | 48 | NUT HEX | | | | |
| 16 | NSA5372-416B | 96 | 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: Kit B05 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

Kit 571208B06R02

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 7 | EN6115V4Y6 | 40 | BOLT | | | | |
| 8 | EN6115V4Y7 | 8 | BOLT | | | | |
| 13 | NAS1751-4L6 | 8 | BOLT BLN | | | | |
| 15 | ASNA2531-4 | 48 | NUT HEX | | | | |
| 16 | NSA5372-416B | 96 | WASHER | | | | |



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

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: Kit B06 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

Kit 571208B07R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 7 | EN6115V4Y6 | 40 | BOLT | | | | |
| 8 | EN6115V4Y7 | 8 | BOLT | | | | |
| 15 | ASNA2531-4 | 48 | NUT HEX | | | | |
| 16 | NSA5372-416B | 96 | 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: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

Kit 571208B08R02

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 6 | EN6115V4Y5 | 8 | BOLT | | | | |
| 7 | EN6115V4Y6 | 28 | BOLT | | | | |
| 8 | EN6115V4Y7 | 8 | BOLT | | | | |
| 13 | NAS1751-4L6 | 8 | BOLT BLN | | | | |
| 15 | ASNA2531-4 | 44 | NUT HEX | | | | |
| 16 | NSA5372-416B | 88 | 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: Kit B08 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

Kit 571208B09R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 6 | EN6115V4Y5 | 12 | BOLT | | | | |
| 7 | EN6115V4Y6 | 24 | BOLT | | | | |
| 8 | EN6115V4Y7 | 8 | BOLT | | | | |
| 15 | ASNA2531-4 | 44 | NUT HEX | | | | |



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

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 16 | NSA5372-416B | 88 | 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: Kit B09 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

Kit 571208B10R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 6 | EN6115V4Y5 | 8 | BOLT | | | | |
| 7 | EN6115V4Y6 | 28 | BOLT | | | | |
| 8 | EN6115V4Y7 | 8 | BOLT | | | | |
| 15 | ASNA2531-4 | 44 | NUT HEX | | | | |
| 16 | NSA5372-416B | 88 | 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: Kit B10 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

Kit 571208B11R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 6 | EN6115V4Y5 | 8 | BOLT | | | | |
| 7 | EN6115V4Y6 | 28 | BOLT | | | | |
| 8 | EN6115V4Y7 | 8 | BOLT | | | | |
| 15 | ASNA2531-4 | 44 | NUT HEX | | | | |
| 16 | NSA5372-416B | 88 | 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: Kit B11 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.



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

Kit 571208B12R04

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 3 | D5725655721000 | 2 | SEALANT | | | | |
| 4 | D5725655721200 | 2 | SEALANT | | | | |
| 6 | EN6115V4Y5 | 4 | BOLT | | | | |
| 7 | EN6115V4Y6 | 26 | BOLT | | | | |
| 8 | EN6115V4Y7 | 10 | BOLT | | | | |
| 10 | EN6114V4Y17 | 2 | BOLT CSK | | | | |
| 11 | EN6114V4Y18 | 2 | BOLT CSK | | | | |
| 15 | ASNA2531-4 | 48 | NUT HEX | | | | |
| 16 | NSA5372-416B | 96 | WASHER | | | | |
| 17 | EN6115V4-3 | 4 | BOLT | | | | |
| 18 | EN6115V3-4 | 8 | BOLT | | | | |
| 19 | EN6115V3-5 | 8 | BOLT | | | | |
| 22 | D5725655721400 | 2 | SEALANT | | | | |
| 24 | ASNA2531-5 | 4 | NUT | | | | |
| 27 | ASNA2531-3 | 16 | NUT | | | | |

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

NOTE: Kit B12 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

Kit 571208B13R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 6 | EN6115V4Y5 | 8 | BOLT | | | | |
| 7 | EN6115V4Y6 | 28 | BOLT | | | | |
| 8 | EN6115V4Y7 | 8 | BOLT | | | | |
| 15 | ASNA2531-4 | 44 | NUT HEX | | | | |
| 16 | NSA5372-416B | 88 | 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: Kit B13 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

Kit 571208B14R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 6 | EN6115V4Y5 | 8 | BOLT | | | | |



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

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 7 | EN6115V4Y6 | 28 | BOLT | | | | |
| 8 | EN6115V4Y7 | 8 | BOLT | | | | |
| 15 | ASNA2531-4 | 44 | NUT HEX | | | | |
| 16 | NSA5372-416B | 88 | 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: Kit B14 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

Kit 571208B15R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 6 | EN6115V4Y5 | 4 | BOLT | | | | |
| 7 | EN6115V4Y6 | 28 | BOLT | | | | |
| 8 | EN6115V4Y7 | 12 | BOLT | | | | |
| 15 | ASNA2531-4 | 44 | NUT HEX | | | | |
| 16 | NSA5372-416B | 88 | 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: Kit B15 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

Kit 571208B16R04

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 3 | D5725655721000 | 2 | SEALANT | | | | |
| 4 | D5725655721200 | 2 | SEALANT | | | | |
| 6 | EN6115V4Y5 | 4 | BOLT | | | | |
| 7 | EN6115V4Y6 | 26 | BOLT | | | | |
| 8 | EN6115V4Y7 | 9 | BOLT | | | | |
| 9 | EN6115V4Y8 | 1 | BOLT | | | | |
| 10 | EN6114V4Y17 | 2 | BOLT CSK | | | | |
| 11 | EN6114V4Y18 | 2 | BOLT CSK | | | | |
| 15 | ASNA2531-4 | 48 | NUT HEX | | | | |
| 16 | NSA5372-416B | 96 | WASHER | | | | |
| 17 | EN6115V4-3 | 4 | BOLT | | | | |
| 18 | EN6115V3-4 | 8 | BOLT | | | | |
| 19 | EN6115V3-5 | 8 | BOLT | | | | |
| 22 | D5725655721400 | 2 | SEALANT | | | | |



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

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 24 | ASNA2531-5 | 5 | NUT | | | | |
| 27 | ASNA2531-3 | 16 | NUT | | | | |

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

NOTE: Kit B16 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

Kit 571208B17R03

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 4 | EN6115V3A7 | 2 | BOLT | | | | |
| 6 | EN6115V4Y5 | 6 | BOLT | | | | |
| 7 | EN6115V4Y6 | 24 | BOLT | | | | |
| 9 | EN6115V4Y8 | 8 | BOLT | | | | |
| 13 | NAS1751-4L6 | 8 | BOLT BLN | | | | |
| 14 | ASNA2531-3A | 2 | NUT HEX | | | | |
| 15 | ASNA2531-4 | 38 | NUT HEX | | | | |
| 16 | NSA5372-416B | 76 | 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: Kit B17 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

Kit 571208B18R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 2 | EN6115V3A5 | 2 | BOLT | | | | |
| 6 | EN6115V4Y5 | 6 | BOLT | | | | |
| 7 | EN6115V4Y6 | 24 | BOLT | | | | |
| 9 | EN6115V4Y8 | 8 | BOLT | | | | |
| 14 | ASNA2531-3A | 2 | NUT HEX | | | | |
| 15 | ASNA2531-4 | 38 | NUT HEX | | | | |
| 16 | NSA5372-416B | 76 | 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.



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

NOTE: Kit B18 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

Kit 571208B19R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 6 | EN6115V4Y5 | 4 | BOLT | | | | |
| 7 | EN6115V4Y6 | 28 | BOLT | | | | |
| 9 | EN6115V4Y8 | 8 | BOLT | | | | |
| 15 | ASNA2531-4 | 40 | NUT HEX | | | | |
| 16 | NSA5372-416B | 80 | 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: Kit B19 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

Kit 571208B20R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 4 | EN6115V3A7 | 2 | BOLT | | | | |
| 6 | EN6115V4Y5 | 6 | BOLT | | | | |
| 7 | EN6115V4Y6 | 24 | BOLT | | | | |
| 9 | EN6115V4Y8 | 8 | BOLT | | | | |
| 14 | ASNA2531-3A | 2 | NUT HEX | | | | |
| 15 | ASNA2531-4 | 38 | NUT HEX | | | | |
| 16 | NSA5372-416B | 76 | 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: Kit B20 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

Kit 571208B21R03

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 5 | EN6114V3A16 | 2 | BOLT CSK | | | | |
| 6 | EN6115V4Y5 | 4 | BOLT | | | | |
| 7 | EN6115V4Y6 | 24 | BOLT | | | | |
| 8 | EN6115V4Y7 | 2 | BOLT | | | | |
| 9 | EN6115V4Y8 | 8 | BOLT | | | | |
| 12 | D5725655720000 | 2 | SEALANT | | | | |
| 14 | ASNA2531-3A | 2 | NUT HEX | | | | |



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

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 15 | ASNA2531-4 | 38 | NUT HEX | | | | |
| 16 | NSA5372-416B | 76 | WASHER | | | | |
| 18 | EN6115V3-4 | 2 | BOLT | | | | |
| 24 | ASNA2531-5 | 4 | NUT | | | | |
| 25 | EN6115V3-6 | 4 | BOLT | | | | |
| 26 | EN6115V3-8 | 4 | BOLT | | | | |
| 27 | ASNA2531-3 | 10 | NUT | | | | |

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

NOTE: Kit B21 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

Kit 571208B22R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 3 | EN6115V3A6 | 2 | BOLT | | | | |
| 6 | EN6115V4Y5 | 4 | BOLT | | | | |
| 7 | EN6115V4Y6 | 26 | BOLT | | | | |
| 9 | EN6115V4Y8 | 8 | BOLT | | | | |
| 14 | ASNA2531-3A | 2 | NUT HEX | | | | |
| 15 | ASNA2531-4 | 38 | NUT HEX | | | | |
| 16 | NSA5372-416B | 76 | 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: Kit B22 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

Kit 571208B23R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 6 | EN6115V4Y5 | 4 | BOLT | | | | |
| 7 | EN6115V4Y6 | 28 | BOLT | | | | |
| 9 | EN6115V4Y8 | 8 | BOLT | | | | |
| 15 | ASNA2531-4 | 40 | NUT HEX | | | | |
| 16 | NSA5372-416B | 80 | 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.



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

NOTE: Kit B23 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

Kit 571208B24R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 4 | EN6115V3A7 | 2 | BOLT | | | | |
| 6 | EN6115V4Y5 | 6 | BOLT | | | | |
| 7 | EN6115V4Y6 | 24 | BOLT | | | | |
| 9 | EN6115V4Y8 | 8 | BOLT | | | | |
| 14 | ASNA2531-3A | 2 | NUT HEX | | | | |
| 15 | ASNA2531-4 | 38 | NUT HEX | | | | |
| 16 | NSA5372-416B | 76 | 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: Kit B24 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

Kit 571208B25R03

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 5 | EN6114V3A16 | 2 | BOLT CSK | | | | |
| 6 | EN6115V4Y5 | 4 | BOLT | | | | |
| 7 | EN6115V4Y6 | 24 | BOLT | | | | |
| 8 | EN6115V4Y7 | 1 | BOLT | | | | |
| 9 | EN6115V4Y8 | 9 | BOLT | | | | |
| 12 | D5725655720000 | 2 | SEALANT | | | | |
| 14 | ASNA2531-3A | 2 | NUT HEX | | | | |
| 15 | ASNA2531-4 | 38 | NUT HEX | | | | |
| 16 | NSA5372-416B | 76 | WASHER | | | | |
| 18 | EN6115V3-4 | 2 | BOLT | | | | |
| 24 | ASNA2531-5 | 3 | NUT | | | | |
| 25 | EN6115V3-6 | 4 | BOLT | | | | |
| 26 | EN6115V3-8 | 4 | BOLT | | | | |
| 27 | ASNA2531-3 | 10 | NUT | | | | |

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

NOTE: Kit B25 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.



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

Kit 571208B26R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 2 | EN6115V3A5 | 4 | BOLT | | | | |
| 14 | ASNA2531-3A | 4 | NUT HEX | | | | |

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: Kit B26 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.

Kit 571208B27R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 1 | EN6115V3A4 | 4 | BOLT | | | | |
| 14 | ASNA2531-3A | 4 | NUT HEX | | | | |

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: Kit B27 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.

Kit 571208B28R02

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 3 | EN6115V3A6 | 4 | BOLT | | | | |
| 14 | ASNA2531-3A | 4 | NUT HEX | | | | |

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: Kit B28 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.

Kit 571208B29R02

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 7 | EN6115V4Y6 | 36 | BOLT | | | | |
| 8 | EN6115V4Y7 | 4 | BOLT | | | | |
| 12 | NAS1751-4L5 | 8 | BOLT BLN | | | | |
| 15 | ASNA2531-4 | 40 | NUT HEX | | | | |



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

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 16 | NSA5372-416B | 80 | 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: Kit B29 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

Kit 571208B30R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 7 | EN6115V4Y6 | 36 | BOLT | | | | |
| 8 | EN6115V4Y7 | 4 | BOLT | | | | |
| 15 | ASNA2531-4 | 40 | NUT HEX | | | | |
| 16 | NSA5372-416B | 80 | 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: Kit B30 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

Kit 571208B31R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | ITEM | OLD PART N° | INT | SEE NOTES |
|---|---|---|---|---|---|---|---|
| 7 | EN6115V4Y6 | 32 | BOLT | | | | |
| 8 | EN6115V4Y7 | 8 | BOLT | | | | |
| 15 | ASNA2531-4 | 40 | NUT HEX | | | | |
| 16 | NSA5372-416B | 80 | 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: Kit B31 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.



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

## D. LIST OF MATERIALS - OPERATOR SUPPLIED

(1) Consumable Materials

Consumable CMLB01

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |
| | Polysulfide Sealant-Low Density Multi Purpose Bru | 06ACA1 | As required | |
| | Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required | |
| | Non Aqueous Cleaner - General | 08BAA9 | As required | |
| | Textile - Lint Free Cotton | 14SBA1 | As required | |

(2) Components

None

(3) Equipment

None

## E. PARTS TO BE RE-IDENTIFIED BY OPERATOR

None

## F. TOOLING

None



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

This Page Intentionally Left Blank



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

## 3. ACCOMPLISHMENT INSTRUCTIONS

**Task 571208-831-895-001 - Modification**

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

WARNING: THIS PROCEDURE USES A FUEL SYSTEM ITEM THAT IS IN A CATEGORY KNOWN AS A CRITICAL DESIGN CONFIGURATION CONTROL LIMITATION (CDCCL). CDCCL IDENTIFIES AN ITEM THAT CAN BE THE SOURCE OF A POSSIBLE LOW OXYGEN CONDITION. YOU MUST KEEP ALL CDCCL ITEMS IN THE APPROVED CONFIGURATION. DAMAGE, WEAR OR CHANGES TO A CDCCL ITEM CAN CAUSE INJURY OR DEATH.

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. 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



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

the aircraft can be put back into a serviceable condition.

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

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

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

**Task Associated Data**

****CONF 001**

| Zone | |
|---|---|
| 400 570 670 | |
| Access | |
| Panel | 540AB 640AB |
| Manpower | |
| TOTAL MANHOURS | 125.00 |
| ELAPSED TIME (HOURS) | 34.50 |

****CONF 002**

| Zone | |
|---|---|
| 400 570 670 | |
| Access | |
| Panel | 540AB 640AB |
| Manpower | |
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

****CONF 003**

| Zone | |
|---|---|
| 400 570 670 | |
| Access | |
| Panel | 540AB 640AB |
| Manpower | |
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

****CONF 004**

| Zone | |
|---|---|
| 400 570 670 | |
| Access | |
| Panel | 540AB 640AB |



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

| Manpower | |
|---|---|
| TOTAL MANHOURS | 125.00 |
| ELAPSED TIME (HOURS) | 34.50 |

**CONF 005

| Zone | |
|---|---|
| 400 570 670 | |
| Access | |
| Panel | 540AB 640AB |
| Manpower | |
| TOTAL MANHOURS | 127.00 |
| ELAPSED TIME (HOURS) | 35.50 |

**CONF 006

| Zone | |
|---|---|
| 400 570 670 | |
| Access | |
| Panel | 540AB 640AB |
| Manpower | |
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

**CONF 007

| Zone | |
|---|---|
| 400 570 670 | |
| Access | |
| Panel | 540AB 640AB |
| Manpower | |
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

**CONF 008

| Zone | |
|---|---|
| 400 570 670 | |
| Access | |
| Panel | 540AB 640AB |
| Manpower | |
| TOTAL MANHOURS | 125.00 |
| ELAPSED TIME (HOURS) | 34.50 |



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

**CONF 009

| Zone | |
|---|---|
| 400 570 670 | |
| Access | |
| Panel | 540AB 640AB |
| Manpower | |
| TOTAL MANHOURS | 127.00 |
| ELAPSED TIME (HOURS) | 35.50 |

**CONF 010

| Zone | |
|---|---|
| 400 570 670 | |
| Access | |
| Panel | 540AB 640AB |
| Manpower | |
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

**CONF 011

| Zone | |
|---|---|
| 400 570 670 | |
| Access | |
| Panel | 540AB 640AB |
| Manpower | |
| TOTAL MANHOURS | 127.00 |
| ELAPSED TIME (HOURS) | 35.50 |

**CONF 012

| Zone | |
|---|---|
| 400 570 670 | |
| Access | |
| Panel | 540AB 640AB |
| Manpower | |
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

**CONF 013

| Zone | |
|---|---|
| 400 570 670 | |
| Access | |
| Panel | 540AB 640AB |



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

| Manpower | |
|---|---|
| TOTAL MANHOURS | 125.00 |
| ELAPSED TIME (HOURS) | 34.50 |

****CONF 014**

| Zone | |
|---|---|
| 400 570 670 | |
| Access | |
| Panel | 540AB 640AB |
| Manpower | |
| TOTAL MANHOURS | 125.00 |
| ELAPSED TIME (HOURS) | 34.50 |

****CONF 015**

| Zone | |
|---|---|
| 400 570 670 | |
| Access | |
| Panel | 540AB 640AB |
| Manpower | |
| TOTAL MANHOURS | 127.00 |
| ELAPSED TIME (HOURS) | 35.50 |

****CONF 016**

| Zone | |
|---|---|
| 400 570 670 | |
| Access | |
| Panel | 540AB 640AB |
| Manpower | |
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |

****CONF 017**

| Zone | |
|---|---|
| 400 570 670 | |
| Access | |
| Panel | 540AB 640AB |
| Manpower | |
| TOTAL MANHOURS | 121.00 |
| ELAPSED TIME (HOURS) | 33.50 |



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

**CONF ALL

## A. GENERAL

**CONF 001

### (1) Subtask 571208-910-401-001 - Standard Practices

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00, Page Block 001<br>06-31-57, Page Block 001<br>06-41-57, Page Block 001<br>Task 28-00-00-910-001<br>Task 28-10-00-910-001 |
| Consumable Material List (CML) | |
| Structural Repair Manual (SRM) | 51-23-12<br>51-40-00<br>51-42-00<br>51-42-11<br>51-43-00<br>51-44-00<br>51-44-11<br>51-49-00<br>51-75-12<br>51-76-12 |

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

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

(c) For wing rib identification, refer to AMM 06-31-57, Page Block 001.

(d) For the identification of access panels, refer to AMM 06-41-57, Page Block 001.

(e) Obey the safety procedures when you do work in the fuel tank, refer to AMM Task 28-10-00-910-001 and AMM Task 28-00-00-910-001.

(f) Remove and install fasteners in accordance with SRM 51-42-00 and SRM 51-42-11.

(g) Torque tighten standard threaded fasteners in accordance with SRM 51-49-00.

(h) Renew any damaged protective finish in accordance with SRM 51-75-12.

(i) Oversize fasteners in accordance with SRM 51-43-00.

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



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

(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 correct fastener grip length in accordance with SRM Chapter 51.

(m) Get fastener hole diameters, drill and de-burr data in accordance with SRM 51-44-00 and SRM 51-44-11 tables 7 and 12:

- Diameter 3 - 2nd oversize clearance fit
- Diameter 4 - 2nd oversize clearance fit
- 7.01 mm (0,276 in.) inch diameter blind bolts - 1st oversize clearance fit
- Surface finish of holes to be 1,6.

(n) Apply fuel tank sealant and paint bolt heads, nuts and washers in accordance with SRM 51-76-12 and SRM 51-23-12.

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

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

**(2) Subtask 571208-839-401-001 - 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 571208-910-401-002 - Standard Practices**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00, Page Block 001<br>06-31-57, Page Block 001<br>06-41-57, Page Block 001<br>Task 28-00-00-910-001<br>Task 28-10-00-910-001 |
| Consumable Material List (CML) | |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-12<br>51-40-00<br>51-42-00<br>51-42-11<br>51-43-00<br>51-44-00<br>51-44-11<br>51-49-00<br>51-75-12<br>51-76-12 |

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

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

(c) For wing rib identification, refer to AMM 06-31-57, Page Block 001.

(d) For the identification of access panels, refer to AMM 06-41-57, Page Block 001.

(e) Obey the safety procedures when you do work in the fuel tank, refer to AMM Task 28-10-00-910-001 and AMM Task 28-00-00-910-001.

(f) Remove and install fasteners in accordance with SRM 51-42-00 and SRM 51-42-11.

(g) Torque tighten standard threaded fasteners in accordance with SRM 51-49-00.

(h) Renew any damaged protective finish in accordance with SRM 51-75-12.

(i) Oversize fasteners in accordance with SRM 51-43-00.

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

(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 correct fastener grip length in accordance with SRM Chapter 51.

(m) Get fastener hole diameters, drill and de-burr data in accordance with SRM 51-44-00 and SRM 51-44-11 tables 7 and 12:

- Diameter 3 - 2nd oversize clearance fit
- Diameter 4 - 2nd oversize clearance fit
- Surface finish of holes to be 1,6.



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

(n) Apply fuel tank sealant and paint bolt heads, nuts and washers in accordance with SRM 51-76-12 and SRM 51-23-12.

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

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

**(2) Subtask 571208-839-401-001 - 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 571208-910-401-003 - Standard Practices**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00, Page Block 001<br>06-31-57, Page Block 001<br>06-41-57, Page Block 001<br>Task 28-00-00-910-001<br>Task 28-10-00-910-001 |
| Consumable Material List (CML) | |
| Structural Repair Manual (SRM) | 51-23-12<br>51-40-00<br>51-42-00<br>51-42-11<br>51-43-00<br>51-44-00<br>51-44-11<br>51-49-00<br>51-75-12<br>51-76-12 |

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

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

(c) For wing rib identification, refer to AMM 06-31-57, Page Block 001.

(d) For the identification of access panels, refer to AMM 06-41-57, Page Block 001.

(e) Obey the safety procedures when you do work in the fuel tank, refer to AMM Task 28-10-00-910-001 and AMM Task 28-00-00-910-001.



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

(f) Remove and install fasteners in accordance with SRM 51-42-00 and SRM 51-42-11.

(g) Torque tighten standard threaded fasteners in accordance with SRM 51-49-00.

(h) Renew any damaged protective finish in accordance with SRM 51-75-12.

(i) Oversize fasteners in accordance with SRM 51-43-00.

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

(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 correct fastener grip length in accordance with SRM Chapter 51.

(m) Get fastener hole diameters, drill and de-burr data in accordance with SRM 51-44-00 and SRM 51-44-11 tables 7 and 12:

- Diameter 4 - 2nd oversize clearance fit
- Surface finish of holes to be 1,6.

(n) Apply fuel tank sealant and paint bolt heads, nuts and washers in accordance with SRM 51-76-12 and SRM 51-23-12.

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

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

**(2) Subtask 571208-839-401-001 - 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 571208-910-401-002 - Standard Practices**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |



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

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00, Page Block 001<br>06-31-57, Page Block 001<br>06-41-57, Page Block 001<br>Task 28-00-00-910-001<br>Task 28-10-00-910-001 |
| Consumable Material List (CML) | |
| Structural Repair Manual (SRM) | 51-23-12<br>51-40-00<br>51-42-00<br>51-42-11<br>51-43-00<br>51-44-00<br>51-44-11<br>51-49-00<br>51-75-12<br>51-76-12 |

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

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

(c) For wing rib identification, refer to AMM 06-31-57, Page Block 001.

(d) For the identification of access panels, refer to AMM 06-41-57, Page Block 001.

(e) Obey the safety procedures when you do work in the fuel tank, refer to AMM Task 28-10-00-910-001 and AMM Task 28-00-00-910-001.

(f) Remove and install fasteners in accordance with SRM 51-42-00 and SRM 51-42-11.

(g) Torque tighten standard threaded fasteners in accordance with SRM 51-49-00.

(h) Renew any damaged protective finish in accordance with SRM 51-75-12.

(i) Oversize fasteners in accordance with SRM 51-43-00.

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

(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 correct fastener grip length in accordance with SRM Chapter 51.



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

(m) Get fastener hole diameters, drill and de-burr data in accordance with SRM 51-44-00 and SRM 51-44-11 tables 7 and 12:

- Diameter 3 - 2nd oversize clearance fit
- Diameter 4 - 2nd oversize clearance fit
- Surface finish of holes to be 1,6.

(n) Apply fuel tank sealant and paint bolt heads, nuts and washers in accordance with SRM 51-76-12 and SRM 51-23-12.

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

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

**(2) Subtask 571208-839-401-001 - 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 571208-910-401-002 - Standard Practices**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00, Page Block 001<br>06-31-57, Page Block 001<br>06-41-57, Page Block 001<br>Task 28-00-00-910-001<br>Task 28-10-00-910-001 |
| Consumable Material List (CML) | |
| Structural Repair Manual (SRM) | 51-23-12<br>51-40-00<br>51-42-00<br>51-42-11<br>51-43-00<br>51-44-00<br>51-44-11<br>51-49-00<br>51-75-12<br>51-76-12 |

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



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

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

(c) For wing rib identification, refer to AMM 06-31-57, Page Block 001.

(d) For the identification of access panels, refer to AMM 06-41-57, Page Block 001.

(e) Obey the safety procedures when you do work in the fuel tank, refer to AMM Task 28-10-00-910-001 and AMM Task 28-00-00-910-001.

(f) Remove and install fasteners in accordance with SRM 51-42-00 and SRM 51-42-11.

(g) Torque tighten standard threaded fasteners in accordance with SRM 51-49-00.

(h) Renew any damaged protective finish in accordance with SRM 51-75-12.

(i) Oversize fasteners in accordance with SRM 51-43-00.

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

(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 correct fastener grip length in accordance with SRM Chapter 51.

(m) Get fastener hole diameters, drill and de-burr data in accordance with SRM 51-44-00 and SRM 51-44-11 tables 7 and 12:

- Diameter 3 - 2nd oversize clearance fit
- Diameter 4 - 2nd oversize clearance fit
- Surface finish of holes to be 1,6.

(n) Apply fuel tank sealant and paint bolt heads, nuts and washers in accordance with SRM 51-76-12 and SRM 51-23-12.

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

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

**(2) Subtask 571208-839-401-001 - Administrative**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |



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

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

**CONF 006

(1) **Subtask 571208-910-401-002 - Standard Practices**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00, Page Block 001<br>06-31-57, Page Block 001<br>06-41-57, Page Block 001<br>Task 28-00-00-910-001<br>Task 28-10-00-910-001 |
| Consumable Material List (CML) | |
| Structural Repair Manual (SRM) | 51-23-12<br>51-40-00<br>51-42-00<br>51-42-11<br>51-43-00<br>51-44-00<br>51-44-11<br>51-49-00<br>51-75-12<br>51-76-12 |

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

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

(c) For wing rib identification, refer to AMM 06-31-57, Page Block 001.

(d) For the identification of access panels, refer to AMM 06-41-57, Page Block 001.

(e) Obey the safety procedures when you do work in the fuel tank, refer to AMM Task 28-10-00-910-001 and AMM Task 28-00-00-910-001.

(f) Remove and install fasteners in accordance with SRM 51-42-00 and SRM 51-42-11.

(g) Torque tighten standard threaded fasteners in accordance with SRM 51-49-00.

(h) Renew any damaged protective finish in accordance with SRM 51-75-12.

(i) Oversize fasteners in accordance with SRM 51-43-00.

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



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

(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 correct fastener grip length in accordance with SRM Chapter 51.

(m) Get fastener hole diameters, drill and de-burr data in accordance with SRM 51-44-00 and SRM 51-44-11 tables 7 and 12:

- Diameter 3 - 2nd oversize clearance fit
- Diameter 4 - 2nd oversize clearance fit
- Surface finish of holes to be 1,6.

(n) Apply fuel tank sealant and paint bolt heads, nuts and washers in accordance with SRM 51-76-12 and SRM 51-23-12.

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

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

**(2) Subtask 571208-839-401-001 - Administrative**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

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

****CONF 007**

**(1) Subtask 571208-910-401-003 - Standard Practices**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00, Page Block 001<br>06-31-57, Page Block 001<br>06-41-57, Page Block 001<br>Task 28-00-00-910-001<br>Task 28-10-00-910-001 |
| Consumable Material List (CML) | |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-12<br>51-40-00<br>51-42-00<br>51-42-11<br>51-43-00<br>51-44-00<br>51-44-11<br>51-49-00<br>51-75-12<br>51-76-12 |

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

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

(c) For wing rib identification, refer to AMM 06-31-57, Page Block 001.

(d) For the identification of access panels, refer to AMM 06-41-57, Page Block 001.

(e) Obey the safety procedures when you do work in the fuel tank, refer to AMM Task 28-10-00-910-001 and AMM Task 28-00-00-910-001.

(f) Remove and install fasteners in accordance with SRM 51-42-00 and SRM 51-42-11.

(g) Torque tighten standard threaded fasteners in accordance with SRM 51-49-00.

(h) Renew any damaged protective finish in accordance with SRM 51-75-12.

(i) Oversize fasteners in accordance with SRM 51-43-00.

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

(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 correct fastener grip length in accordance with SRM Chapter 51.

(m) Get fastener hole diameters, drill and de-burr data in accordance with SRM 51-44-00 and SRM 51-44-11 tables 7 and 12:

- Diameter 4 - 2nd oversize clearance fit
- Surface finish of holes to be 1,6.



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

(n) Apply fuel tank sealant and paint bolt heads, nuts and washers in accordance with SRM 51-76-12 and SRM 51-23-12.

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

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

**(2) Subtask 571208-839-401-001 - Administrative**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

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

****CONF 008**

**(1) Subtask 571208-910-401-002 - Standard Practices**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00, Page Block 001<br>06-31-57, Page Block 001<br>06-41-57, Page Block 001<br>Task 28-00-00-910-001<br>Task 28-10-00-910-001 |
| Consumable Material List (CML) | |
| Structural Repair Manual (SRM) | 51-23-12<br>51-40-00<br>51-42-00<br>51-42-11<br>51-43-00<br>51-44-00<br>51-44-11<br>51-49-00<br>51-75-12<br>51-76-12 |

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

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

(c) For wing rib identification, refer to AMM 06-31-57, Page Block 001.

(d) For the identification of access panels, refer to AMM 06-41-57, Page Block 001.

(e) Obey the safety procedures when you do work in the fuel tank, refer to AMM Task 28-10-00-910-001 and AMM Task 28-00-00-910-001.



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

(f) Remove and install fasteners in accordance with SRM 51-42-00 and SRM 51-42-11.

(g) Torque tighten standard threaded fasteners in accordance with SRM 51-49-00.

(h) Renew any damaged protective finish in accordance with SRM 51-75-12.

(i) Oversize fasteners in accordance with SRM 51-43-00.

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

(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 correct fastener grip length in accordance with SRM Chapter 51.

(m) Get fastener hole diameters, drill and de-burr data in accordance with SRM 51-44-00 and SRM 51-44-11 tables 7 and 12:

- Diameter 3 - 2nd oversize clearance fit
- Diameter 4 - 2nd oversize clearance fit
- Surface finish of holes to be 1,6.

(n) Apply fuel tank sealant and paint bolt heads, nuts and washers in accordance with SRM 51-76-12 and SRM 51-23-12.

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

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

**(2) Subtask 571208-839-401-001 - Administrative**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

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

****CONF 009**

**(1) Subtask 571208-910-401-002 - Standard Practices**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |



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

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00, Page Block 001<br>06-31-57, Page Block 001<br>06-41-57, Page Block 001<br>Task 28-00-00-910-001<br>Task 28-10-00-910-001 |
| Consumable Material List (CML) | |
| Structural Repair Manual (SRM) | 51-23-12<br>51-40-00<br>51-42-00<br>51-42-11<br>51-43-00<br>51-44-00<br>51-44-11<br>51-49-00<br>51-75-12<br>51-76-12 |

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

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

(c) For wing rib identification, refer to AMM 06-31-57, Page Block 001.

(d) For the identification of access panels, refer to AMM 06-41-57, Page Block 001.

(e) Obey the safety procedures when you do work in the fuel tank, refer to AMM Task 28-10-00-910-001 and AMM Task 28-00-00-910-001.

(f) Remove and install fasteners in accordance with SRM 51-42-00 and SRM 51-42-11.

(g) Torque tighten standard threaded fasteners in accordance with SRM 51-49-00.

(h) Renew any damaged protective finish in accordance with SRM 51-75-12.

(i) Oversize fasteners in accordance with SRM 51-43-00.

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

(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 correct fastener grip length in accordance with SRM Chapter 51.



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

(m) Get fastener hole diameters, drill and de-burr data in accordance with SRM 51-44-00 and SRM 51-44-11 tables 7 and 12:

- Diameter 3 - 2nd oversize clearance fit
- Diameter 4 - 2nd oversize clearance fit
- Surface finish of holes to be 1,6.

(n) Apply fuel tank sealant and paint bolt heads, nuts and washers in accordance with SRM 51-76-12 and SRM 51-23-12.

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

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

**(2) Subtask 571208-839-401-001 - 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 010**

**(1) Subtask 571208-910-401-003 - Standard Practices**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00, Page Block 001<br>06-31-57, Page Block 001<br>06-41-57, Page Block 001<br>Task 28-00-00-910-001<br>Task 28-10-00-910-001 |
| Consumable Material List (CML) | |
| Structural Repair Manual (SRM) | 51-23-12<br>51-40-00<br>51-42-00<br>51-42-11<br>51-43-00<br>51-44-00<br>51-44-11<br>51-49-00<br>51-75-12<br>51-76-12 |

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



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

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

(c) For wing rib identification, refer to AMM 06-31-57, Page Block 001.

(d) For the identification of access panels, refer to AMM 06-41-57, Page Block 001.

(e) Obey the safety procedures when you do work in the fuel tank, refer to AMM Task 28-10-00-910-001 and AMM Task 28-00-00-910-001.

(f) Remove and install fasteners in accordance with SRM 51-42-00 and SRM 51-42-11.

(g) Torque tighten standard threaded fasteners in accordance with SRM 51-49-00.

(h) Renew any damaged protective finish in accordance with SRM 51-75-12.

(i) Oversize fasteners in accordance with SRM 51-43-00.

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

(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 correct fastener grip length in accordance with SRM Chapter 51.

(m) Get fastener hole diameters, drill and de-burr data in accordance with SRM 51-44-00 and SRM 51-44-11 tables 7 and 12:

- Diameter 4 - 2nd oversize clearance fit
- Surface finish of holes to be 1,6.

(n) Apply fuel tank sealant and paint bolt heads, nuts and washers in accordance with SRM 51-76-12 and SRM 51-23-12.

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

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

**(2) Subtask 571208-839-401-001 - Administrative**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

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



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

**CONF 011

(1) **Subtask 571208-910-401-002 - Standard Practices**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00, Page Block 001<br>06-31-57, Page Block 001<br>06-41-57, Page Block 001<br>Task 28-00-00-910-001<br>Task 28-10-00-910-001 |
| Consumable Material List (CML) | |
| Structural Repair Manual (SRM) | 51-23-12<br>51-40-00<br>51-42-00<br>51-42-11<br>51-43-00<br>51-44-00<br>51-44-11<br>51-49-00<br>51-75-12<br>51-76-12 |

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

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

(c) For wing rib identification, refer to AMM 06-31-57, Page Block 001.

(d) For the identification of access panels, refer to AMM 06-41-57, Page Block 001.

(e) Obey the safety procedures when you do work in the fuel tank, refer to AMM Task 28-10-00-910-001 and AMM Task 28-00-00-910-001.

(f) Remove and install fasteners in accordance with SRM 51-42-00 and SRM 51-42-11.

(g) Torque tighten standard threaded fasteners in accordance with SRM 51-49-00.

(h) Renew any damaged protective finish in accordance with SRM 51-75-12.

(i) Oversize fasteners in accordance with SRM 51-43-00.

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

(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.



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

(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 correct fastener grip length in accordance with SRM Chapter 51.

(m) Get fastener hole diameters, drill and de-burr data in accordance with SRM 51-44-00 and SRM 51-44-11 tables 7 and 12:

- Diameter 3 - 2nd oversize clearance fit
- Diameter 4 - 2nd oversize clearance fit
- Surface finish of holes to be 1,6.

(n) Apply fuel tank sealant and paint bolt heads, nuts and washers in accordance with SRM 51-76-12 and SRM 51-23-12.

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

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

**(2) Subtask 571208-839-401-001 - 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 012**

**(1) Subtask 571208-910-401-003 - Standard Practices**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00, Page Block 001<br>06-31-57, Page Block 001<br>06-41-57, Page Block 001<br>Task 28-00-00-910-001<br>Task 28-10-00-910-001 |
| Consumable Material List (CML) | |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-12<br>51-40-00<br>51-42-00<br>51-42-11<br>51-43-00<br>51-44-00<br>51-44-11<br>51-49-00<br>51-75-12<br>51-76-12 |

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

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

(c) For wing rib identification, refer to AMM 06-31-57, Page Block 001.

(d) For the identification of access panels, refer to AMM 06-41-57, Page Block 001.

(e) Obey the safety procedures when you do work in the fuel tank, refer to AMM Task 28-10-00-910-001 and AMM Task 28-00-00-910-001.

(f) Remove and install fasteners in accordance with SRM 51-42-00 and SRM 51-42-11.

(g) Torque tighten standard threaded fasteners in accordance with SRM 51-49-00.

(h) Renew any damaged protective finish in accordance with SRM 51-75-12.

(i) Oversize fasteners in accordance with SRM 51-43-00.

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

(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 correct fastener grip length in accordance with SRM Chapter 51.

(m) Get fastener hole diameters, drill and de-burr data in accordance with SRM 51-44-00 and SRM 51-44-11 tables 7 and 12:

- Diameter 4 - 2nd oversize clearance fit
- Surface finish of holes to be 1,6.



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

(n) Apply fuel tank sealant and paint bolt heads, nuts and washers in accordance with SRM 51-76-12 and SRM 51-23-12.

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

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

**(2) Subtask 571208-839-401-001 - 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 013**

**(1) Subtask 571208-910-401-002 - Standard Practices**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00, Page Block 001<br>06-31-57, Page Block 001<br>06-41-57, Page Block 001<br>Task 28-00-00-910-001<br>Task 28-10-00-910-001 |
| Consumable Material List (CML) | |
| Structural Repair Manual (SRM) | 51-23-12<br>51-40-00<br>51-42-00<br>51-42-11<br>51-43-00<br>51-44-00<br>51-44-11<br>51-49-00<br>51-75-12<br>51-76-12 |

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

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

(c) For wing rib identification, refer to AMM 06-31-57, Page Block 001.

(d) For the identification of access panels, refer to AMM 06-41-57, Page Block 001.

(e) Obey the safety procedures when you do work in the fuel tank, refer to AMM Task 28-10-00-910-001 and AMM Task 28-00-00-910-001.



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

(f) Remove and install fasteners in accordance with SRM 51-42-00 and SRM 51-42-11.

(g) Torque tighten standard threaded fasteners in accordance with SRM 51-49-00.

(h) Renew any damaged protective finish in accordance with SRM 51-75-12.

(i) Oversize fasteners in accordance with SRM 51-43-00.

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

(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 correct fastener grip length in accordance with SRM Chapter 51.

(m) Get fastener hole diameters, drill and de-burr data in accordance with SRM 51-44-00 and SRM 51-44-11 tables 7 and 12:

- Diameter 3 - 2nd oversize clearance fit
- Diameter 4 - 2nd oversize clearance fit
- Surface finish of holes to be 1,6.

(n) Apply fuel tank sealant and paint bolt heads, nuts and washers in accordance with SRM 51-76-12 and SRM 51-23-12.

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

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

**(2) Subtask 571208-839-401-001 - 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 014**

**(1) Subtask 571208-910-401-002 - Standard Practices**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |



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

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00, Page Block 001<br>06-31-57, Page Block 001<br>06-41-57, Page Block 001<br>Task 28-00-00-910-001<br>Task 28-10-00-910-001 |
| Consumable Material List (CML) | |
| Structural Repair Manual (SRM) | 51-23-12<br>51-40-00<br>51-42-00<br>51-42-11<br>51-43-00<br>51-44-00<br>51-44-11<br>51-49-00<br>51-75-12<br>51-76-12 |

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

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

(c) For wing rib identification, refer to AMM 06-31-57, Page Block 001.

(d) For the identification of access panels, refer to AMM 06-41-57, Page Block 001.

(e) Obey the safety procedures when you do work in the fuel tank, refer to AMM Task 28-10-00-910-001 and AMM Task 28-00-00-910-001.

(f) Remove and install fasteners in accordance with SRM 51-42-00 and SRM 51-42-11.

(g) Torque tighten standard threaded fasteners in accordance with SRM 51-49-00.

(h) Renew any damaged protective finish in accordance with SRM 51-75-12.

(i) Oversize fasteners in accordance with SRM 51-43-00.

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

(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 correct fastener grip length in accordance with SRM Chapter 51.



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

(m) Get fastener hole diameters, drill and de-burr data in accordance with SRM 51-44-00 and SRM 51-44-11 tables 7 and 12:

- Diameter 3 - 2nd oversize clearance fit
- Diameter 4 - 2nd oversize clearance fit
- Surface finish of holes to be 1,6.

(n) Apply fuel tank sealant and paint bolt heads, nuts and washers in accordance with SRM 51-76-12 and SRM 51-23-12.

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

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

**(2) Subtask 571208-839-401-001 - 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 015**

**(1) Subtask 571208-910-401-002 - Standard Practices**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00, Page Block 001<br>06-31-57, Page Block 001<br>06-41-57, Page Block 001<br>Task 28-00-00-910-001<br>Task 28-10-00-910-001 |
| Consumable Material List (CML) | |
| Structural Repair Manual (SRM) | 51-23-12<br>51-40-00<br>51-42-00<br>51-42-11<br>51-43-00<br>51-44-00<br>51-44-11<br>51-49-00<br>51-75-12<br>51-76-12 |

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



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

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

(c) For wing rib identification, refer to AMM 06-31-57, Page Block 001.

(d) For the identification of access panels, refer to AMM 06-41-57, Page Block 001.

(e) Obey the safety procedures when you do work in the fuel tank, refer to AMM Task 28-10-00-910-001 and AMM Task 28-00-00-910-001.

(f) Remove and install fasteners in accordance with SRM 51-42-00 and SRM 51-42-11.

(g) Torque tighten standard threaded fasteners in accordance with SRM 51-49-00.

(h) Renew any damaged protective finish in accordance with SRM 51-75-12.

(i) Oversize fasteners in accordance with SRM 51-43-00.

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

(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 correct fastener grip length in accordance with SRM Chapter 51.

(m) Get fastener hole diameters, drill and de-burr data in accordance with SRM 51-44-00 and SRM 51-44-11 tables 7 and 12:

- Diameter 3 - 2nd oversize clearance fit
- Diameter 4 - 2nd oversize clearance fit
- Surface finish of holes to be 1,6.

(n) Apply fuel tank sealant and paint bolt heads, nuts and washers in accordance with SRM 51-76-12 and SRM 51-23-12.

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

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

**(2) Subtask 571208-839-401-001 - Administrative**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |



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

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

**CONF 016

(1) **Subtask 571208-910-401-002 - Standard Practices**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00, Page Block 001<br>06-31-57, Page Block 001<br>06-41-57, Page Block 001<br>Task 28-00-00-910-001<br>Task 28-10-00-910-001 |
| Consumable Material List (CML) | |
| Structural Repair Manual (SRM) | 51-23-12<br>51-40-00<br>51-42-00<br>51-42-11<br>51-43-00<br>51-44-00<br>51-44-11<br>51-49-00<br>51-75-12<br>51-76-12 |

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

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

(c) For wing rib identification, refer to AMM 06-31-57, Page Block 001.

(d) For the identification of access panels, refer to AMM 06-41-57, Page Block 001.

(e) Obey the safety procedures when you do work in the fuel tank, refer to AMM Task 28-10-00-910-001 and AMM Task 28-00-00-910-001.

(f) Remove and install fasteners in accordance with SRM 51-42-00 and SRM 51-42-11.

(g) Torque tighten standard threaded fasteners in accordance with SRM 51-49-00.

(h) Renew any damaged protective finish in accordance with SRM 51-75-12.

(i) Oversize fasteners in accordance with SRM 51-43-00.

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



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

(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 correct fastener grip length in accordance with SRM Chapter 51.

(m) Get fastener hole diameters, drill and de-burr data in accordance with SRM 51-44-00 and SRM 51-44-11 tables 7 and 12:

- Diameter 3 - 2nd oversize clearance fit
- Diameter 4 - 2nd oversize clearance fit
- Surface finish of holes to be 1,6.

(n) Apply fuel tank sealant and paint bolt heads, nuts and washers in accordance with SRM 51-76-12 and SRM 51-23-12.

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

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

**(2) Subtask 571208-839-401-001 - 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 017**

**(1) Subtask 571208-910-401-002 - Standard Practices**

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | 06-20-00, Page Block 001<br>06-31-57, Page Block 001<br>06-41-57, Page Block 001<br>Task 28-00-00-910-001<br>Task 28-10-00-910-001 |
| Consumable Material List (CML) | |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-12<br>51-40-00<br>51-42-00<br>51-42-11<br>51-43-00<br>51-44-00<br>51-44-11<br>51-49-00<br>51-75-12<br>51-76-12 |

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

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

(c) For wing rib identification, refer to AMM 06-31-57, Page Block 001.

(d) For the identification of access panels, refer to AMM 06-41-57, Page Block 001.

(e) Obey the safety procedures when you do work in the fuel tank, refer to AMM Task 28-10-00-910-001 and AMM Task 28-00-00-910-001.

(f) Remove and install fasteners in accordance with SRM 51-42-00 and SRM 51-42-11.

(g) Torque tighten standard threaded fasteners in accordance with SRM 51-49-00.

(h) Renew any damaged protective finish in accordance with SRM 51-75-12.

(i) Oversize fasteners in accordance with SRM 51-43-00.

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

(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 correct fastener grip length in accordance with SRM Chapter 51.

(m) Get fastener hole diameters, drill and de-burr data in accordance with SRM 51-44-00 and SRM 51-44-11 tables 7 and 12:

- Diameter 3 - 2nd oversize clearance fit
- Diameter 4 - 2nd oversize clearance fit
- Surface finish of holes to be 1,6.



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

(n) Apply fuel tank sealant and paint bolt heads, nuts and washers in accordance with SRM 51-76-12 and SRM 51-23-12.

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

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

**(2) Subtask 571208-839-401-001 - 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 571208-941-401-001 - Job Set-up**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-001<br>Task 12-34-24-869-002<br>Task 28-10-00-910-001<br>Task 28-10-00-910-004<br>Task 28-25-00-650-001<br>Task 28-25-00-650-003<br>Task 32-00-00-481-001<br>Task 57-27-11-000-001<br>Task 57-27-11-000-007 |

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

- Aircraft on the ground resting on landing gear (the ground safety locks and the wheel chocks are in position on the landing gear)
- Engine shut down, thrust reversers closed and locked
- Aircraft in clean configuration



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

- Parking brake applied
- Aircraft electrical network de-energized
- Hydraulic systems depressurized
- Access to the cockpit and cabin is available
- All circuit breakers are in closed position
- All controls in NORM, AUTO or OFF position.

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

(b) Make sure that the ground safety locks are in position on the MLG, refer to AMM Task 32-00-00-481-001.

(c) Defuel the aircraft, refer to AMM Task 28-25-00-650-001.

(d) Remove any remaining fuel, refer to AMM Task 28-25-00-650-003.

(e) Obey the fuel tank safety procedures, refer to AMM Task 28-10-00-910-001.

(f) Purge and vent the fuel tanks, refer to AMM Task 28-10-00-910-004.

(g) Lift the aircraft on jacks, refer to AMM Task 07-11-00-581-001.

(h) Put access platforms in position at zones 570 and 670, between Stringers 8 and 11 at Rib 2.

(i) Remove access panels 540AB and 640AB, refer to AMM Task 57-27-11-000-001.

(j) Remove access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-000-007.

****CONF 002**

**(1) Subtask 571208-941-401-001 - Job Set-up**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |



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

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-001<br>Task 12-34-24-869-002<br>Task 28-10-00-910-001<br>Task 28-10-00-910-004<br>Task 28-25-00-650-001<br>Task 28-25-00-650-003<br>Task 32-00-00-481-001<br>Task 57-27-11-000-001<br>Task 57-27-11-000-007 |

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

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

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

(b) Make sure that the ground safety locks are in position on the MLG, refer to AMM Task 32-00-00-481-001.

(c) Defuel the aircraft, refer to AMM Task 28-25-00-650-001.

(d) Remove any remaining fuel, refer to AMM Task 28-25-00-650-003.

(e) Obey the fuel tank safety procedures, refer to AMM Task 28-10-00-910-001.

(f) Purge and vent the fuel tanks, refer to AMM Task 28-10-00-910-004.

(g) Lift the aircraft on jacks, refer to AMM Task 07-11-00-581-001.

(h) Put access platforms in position at zones 570 and 670, between Stringers 8 and 11 at Rib 2.

(i) Remove access panels 540AB and 640AB, refer to AMM Task 57-27-11-000-001.



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

(j) Remove access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-000-007.

**CONF 003

**(1) Subtask 571208-941-401-001 - Job Set-up**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-001<br>Task 12-34-24-869-002<br>Task 28-10-00-910-001<br>Task 28-10-00-910-004<br>Task 28-25-00-650-001<br>Task 28-25-00-650-003<br>Task 32-00-00-481-001<br>Task 57-27-11-000-001<br>Task 57-27-11-000-007 |

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

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

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

(b) Make sure that the ground safety locks are in position on the MLG, refer to AMM Task 32-00-00-481-001.



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

(c) Defuel the aircraft, refer to AMM Task 28-25-00-650-001.

(d) Remove any remaining fuel, refer to AMM Task 28-25-00-650-003.

(e) Obey the fuel tank safety procedures, refer to AMM Task 28-10-00-910-001.

(f) Purge and vent the fuel tanks, refer to AMM Task 28-10-00-910-004.

(g) Lift the aircraft on jacks, refer to AMM Task 07-11-00-581-001.

(h) Put access platforms in position at zones 570 and 670, between Stringers 8 and 11 at Rib 2.

(i) Remove access panels 540AB and 640AB, refer to AMM Task 57-27-11-000-001.

(j) Remove access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-000-007.

**CONF 004

**(1) Subtask 571208-941-401-001 - Job Set-up**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-001<br>Task 12-34-24-869-002<br>Task 28-10-00-910-001<br>Task 28-10-00-910-004<br>Task 28-25-00-650-001<br>Task 28-25-00-650-003<br>Task 32-00-00-481-001<br>Task 57-27-11-000-001<br>Task 57-27-11-000-007 |

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

- Aircraft on the ground resting on landing gear (the ground safety locks and the wheel chocks are in position on the landing gear)
- Engine shut down, thrust reversers closed and locked
- Aircraft in clean configuration
- Parking brake applied
- Aircraft electrical network de-energized



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

- Hydraulic systems depressurized
- Access to the cockpit and cabin is available
- All circuit breakers are in closed position
- All controls in NORM, AUTO or OFF position.

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

(b) Make sure that the ground safety locks are in position on the MLG, refer to AMM Task 32-00-00-481-001.

(c) Defuel the aircraft, refer to AMM Task 28-25-00-650-001.

(d) Remove any remaining fuel, refer to AMM Task 28-25-00-650-003.

(e) Obey the fuel tank safety procedures, refer to AMM Task 28-10-00-910-001.

(f) Purge and vent the fuel tanks, refer to AMM Task 28-10-00-910-004.

(g) Lift the aircraft on jacks, refer to AMM Task 07-11-00-581-001.

(h) Put access platforms in position at zones 570 and 670, between Stringers 8 and 11 at Rib 2.

(i) Remove access panels 540AB and 640AB, refer to AMM Task 57-27-11-000-001.

(j) Remove access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-000-007.

**CONF 005

**(1) Subtask 571208-941-401-001 - Job Set-up**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-001<br>Task 12-34-24-869-002<br>Task 28-10-00-910-001<br>Task 28-10-00-910-004<br>Task 28-25-00-650-001<br>Task 28-25-00-650-003<br>Task 32-00-00-481-001<br>Task 57-27-11-000-001<br>Task 57-27-11-000-007 |



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

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

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

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

(b) Make sure that the ground safety locks are in position on the MLG, refer to AMM Task 32-00-00-481-001.

(c) Defuel the aircraft, refer to AMM Task 28-25-00-650-001.

(d) Remove any remaining fuel, refer to AMM Task 28-25-00-650-003.

(e) Obey the fuel tank safety procedures, refer to AMM Task 28-10-00-910-001.

(f) Purge and vent the fuel tanks, refer to AMM Task 28-10-00-910-004.

(g) Lift the aircraft on jacks, refer to AMM Task 07-11-00-581-001.

(h) Put access platforms in position at zones 570 and 670, between Stringers 8 and 11 at Rib 2.

(i) Remove access panels 540AB and 640AB, refer to AMM Task 57-27-11-000-001.

(j) Remove access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-000-007.

**CONF 006

**(1) Subtask 571208-941-401-001 - Job Set-up**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |



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

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-001<br>Task 12-34-24-869-002<br>Task 28-10-00-910-001<br>Task 28-10-00-910-004<br>Task 28-25-00-650-001<br>Task 28-25-00-650-003<br>Task 32-00-00-481-001<br>Task 57-27-11-000-001<br>Task 57-27-11-000-007 |

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

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

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

(b) Make sure that the ground safety locks are in position on the MLG, refer to AMM Task 32-00-00-481-001.

(c) Defuel the aircraft, refer to AMM Task 28-25-00-650-001.

(d) Remove any remaining fuel, refer to AMM Task 28-25-00-650-003.

(e) Obey the fuel tank safety procedures, refer to AMM Task 28-10-00-910-001.

(f) Purge and vent the fuel tanks, refer to AMM Task 28-10-00-910-004.

(g) Lift the aircraft on jacks, refer to AMM Task 07-11-00-581-001.



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

(h) Put access platforms in position at zones 570 and 670, between Stringers 8 and 11 at Rib 2.

(i) Remove access panels 540AB and 640AB, refer to AMM Task 57-27-11-000-001.

(j) Remove access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-000-007.

**CONF 007

**(1) Subtask 571208-941-401-001 - Job Set-up**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-001<br>Task 12-34-24-869-002<br>Task 28-10-00-910-001<br>Task 28-10-00-910-004<br>Task 28-25-00-650-001<br>Task 28-25-00-650-003<br>Task 32-00-00-481-001<br>Task 57-27-11-000-001<br>Task 57-27-11-000-007 |

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

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



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

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

(b) Make sure that the ground safety locks are in position on the MLG, refer to AMM Task 32-00-00-481-001.

(c) Defuel the aircraft, refer to AMM Task 28-25-00-650-001.

(d) Remove any remaining fuel, refer to AMM Task 28-25-00-650-003.

(e) Obey the fuel tank safety procedures, refer to AMM Task 28-10-00-910-001.

(f) Purge and vent the fuel tanks, refer to AMM Task 28-10-00-910-004.

(g) Lift the aircraft on jacks, refer to AMM Task 07-11-00-581-001.

(h) Put access platforms in position at zones 570 and 670, between Stringers 8 and 11 at Rib 2.

(i) Remove access panels 540AB and 640AB, refer to AMM Task 57-27-11-000-001.

(j) Remove access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-000-007.

**CONF 008

**(1) Subtask 571208-941-401-001 - Job Set-up**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-001<br>Task 12-34-24-869-002<br>Task 28-10-00-910-001<br>Task 28-10-00-910-004<br>Task 28-25-00-650-001<br>Task 28-25-00-650-003<br>Task 32-00-00-481-001<br>Task 57-27-11-000-001<br>Task 57-27-11-000-007 |

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

- Aircraft on the ground resting on landing gear (the ground safety locks and the wheel chocks are in position on the landing gear)

- Engine shut down, thrust reversers closed and locked



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

- Aircraft in clean configuration
- Parking brake applied
- Aircraft electrical network de-energized
- Hydraulic systems depressurized
- Access to the cockpit and cabin is available
- All circuit breakers are in closed position
- All controls in NORM, AUTO or OFF position.

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

(b) Make sure that the ground safety locks are in position on the MLG, refer to AMM Task 32-00-00-481-001.

(c) Defuel the aircraft, refer to AMM Task 28-25-00-650-001.

(d) Remove any remaining fuel, refer to AMM Task 28-25-00-650-003.

(e) Obey the fuel tank safety procedures, refer to AMM Task 28-10-00-910-001.

(f) Purge and vent the fuel tanks, refer to AMM Task 28-10-00-910-004.

(g) Lift the aircraft on jacks, refer to AMM Task 07-11-00-581-001.

(h) Put access platforms in position at zones 570 and 670, between Stringers 8 and 11 at Rib 2.

(i) Remove access panels 540AB and 640AB, refer to AMM Task 57-27-11-000-001.

(j) Remove access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-000-007.

**CONF 009

**(1) Subtask 571208-941-401-001 - Job Set-up**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |



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

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-001<br>Task 12-34-24-869-002<br>Task 28-10-00-910-001<br>Task 28-10-00-910-004<br>Task 28-25-00-650-001<br>Task 28-25-00-650-003<br>Task 32-00-00-481-001<br>Task 57-27-11-000-001<br>Task 57-27-11-000-007 |

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

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

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

(b) Make sure that the ground safety locks are in position on the MLG, refer to AMM Task 32-00-00-481-001.

(c) Defuel the aircraft, refer to AMM Task 28-25-00-650-001.

(d) Remove any remaining fuel, refer to AMM Task 28-25-00-650-003.

(e) Obey the fuel tank safety procedures, refer to AMM Task 28-10-00-910-001.

(f) Purge and vent the fuel tanks, refer to AMM Task 28-10-00-910-004.

(g) Lift the aircraft on jacks, refer to AMM Task 07-11-00-581-001.

(h) Put access platforms in position at zones 570 and 670, between Stringers 8 and 11 at Rib 2.

(i) Remove access panels 540AB and 640AB, refer to AMM Task 57-27-11-000-001.



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

(j) Remove access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-000-007.

**CONF 010

**(1) Subtask 571208-941-401-001 - Job Set-up**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-001<br>Task 12-34-24-869-002<br>Task 28-10-00-910-001<br>Task 28-10-00-910-004<br>Task 28-25-00-650-001<br>Task 28-25-00-650-003<br>Task 32-00-00-481-001<br>Task 57-27-11-000-001<br>Task 57-27-11-000-007 |

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

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

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

(b) Make sure that the ground safety locks are in position on the MLG, refer to AMM Task 32-00-00-481-001.



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

(c) Defuel the aircraft, refer to AMM Task 28-25-00-650-001.

(d) Remove any remaining fuel, refer to AMM Task 28-25-00-650-003.

(e) Obey the fuel tank safety procedures, refer to AMM Task 28-10-00-910-001.

(f) Purge and vent the fuel tanks, refer to AMM Task 28-10-00-910-004.

(g) Lift the aircraft on jacks, refer to AMM Task 07-11-00-581-001.

(h) Put access platforms in position at zones 570 and 670, between Stringers 8 and 11 at Rib 2.

(i) Remove access panels 540AB and 640AB, refer to AMM Task 57-27-11-000-001.

(j) Remove access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-000-007.

**CONF 011

**(1) Subtask 571208-941-401-001 - Job Set-up**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-001<br>Task 12-34-24-869-002<br>Task 28-10-00-910-001<br>Task 28-10-00-910-004<br>Task 28-25-00-650-001<br>Task 28-25-00-650-003<br>Task 32-00-00-481-001<br>Task 57-27-11-000-001<br>Task 57-27-11-000-007 |

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

- Aircraft on the ground resting on landing gear (the ground safety locks and the wheel chocks are in position on the landing gear)
- Engine shut down, thrust reversers closed and locked
- Aircraft in clean configuration
- Parking brake applied
- Aircraft electrical network de-energized



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

- Hydraulic systems depressurized
- Access to the cockpit and cabin is available
- All circuit breakers are in closed position
- All controls in NORM, AUTO or OFF position.

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

(b) Make sure that the ground safety locks are in position on the MLG, refer to AMM Task 32-00-00-481-001.

(c) Defuel the aircraft, refer to AMM Task 28-25-00-650-001.

(d) Remove any remaining fuel, refer to AMM Task 28-25-00-650-003.

(e) Obey the fuel tank safety procedures, refer to AMM Task 28-10-00-910-001.

(f) Purge and vent the fuel tanks, refer to AMM Task 28-10-00-910-004.

(g) Lift the aircraft on jacks, refer to AMM Task 07-11-00-581-001.

(h) Put access platforms in position at zones 570 and 670, between Stringers 8 and 11 at Rib 2.

(i) Remove access panels 540AB and 640AB, refer to AMM Task 57-27-11-000-001.

(j) Remove access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-000-007.

**CONF 012

**(1) Subtask 571208-941-401-001 - Job Set-up**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-001<br>Task 12-34-24-869-002<br>Task 28-10-00-910-001<br>Task 28-10-00-910-004<br>Task 28-25-00-650-001<br>Task 28-25-00-650-003<br>Task 32-00-00-481-001<br>Task 57-27-11-000-001<br>Task 57-27-11-000-007 |



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

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

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

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

(b) Make sure that the ground safety locks are in position on the MLG, refer to AMM Task 32-00-00-481-001.

(c) Defuel the aircraft, refer to AMM Task 28-25-00-650-001.

(d) Remove any remaining fuel, refer to AMM Task 28-25-00-650-003.

(e) Obey the fuel tank safety procedures, refer to AMM Task 28-10-00-910-001.

(f) Purge and vent the fuel tanks, refer to AMM Task 28-10-00-910-004.

(g) Lift the aircraft on jacks, refer to AMM Task 07-11-00-581-001.

(h) Put access platforms in position at zones 570 and 670, between Stringers 8 and 11 at Rib 2.

(i) Remove access panels 540AB and 640AB, refer to AMM Task 57-27-11-000-001.

(j) Remove access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-000-007.

**CONF 013

**(1) Subtask 571208-941-401-001 - Job Set-up**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |



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

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-001<br>Task 12-34-24-869-002<br>Task 28-10-00-910-001<br>Task 28-10-00-910-004<br>Task 28-25-00-650-001<br>Task 28-25-00-650-003<br>Task 32-00-00-481-001<br>Task 57-27-11-000-001<br>Task 57-27-11-000-007 |

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

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

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

(b) Make sure that the ground safety locks are in position on the MLG, refer to AMM Task 32-00-00-481-001.

(c) Defuel the aircraft, refer to AMM Task 28-25-00-650-001.

(d) Remove any remaining fuel, refer to AMM Task 28-25-00-650-003.

(e) Obey the fuel tank safety procedures, refer to AMM Task 28-10-00-910-001.

(f) Purge and vent the fuel tanks, refer to AMM Task 28-10-00-910-004.

(g) Lift the aircraft on jacks, refer to AMM Task 07-11-00-581-001.



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

(h) Put access platforms in position at zones 570 and 670, between Stringers 8 and 11 at Rib 2.

(i) Remove access panels 540AB and 640AB, refer to AMM Task 57-27-11-000-001.

(j) Remove access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-000-007.

**CONF 014

**(1) Subtask 571208-941-401-001 - Job Set-up**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-001<br>Task 12-34-24-869-002<br>Task 28-10-00-910-001<br>Task 28-10-00-910-004<br>Task 28-25-00-650-001<br>Task 28-25-00-650-003<br>Task 32-00-00-481-001<br>Task 57-27-11-000-001<br>Task 57-27-11-000-007 |

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

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



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

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

(b) Make sure that the ground safety locks are in position on the MLG, refer to AMM Task 32-00-00-481-001.

(c) Defuel the aircraft, refer to AMM Task 28-25-00-650-001.

(d) Remove any remaining fuel, refer to AMM Task 28-25-00-650-003.

(e) Obey the fuel tank safety procedures, refer to AMM Task 28-10-00-910-001.

(f) Purge and vent the fuel tanks, refer to AMM Task 28-10-00-910-004.

(g) Lift the aircraft on jacks, refer to AMM Task 07-11-00-581-001.

(h) Put access platforms in position at zones 570 and 670, between Stringers 8 and 11 at Rib 2.

(i) Remove access panels 540AB and 640AB, refer to AMM Task 57-27-11-000-001.

(j) Remove access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-000-007.

**CONF 015

**(1) Subtask 571208-941-401-001 - Job Set-up**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-001<br>Task 12-34-24-869-002<br>Task 28-10-00-910-001<br>Task 28-10-00-910-004<br>Task 28-25-00-650-001<br>Task 28-25-00-650-003<br>Task 32-00-00-481-001<br>Task 57-27-11-000-001<br>Task 57-27-11-000-007 |

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

- Aircraft on the ground resting on landing gear (the ground safety locks and the wheel chocks are in position on the landing gear)

- Engine shut down, thrust reversers closed and locked



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

- Aircraft in clean configuration
- Parking brake applied
- Aircraft electrical network de-energized
- Hydraulic systems depressurized
- Access to the cockpit and cabin is available
- All circuit breakers are in closed position
- All controls in NORM, AUTO or OFF position.

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

(b) Make sure that the ground safety locks are in position on the MLG, refer to AMM Task 32-00-00-481-001.

(c) Defuel the aircraft, refer to AMM Task 28-25-00-650-001.

(d) Remove any remaining fuel, refer to AMM Task 28-25-00-650-003.

(e) Obey the fuel tank safety procedures, refer to AMM Task 28-10-00-910-001.

(f) Purge and vent the fuel tanks, refer to AMM Task 28-10-00-910-004.

(g) Lift the aircraft on jacks, refer to AMM Task 07-11-00-581-001.

(h) Put access platforms in position at zones 570 and 670, between Stringers 8 and 11 at Rib 2.

(i) Remove access panels 540AB and 640AB, refer to AMM Task 57-27-11-000-001.

(j) Remove access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-000-007.

**CONF 016

**(1) Subtask 571208-941-401-001 - Job Set-up**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |



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

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-001<br>Task 12-34-24-869-002<br>Task 28-10-00-910-001<br>Task 28-10-00-910-004<br>Task 28-25-00-650-001<br>Task 28-25-00-650-003<br>Task 32-00-00-481-001<br>Task 57-27-11-000-001<br>Task 57-27-11-000-007 |

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

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

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

(b) Make sure that the ground safety locks are in position on the MLG, refer to AMM Task 32-00-00-481-001.

(c) Defuel the aircraft, refer to AMM Task 28-25-00-650-001.

(d) Remove any remaining fuel, refer to AMM Task 28-25-00-650-003.

(e) Obey the fuel tank safety procedures, refer to AMM Task 28-10-00-910-001.

(f) Purge and vent the fuel tanks, refer to AMM Task 28-10-00-910-004.

(g) Lift the aircraft on jacks, refer to AMM Task 07-11-00-581-001.

(h) Put access platforms in position at zones 570 and 670, between Stringers 8 and 11 at Rib 2.

(i) Remove access panels 540AB and 640AB, refer to AMM Task 57-27-11-000-001.



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

(j) Remove access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-000-007.

**CONF 017

**(1) Subtask 571208-941-401-001 - Job Set-up**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | NON SPECIFIC |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-001<br>Task 12-34-24-869-002<br>Task 28-10-00-910-001<br>Task 28-10-00-910-004<br>Task 28-25-00-650-001<br>Task 28-25-00-650-003<br>Task 32-00-00-481-001<br>Task 57-27-11-000-001<br>Task 57-27-11-000-007 |

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

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

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

(b) Make sure that the ground safety locks are in position on the MLG, refer to AMM Task 32-00-00-481-001.



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

(c) Defuel the aircraft, refer to AMM Task 28-25-00-650-001.

(d) Remove any remaining fuel, refer to AMM Task 28-25-00-650-003.

(e) Obey the fuel tank safety procedures, refer to AMM Task 28-10-00-910-001.

(f) Purge and vent the fuel tanks, refer to AMM Task 28-10-00-910-004.

(g) Lift the aircraft on jacks, refer to AMM Task 07-11-00-581-001.

(h) Put access platforms in position at zones 570 and 670, between Stringers 8 and 11 at Rib 2.

(i) Remove access panels 540AB and 640AB, refer to AMM Task 57-27-11-000-001.

(j) Remove access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-000-007.

****CONF ALL**

## C. PROCEDURE

CAUTION: IF ANY OF THE REMOVED FASTENERS ARE FOUND TO BE ALREADY OVERSIZED, CONTACT AIRBUS FOR FURTHER INSTRUCTIONS.

WORK MUST BE CARRIED OUT ON NO MORE THAN ONE RIB AT A TIME IN EACH WING. DO NOT REMOVE FASTENERS FROM TWO CONSECUTIVE STRINGER POSITIONS AT ANY ONE TIME AND FOR EACH CLEAT MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STRINGER AT ALL TIMES WITH SUFFICIENT CLAMPING, OTHERWISE DAMAGE TO THE AIRCRAFT STRUCTURE CAN OCCUR.

THIS SERVICE BULLETIN MUST BE ACCOMPLISHED ON THE INBOARD SIDE BEFORE THE OUTBOARD SIDE AT EACH RIB POSITION.

****CONF 001**

### (1) Subtask 571208-020-401-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAA<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STRINGER AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK AND FROM INSIDE THE VENT BOX STGRs 13 THRU 14.

(a) At Rib 2 LH between STGRs 2 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAA Sheet 01, remove:

| | | |
|---|---|---|
| 32 | Fasteners | Discard |

**(2) Subtask 571208-320-401-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAA<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



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

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14 WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 LH between STGRs 2 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAA Sheet 01 and Fig. A-UBAAA Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(3) Subtask 571208-250-402-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Work location | Rib 2<br>from Stringer 2 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAA<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAA Sheet 01 and Fig. A-UBAAA Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(4) Subtask 571208-831-401-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B01R03 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 12 | NAS1751-4L5 | 4 | BOLT BLN | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B01 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAA<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |



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

(a) At Rib 2 LH between STGRs 2 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAA Sheet 01 and Fig. A-UBAAA Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 4 | Bolt - Blind | NAS1751-4L5 | Item 12 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 LH between STGRs 2 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAA Sheet 01 and Fig. A-UBAAA Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

(c) At Rib 2 LH between STGRs 13 and 14 in accordance with SRM 51-76-12, overseal the heads of the Blind Bolts, Item 12, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

**(5) Subtask 571208-000-401-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAA<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK AND FROM INSIDE THE VENT BOX STGRs 13 THRU 14.

(a) At Rib 2 RH between STGRs 2 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAA Sheet 01, remove:

| | | |
|---|---|---|
| 32 | Fasteners | Discard |

**(6) Subtask 571208-320-403-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAA<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



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

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 RH between STGRs 2 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAA Sheet 01 and Fig. A-UBAAA Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(7) Subtask 571208-250-403-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAA<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAA Sheet 01 and Fig. A-UBAAA Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(8) Subtask 571208-831-402-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B01R03 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 12 | NAS1751-4L5 | 4 | BOLT BLN | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B01 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAA<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |



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

(a) At Rib 2 RH between STGRs 2 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAA Sheet 01 and Fig. A-UBAAA Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 4 | Bolt - Blind | NAS1751-4L5 | Item 12 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 RH between STGRs 2 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAA Sheet 01 and Fig. A-UBAAA Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

(c) At Rib 2 RH between STGRs 13 and 14 in accordance with SRM 51-76-12, overseal the heads of the Blind Bolts, Item 12, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

**(9) Subtask 571208-020-402-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAA<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK AND FROM INSIDE THE VENT BOX STGRs 13 THRU 14.

(a) At Rib 3 LH between STGRs 3 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAA Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(10) Subtask 571208-320-404-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAA<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



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

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 LH between STGRs 3 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAA Sheet 01 and Fig. A-UBBAA Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(11) Subtask 571208-250-404-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAA<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAA Sheet 01 and Fig. A-UBBAA Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(12) Subtask 571208-831-403-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

Material necessary to do the job

Kit 571208B03R02

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 13 | NAS1751-4L6 | 4 | BOLT BLN | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B03 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

Consumable CMLB01

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAA<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



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

(a) At Rib 3 LH between STGRs 3 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAA Sheet 01 and Fig. A-UBBAA Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 4 | Bolt - Blind | NAS1751-4L6 | Item 13 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 LH between STGRs 3 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAA Sheet 01 and Fig. A-UBBAA Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

(c) At Rib 3 LH between STGRs 13 and 14 in accordance with SRM 51-76-12, overseal the heads of the Blind Bolts, Item 13, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

**(13) Subtask 571208-020-403-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAA<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK AND FROM INSIDE THE VENT BOX STGRs 13 THRU 14.

(a) At Rib 3 RH between STGRs 3 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAA Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(14) Subtask 571208-320-405-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAA<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



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

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 RH between STGRs 3 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAA Sheet 01 and Fig. A-UBBAA Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(15) Subtask 571208-250-405-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAA<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAA Sheet 01 and Fig. A-UBBAA Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(16) Subtask 571208-831-404-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

Material necessary to do the job

Kit 571208B03R02

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 13 | NAS1751-4L6 | 4 | BOLT BLN | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B03 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

Consumable CMLB01

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAA<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



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

(a) At Rib 3 RH between STGRs 3 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAA Sheet 01 and Fig. A-UBBAA Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 4 | Bolt - Blind | NAS1751-4L6 | Item 13 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 RH between STGRs 3 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAA Sheet 01 and Fig. A-UBBAA Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

(c) At Rib 3 RH between STGRs 13 and 14 in accordance with SRM 51-76-12, overseal the heads of the Blind Bolts, Item 13, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

**(17) Subtask 571208-020-404-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAA<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK AND FROM INSIDE THE VENT BOX STGRs 13 THRU 14.

(a) At Rib 4 LH between STGRs 3 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAA Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(18) Subtask 571208-320-410-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAA<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



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

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 LH between STGRs 3 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAA Sheet 01 and Fig. A-UBCAA Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(19) Subtask 571208-250-406-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAA<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAA Sheet 01 and Fig. A-UBCAA Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(20) Subtask 571208-831-405-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

Material necessary to do the job

| Kit 571208B06R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 13 | NAS1751-4L6 | 4 | BOLT BLN | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B06 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAA<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



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

(a) At Rib 4 LH between STGRs 3 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAA Sheet 01 and Fig. A-UBCAA Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 4 | Bolt - Blind | NAS1751-4L6 | Item 13 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 LH between STGRs 3 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAA Sheet 01 and Fig. A-UBCAA Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

(c) At Rib 4 LH between STGRs 13 and 14 in accordance with SRM 51-76-12, overseal the heads of the Blind Bolts, Item 13, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

**(21) Subtask 571208-020-405-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAA<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK AND FROM INSIDE THE VENT BOX STGRs 13 THRU 14.

(a) At Rib 4 RH between STGRs 3 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAA Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(22) Subtask 571208-320-407-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAA<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



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

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 RH between STGRs 3 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAA Sheet 01 and Fig. A-UBCAA Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(23) Subtask 571208-250-407-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAA<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAA Sheet 01 and Fig. A-UBCAA Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(24) Subtask 571208-831-406-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

Material necessary to do the job

| Kit 571208B06R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 13 | NAS1751-4L6 | 4 | BOLT BLN | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B06 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAA<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



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

(a) At Rib 4 RH between STGRs 3 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAA Sheet 01 and Fig. A-UBCAA Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 4 | Bolt - Blind | NAS1751-4L6 | Item 13 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 RH between STGRs 3 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAA Sheet 01 and Fig. A-UBCAA Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

(c) At Rib 4 RH between STGRs 13 and 14 in accordance with SRM 51-76-12, overseal the heads of the Blind Bolts, Item 13, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

**(25) Subtask 571208-020-406-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAA<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK AND FROM INSIDE THE VENT BOX STGRs 13 THRU 14.

(a) At Rib 5 LH between STGRs 4 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAA Sheet 01, remove:

| | | |
|---|---|---|
| 26 | Fasteners | Discard |

**(26) Subtask 571208-320-408-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAA<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03 |



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

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 LH between STGRs 4 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAA Sheet 01 and Fig. A-UBDAA Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(27) Subtask 571208-250-408-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAA<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 5 LH between STGRs 4 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAA Sheet 01 and Fig. A-UBDAA Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(28) Subtask 571208-831-407-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

Kit 571208B08R02

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 6 | EN6115V4Y5 | 4 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 13 | NAS1751-4L6 | 4 | BOLT BLN | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B08 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

Consumable CMLB01

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAA<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03 |



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

(a) At Rib 5 LH between STGRs 4 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAA Sheet 01 and Fig. A-UBDAA Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 4 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt - Blind | NAS1751-4L6 | Item 13 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 LH between STGRs 4 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAA Sheet 01 and Fig. A-UBDAA Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

(c) At Rib 5 LH between STGRs 13 and 14 in accordance with SRM 51-76-12, overseal the heads of the Blind Bolts, Item 13, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

**(29) Subtask 571208-020-407-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAA<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK AND FROM INSIDE THE VENT BOX STGRs 13 THRU 14.

(a) At Rib 5 RH at STGR 4 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAA Sheet 01, remove:

| | | |
|---|---|---|
| 26 | Fasteners | Discard |

**(30) Subtask 571208-320-409-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAA<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03 |



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

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 RH at STGR 4 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAA Sheet 01 and Fig. A-UBDAA Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(31) Subtask 571208-250-409-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAA<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 5 RH at STGR 4 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAA Sheet 01 and Fig. A-UBDAA Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(32) Subtask 571208-831-408-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

Material necessary to do the job

Kit 571208B08R02

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 6 | EN6115V4Y5 | 4 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 13 | NAS1751-4L6 | 4 | BOLT BLN | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B08 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

Consumable CMLB01

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAA<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03 |



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

(a) At Rib 5 RH at STGR 4 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAA Sheet 01 and Fig. A-UBDAA Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 4 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt - Blind | NAS1751-4L6 | Item 13 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 RH at STGR 4 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAA Sheet 01 and Fig. A-UBDAA Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

(c) At Rib 5 RH between STGRs 13 and 14 in accordance with SRM 51-76-12, overseal the heads of the Blind Bolts, Item 13, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

**(33) Subtask 571208-020-408-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAA<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK AND FROM INSIDE THE VENT BOX STGRs 13 THRU 14.

(a) At Rib 6 LH at STGRs 5 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAA Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fastener | Discard |

**(34) Subtask 571208-320-414-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAA<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |



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

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 LH at STGRs 5 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBEAA Sheet 01 and Fig. A-UBEAA Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(35) Subtask 571208-250-410-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAA<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 LH at STGRs 5 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAA Sheet 01 and Fig. A-UBEAA Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(36) Subtask 571208-831-409-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

Material necessary to do the job

Kit 571208B17R03

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 4 | EN6115V3A7 | 1 | BOLT | |
| 6 | EN6115V4Y5 | 3 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 13 | NAS1751-4L6 | 4 | BOLT BLN | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |

NOTE: Kit B17 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

Consumable CMLB01

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAA<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |



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

(a) At Rib 6 LH at STGRs 5 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAA Sheet 01 and Fig. A-UBEAA Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3A7 | Item 4 |
| 3 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 4 | Bolt - Blind | NAS1751-4L6 | Item 13 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 19 | Nut | ASNA2531-4 | Item 15 |
| 38 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 LH at STGRs 5 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAA Sheet 01 and Fig. A-UBEAA Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

(c) At Rib 6 LH between STGRs 13 and 14 in accordance with SRM 51-76-12, overseal the heads of the Blind Bolts, Item 13, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |



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

**(37) Subtask 571208-020-409-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAA<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK AND FROM INSIDE THE VENT BOX STGRs 13 THRU 14.

(a) At Rib 6 RH at STGRs 5 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAA Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fastener | Discard |

**(38) Subtask 571208-320-415-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAA<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH

At Rib 6 RH at STGRs 5 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBEAA Sheet 01 and Fig. A-UBEAA Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(39) Subtask 571208-250-411-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |



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

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAA<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAA Sheet 01 and Fig. A-UBEAA Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(40) Subtask 571208-831-410-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B17R03 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 4 | EN6115V3A7 | 1 | BOLT | |
| 6 | EN6115V4Y5 | 3 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 13 | NAS1751-4L6 | 4 | BOLT BLN | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |

NOTE: Kit B17 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.



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

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAA<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAA Sheet 01 and Fig. A-UBEAA Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3A7 | Item 4 |
| 3 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 4 | Bolt - Blind | NAS1751-4L6 | Item 13 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 19 | Nut | ASNA2531-4 | Item 15 |
| 38 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



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

(b) At Rib 6 RH at STGRs 5 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAA Sheet 01 and Fig. A-UBEAA Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

(c) At Rib 6 RH between STGRs 13 and 14 in accordance with SRM 51-76-12, overseal the heads of the Blind Bolts, Item 13, with:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

**(41) Subtask 571208-020-410-005 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK AND FROM INSIDE THE VENT BOX STGRs 13 THRU 14.

(a) At Rib 6B LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBFAA Sheet 01, remove:

2 Fastener Discard



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

**(42) Subtask 571208-320-419-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH

At Rib 6B LH at STGR 5 in accordance with SRM 51-44-11 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(43) Subtask 571208-250-412-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |



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

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B LH at STGR 5 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(44) Subtask 571208-831-411-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B26R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 2 | EN6115V3A5 | 2 | BOLT | |
| 14 | ASNA2531-3A | 2 | NUT HEX | |

NOTE: Kit B26 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.



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

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

2 Bolt EN6115V3A5 Item 2

2 Nut ASNA2531-3A Item 14

(b) At Rib 6B LH at STGR 5 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(45) Subtask 571208-020-411-005 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B |



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

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK AND FROM INSIDE THE VENT BOX STGRs 13 THRU 14.

(a) At Rib 6B RH at STGR 5 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBFAA Sheet 01, remove:

| | | |
|---|---|---|
| 2 | Fastener | Discard |

**(46) Subtask 571208-320-418-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |



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

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6B RH at STGR 5 in accordance with SRM 51-44-11 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(47) Subtask 571208-250-413-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B RH at STGR 5 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(48) Subtask 571208-831-412-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B26R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 2 | EN6115V3A5 | 2 | BOLT | |
| 14 | ASNA2531-3A | 2 | NUT HEX | |

NOTE: Kit B26 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required



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

to wet install:

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V3A5 | Item 2 |
| 2 | Nut | ASNA2531-3A | Item 14 |

(b) At Rib 6B RH at STGR 5 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(49) Subtask 571208-020-412-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAA<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK AND FROM INSIDE THE VENT BOX STGRs 13 THRU 14.

(a) At Rib 7 LH at STGRs 5 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAA Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fastener | Discard |



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

**(50) Subtask 571208-320-417-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAA<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 LH at STGRs 5 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAA Sheet 01 and Fig. A-UBGAA Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(51) Subtask 571208-250-414-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAA<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAA Sheet 01 and Fig. A-UBGAA Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(52) Subtask 571208-831-413-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

Kit 571208B29R02

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 7 | EN6115V4Y6 | 18 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 12 | NAS1751-4L5 | 4 | BOLT BLN | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B29 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.



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

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAA<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAA Sheet 01 and Fig. A-UBGAA Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 18 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 4 | Bolt - Blind | NAS1751-4L5 | Item 12 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



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

(b) At Rib 7 LH at STGRs 5 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAA Sheet 01 and Fig. A-UBGAA Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

(c) At Rib 7 LH between STGRs 13 and 14 in accordance with SRM 51-76-12, overseal the heads of the Blind Bolts, Item 13, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

**(53) Subtask 571208-020-413-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAA<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK AND FROM INSIDE THE VENT BOX STGRs 13 THRU 14.

(a) At Rib 7 RH at STGRs 5 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAA Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fastener | Discard |



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

**(54) Subtask 571208-320-416-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAA<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 RH at STGRs 5 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAA Sheet 01 and Fig. A-UBGAA Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(55) Subtask 571208-250-415-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAA<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAA Sheet 01 and Fig. A-UBGAA Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(56) Subtask 571208-831-414-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B29R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 18 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 12 | NAS1751-4L5 | 4 | BOLT BLN | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B29 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.



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

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAA<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAA Sheet 01 and Fig. A-UBGAA Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 18 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 4 | Bolt - Blind | NAS1751-4L5 | Item 12 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



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

(b) At Rib 7 RH at STGRs 5 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAA Sheet 01 and Fig. A-UBGAA Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

(c) At Rib 7 RH between STGRs 13 and 14 in accordance with SRM 51-76-12, overseal the heads of the Blind Bolts, Item 13, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

**(57) Subtask 571208-960-401-001 - Replace the LP Fuel Filters**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 400 | |

| Manpower Resources | |
|---|---|
| Manhours | 1.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.50 |
| Skills | ENGINE |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 73-11-10-920-001<br>Task 73-12-42-920-010 |

(a) Replace the LP fuel filter elements at Engine 1 (1000EM1), Engine 2 (1000EM2):

- if CFM engines are installed, refer to AMM Task 73-11-10-920-001.
- if IAE engines are installed, refer to AMM Task 73-12-42-920-010.

****CONF 002**

**(1) Subtask 571208-020-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



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

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(2) Subtask 571208-320-401-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |



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

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(3) Subtask 571208-250-402-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(4) Subtask 571208-831-401-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |



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

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(5) Subtask 571208-000-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |



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

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(6) Subtask 571208-320-403-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



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

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(7) Subtask 571208-250-403-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(8) Subtask 571208-831-402-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



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

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |



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

| | | | |
|---|---|---|---|
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(9) Subtask 571208-020-402-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



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

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(10) Subtask 571208-320-404-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



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

**(11) Subtask 571208-250-404-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(12) Subtask 571208-831-403-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



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

| Material necessary to do the job |
|---|

| Kit 571208B04R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B04 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



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

(b) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(13) Subtask 571208-020-403-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |



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

**(14) Subtask 571208-320-405-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(15) Subtask 571208-250-405-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(16) Subtask 571208-831-404-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B04R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B04 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.



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

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



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

**(17) Subtask 571208-020-404-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(18) Subtask 571208-320-410-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(19) Subtask 571208-250-406-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



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

| References | |
|---|---|
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(20) Subtask 571208-831-405-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12 install the fasteners from the AFT side of the stringer to make sure that there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(21) Subtask 571208-020-405-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(22) Subtask 571208-320-407-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



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

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(23) Subtask 571208-250-407-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(24) Subtask 571208-831-406-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



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

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(25) Subtask 571208-020-406-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAB<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAB Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(26) Subtask 571208-320-408-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAB<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



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

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAB Sheet 01 and Fig. A-UBDAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(27) Subtask 571208-250-408-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAB<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAB Sheet 01 and Fig. A-UBDAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(28) Subtask 571208-831-407-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B09R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 6 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B09 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAB<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |



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

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAB Sheet 01 and Fig. A-UBDAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 6 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAB Sheet 01 and Fig. A-UBDAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(29) Subtask 571208-020-407-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAB<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIME SAND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAB Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(30) Subtask 571208-320-409-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAB<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



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

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAB Sheet 01 and Fig. A-UBDAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(31) Subtask 571208-250-409-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAB<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAB Sheet 01 and Fig. A-UBDAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(32) Subtask 571208-831-408-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B09R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 6 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B09 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAB<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |



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

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAB Sheet 01 and Fig. A-UBDAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 6 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAB Sheet 01 and Fig. A-UBDAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(33) Subtask 571208-020-408-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAB<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(34) Subtask 571208-320-414-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAB<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



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

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBEAB Sheet 01 and Fig. A-UBEAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(35) Subtask 571208-250-410-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAB<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAB Sheet 01 and Fig. A-UBEAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(36) Subtask 571208-831-409-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B18R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 2 | EN6115V3A5 | 1 | BOLT | |
| 6 | EN6115V4Y5 | 3 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |

NOTE: Kit B18 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAB<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |



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

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAB Sheet 01 and Fig. A-UBEAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3A5 | Item 2 |
| 3 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 19 | Nut | ASNA2531-4 | Item 15 |
| 38 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAB Sheet 01 and Fig. A-UBEAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(37) Subtask 571208-020-409-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAB<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(38) Subtask 571208-320-415-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAB<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |



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

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBEAB Sheet 01 and Fig. A-UBEAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(39) Subtask 571208-250-411-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAB<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAB Sheet 01 and Fig. A-UBEAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(40) Subtask 571208-831-410-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B18R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 2 | EN6115V3A5 | 1 | BOLT | |
| 6 | EN6115V4Y5 | 3 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |

NOTE: Kit B18 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAB<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |



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

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAB Sheet 01 and Fig. A-UBEAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3A5 | Item 2 |
| 3 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 19 | Nut | ASNA2531-4 | Item 15 |
| 38 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAB Sheet 01 and Fig. A-UBEAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(41) Subtask 571208-020-412-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(42) Subtask 571208-320-417-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |



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

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(43) Subtask 571208-250-414-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(44) Subtask 571208-831-413-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B30R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 18 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B30 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |



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

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 18 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(45) Subtask 571208-020-413-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(46) Subtask 571208-320-416-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



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

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(47) Subtask 571208-250-415-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(48) Subtask 571208-831-414-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B30R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 18 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B30 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |



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

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 18 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(49) Subtask 571208-960-401-001 - Replace the LP Fuel Filters**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 400 | |

| Manpower Resources | |
|---|---|
| Manhours | 1.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.50 |
| Skills | ENGINE |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 73-11-10-920-001<br>Task 73-12-42-920-010 |



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

(a) Replace the LP fuel filter elements at Engine 1 (1000EM1), Engine 2 (1000EM2):

- if CFM engines are installed, refer to AMM Task 73-11-10-920-001.
- if IAE engines are installed, refer to AMM Task 73-12-42-920-010.

**CONF 003

**(1) Subtask 571208-020-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |



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

**(2) Subtask 571208-320-401-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(3) Subtask 571208-250-402-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



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

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(4) Subtask 571208-831-401-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.



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

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



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

**(5) Subtask 571208-000-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(6) Subtask 571208-320-403-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



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

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(7) Subtask 571208-250-403-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



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

| References | |
|---|---|
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(8) Subtask 571208-831-402-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(9) Subtask 571208-020-402-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(10) Subtask 571208-320-404-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



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

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(11) Subtask 571208-250-404-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(12) Subtask 571208-831-403-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B04R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B04 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



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

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(13) Subtask 571208-020-403-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



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

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(14) Subtask 571208-320-405-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



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

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(15) Subtask 571208-250-405-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(16) Subtask 571208-831-404-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B04R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B04 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |



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

| | | | |
|---|---|---|---|
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(17) Subtask 571208-020-404-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



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

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(18) Subtask 571208-320-410-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



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

**(19) Subtask 571208-250-406-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(20) Subtask 571208-831-405-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



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

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12 install the fasteners from the AFT side of the stringer to make sure that there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |



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

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(21) Subtask 571208-020-405-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |



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

**(22) Subtask 571208-320-407-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(23) Subtask 571208-250-407-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(24) Subtask 571208-831-406-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.



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

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



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

**(25) Subtask 571208-020-406-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAC<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAC Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(26) Subtask 571208-320-408-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAC<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAC Sheet 01 and Fig. A-UBDAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(27) Subtask 571208-250-408-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



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

| References | |
|---|---|
| Fig. A-UBDAC<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAC Sheet 01 and Fig. A-UBDAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(28) Subtask 571208-831-407-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B10R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 4 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B10 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |



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

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAC<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAC Sheet 01 and Fig. A-UBDAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 4 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAC Sheet 01 and Fig. A-UBDAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



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

**(29) Subtask 571208-020-407-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAC<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAC Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(30) Subtask 571208-320-409-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAC<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAC Sheet 01 and Fig. A-UBDAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(31) Subtask 571208-250-409-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



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

| References | |
|---|---|
| Fig. A-UBDAC<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAC Sheet 01 and Fig. A-UBDAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(32) Subtask 571208-831-408-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B10R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 4 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B10 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |



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

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAC<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAC Sheet 01 and Fig. A-UBDAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 4 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAC Sheet 01 and Fig. A-UBDAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



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

**(33) Subtask 571208-020-408-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAC<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(34) Subtask 571208-320-414-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAC<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBEAC Sheet 01 and Fig. A-UBEAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(35) Subtask 571208-250-410-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



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

| References | |
|---|---|
| Fig. A-UBEAC<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAC Sheet 01 and Fig. A-UBEAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(36) Subtask 571208-831-409-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B19R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B19 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |



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

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAC<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAC Sheet 01 and Fig. A-UBEAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAC Sheet 01 and Fig. A-UBEAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



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

**(37) Subtask 571208-020-409-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAC<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(38) Subtask 571208-320-415-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAC<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBEAC Sheet 01 and Fig. A-UBEAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(39) Subtask 571208-250-411-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



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

| References | |
|---|---|
| Fig. A-UBEAC<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAC Sheet 01 and Fig. A-UBEAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(40) Subtask 571208-831-410-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B19R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B19 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |



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

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAC<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAC Sheet 01 and Fig. A-UBEAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAC Sheet 01 and Fig. A-UBEAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



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

**(41) Subtask 571208-020-412-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(42) Subtask 571208-320-417-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(43) Subtask 571208-250-414-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



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

| References | |
|---|---|
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(44) Subtask 571208-831-413-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B30R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 18 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B30 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 18 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(45) Subtask 571208-020-413-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(46) Subtask 571208-320-416-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |



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

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(47) Subtask 571208-250-415-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(48) Subtask 571208-831-414-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B30R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 18 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B30 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |



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

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 18 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(49) Subtask 571208-960-401-001 - Replace the LP Fuel Filters**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 400 | |

| Manpower Resources | |
|---|---|
| Manhours | 1.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.50 |
| Skills | ENGINE |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 73-11-10-920-001<br>Task 73-12-42-920-010 |



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

(a) Replace the LP fuel filter elements at Engine 1 (1000EM1), Engine 2 (1000EM2):

- if CFM engines are installed, refer to AMM Task 73-11-10-920-001.
- if IAE engines are installed, refer to AMM Task 73-12-42-920-010.

**CONF 004

**(1) Subtask 571208-020-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |



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

**(2) Subtask 571208-320-401-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(3) Subtask 571208-250-402-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



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

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(4) Subtask 571208-831-401-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.



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

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



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

**(5) Subtask 571208-000-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(6) Subtask 571208-320-403-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



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

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(7) Subtask 571208-250-403-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



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

| References | |
|---|---|
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(8) Subtask 571208-831-402-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(9) Subtask 571208-020-402-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(10) Subtask 571208-320-404-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



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

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(11) Subtask 571208-250-404-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(12) Subtask 571208-831-403-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B04R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B04 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



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

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(13) Subtask 571208-020-403-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



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

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(14) Subtask 571208-320-405-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



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

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(15) Subtask 571208-250-405-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(16) Subtask 571208-831-404-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B04R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B04 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |



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

| | | | |
|---|---|---|---|
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(17) Subtask 571208-020-404-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



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

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(18) Subtask 571208-320-410-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



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

**(19) Subtask 571208-250-406-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(20) Subtask 571208-831-405-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



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

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12 install the fasteners from the AFT side of the stringer to make sure that there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |



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

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(21) Subtask 571208-020-405-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |



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

**(22) Subtask 571208-320-407-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(23) Subtask 571208-250-407-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(24) Subtask 571208-831-406-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.



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

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



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

**(25) Subtask 571208-020-406-005 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAD<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAD Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(26) Subtask 571208-320-408-005 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAD<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAD Sheet 01 and Fig. A-UBDAD Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(27) Subtask 571208-250-408-005 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



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

| References | |
|---|---|
| Fig. A-UBDAD<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAD Sheet 01 and Fig. A-UBDAD Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(28) Subtask 571208-831-407-005 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B11R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 4 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B11 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |



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

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAD<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAD Sheet 01 and Fig. A-UBDAD Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 4 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAD Sheet 01 and Fig. A-UBDAD Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



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

**(29) Subtask 571208-020-407-005 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAD<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAD Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(30) Subtask 571208-320-409-005 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAD<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAD Sheet 01 and Fig. A-UBDAD Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(31) Subtask 571208-250-409-005 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



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

| References | |
|---|---|
| Fig. A-UBDAD<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAD Sheet 01 and Fig. A-UBDAD Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(32) Subtask 571208-831-408-005 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B11R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 4 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B11 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |



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

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAD<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAD Sheet 01 and Fig. A-UBDAD Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 4 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAD Sheet 01 and Fig. A-UBDAD Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



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

**(33) Subtask 571208-020-408-004 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAD<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMESAND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAD Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(34) Subtask 571208-320-414-004 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAD<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBEAD Sheet 01 and Fig. A-UBEAD Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(35) Subtask 571208-250-410-004 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



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

| References | |
|---|---|
| Fig. A-UBEAD<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAD Sheet 01 and Fig. A-UBEAD Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(36) Subtask 571208-831-409-004 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B20R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 4 | EN6115V3A7 | 1 | BOLT | |
| 6 | EN6115V4Y5 | 3 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |

NOTE: Kit B20 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.



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

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAD<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAD Sheet 01 and Fig. A-UBEAD Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3A7 | Item 4 |
| 3 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 19 | Nut | ASNA2531-4 | Item 15 |
| 38 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



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

(b) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAD Sheet 01 and Fig. A-UBEAD Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(37) Subtask 571208-020-409-004 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAD<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAD Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |



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

**(38) Subtask 571208-320-415-004 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAD<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBEAD Sheet 01 and Fig. A-UBEAD Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(39) Subtask 571208-250-411-004 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAD<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAD Sheet 01 and Fig. A-UBEAD Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(40) Subtask 571208-831-410-004 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B20R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 4 | EN6115V3A7 | 1 | BOLT | |
| 6 | EN6115V4Y5 | 3 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |



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

NOTE: Kit B20 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAD<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAD Sheet 01 and Fig. A-UBEAD Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3A7 | Item 4 |
| 3 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 19 | Nut | ASNA2531-4 | Item 15 |
| 38 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



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

(b) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAD Sheet 01 and Fig. A-UBEAD Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(41) Subtask 571208-020-410-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6B LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBFAA Sheet 01, remove:

| | | |
|---|---|---|
| 2 | Fastener | Discard |



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

**(42) Subtask 571208-320-419-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH

At Rib 6B LH at STGR 5 in accordance with SRM 51-44-11 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(43) Subtask 571208-250-412-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |



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

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B LH at STGR 5 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(44) Subtask 571208-831-411-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B26R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 2 | EN6115V3A5 | 2 | BOLT | |
| 14 | ASNA2531-3A | 2 | NUT HEX | |

NOTE: Kit B26 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.



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

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

2 Bolt EN6115V3A5 Item 2

2 Nut ASNA2531-3A Item 14

(b) At Rib 6B LH at STGR 5 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(45) Subtask 571208-020-411-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |



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

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6B RH at STGR 5 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBFAA Sheet 01, remove:

| | | |
|---|---|---|
| 2 | Fastener | Discard |

**(46) Subtask 571208-320-418-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



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

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6B RH at STGR 5 in accordance with SRM 51-44-11 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(47) Subtask 571208-250-413-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B RH at STGR 5 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(48) Subtask 571208-831-412-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B26R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 2 | EN6115V3A5 | 2 | BOLT | |
| 14 | ASNA2531-3A | 2 | NUT HEX | |

NOTE: Kit B26 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |



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

to wet install:

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V3A5 | Item 2 |
| 2 | Nut | ASNA2531-3A | Item 14 |

(b) At Rib 6B RH at STGR 5 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(49) Subtask 571208-020-412-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |



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

**(50) Subtask 571208-320-417-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(51) Subtask 571208-250-414-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(52) Subtask 571208-831-413-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B30R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 18 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B30 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.



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

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 18 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



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

**(53) Subtask 571208-020-413-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(54) Subtask 571208-320-416-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(55) Subtask 571208-250-415-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



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

| References | |
|---|---|
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(56) Subtask 571208-831-414-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B30R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 18 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B30 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 18 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(57) Subtask 571208-960-401-001 - Replace the LP Fuel Filters**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 400 | |



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

| Manpower Resources | |
|---|---|
| Manhours | 1.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.50 |
| Skills | ENGINE |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 73-11-10-920-001<br>Task 73-12-42-920-010 |

(a) Replace the LP fuel filter elements at Engine 1 (1000EM1), Engine 2 (1000EM2):

- if CFM engines are installed, refer to AMM Task 73-11-10-920-001.
- if IAE engines are installed, refer to AMM Task 73-12-42-920-010.

****CONF 005**

**(1) Subtask 571208-020-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



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

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(2) Subtask 571208-320-401-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



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

**(3) Subtask 571208-250-402-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(4) Subtask 571208-831-401-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |



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

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



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

(b) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(5) Subtask 571208-000-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |



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

**(6) Subtask 571208-320-403-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(7) Subtask 571208-250-403-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



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

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(8) Subtask 571208-831-402-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.



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

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |



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

**(9) Subtask 571208-020-402-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(10) Subtask 571208-320-404-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(11) Subtask 571208-250-404-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



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

| References | |
|---|---|
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(12) Subtask 571208-831-403-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B04R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B04 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(13) Subtask 571208-020-403-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(14) Subtask 571208-320-405-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



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

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(15) Subtask 571208-250-405-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



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

**(16) Subtask 571208-831-404-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B04R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B04 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



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

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(17) Subtask 571208-020-404-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



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

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(18) Subtask 571208-320-410-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



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

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(19) Subtask 571208-250-406-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(20) Subtask 571208-831-405-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12 install the fasteners from the AFT side of the stringer to make sure that there is clearance with existing electrical conduits.



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

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(21) Subtask 571208-020-405-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.



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

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(22) Subtask 571208-320-407-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



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

**(23) Subtask 571208-250-407-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(24) Subtask 571208-831-406-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



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

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |



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

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(25) Subtask 571208-020-406-006 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAE<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 LH at STGR 4 thru 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAE Sheet 01 and Fig. A-UBDAE Sheet 02, remove:

| | | | | |
|---|---|---|---|---|
| 14 | Fasteners | | | Discard |
| 1 | Foam Carrier STGR 4 | D5725655200000 | Item (1) | Retain |



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

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 5 | D5725655300000 | Item (20) | Retain |
| 1 | Foam Sealant STGR 4 | D5725655721000 | Item (3) | Discard |
| 1 | Foam Sealant STGR 4 | D5725655721200 | Item (4) | Discard |
| 1 | Foam Sealant STGR 5 | D5725655721400 | Item (22) | Discard |
| 2 | Nut | | Item (23) | Discard |
| 1 | Packer STGR 4 | D5725654720000 | Item (28) | Retain |
| 1 | Packer STGR 5 | D5725654820000 | Item (30) | Retain |

(b) At Rib 5 LH at STGR 6 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAE Sheet 01 and Fig. A-UBDAE Sheet 02, remove:

| | | |
|---|---|---|
| 18 | Fasteners | Discard |

**(26) Subtask 571208-320-406-001 - Oversize the Holes of the Metallic Packer Rib 5 LH (On Bench)**

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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBHAA<br>Enlargement of the Metallic Packer holes | Sheet 01 |

(a) Drill and ream the holes of the packers, Items (28) and (30) to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBHAA Sheet 01.

**(27) Subtask 571208-320-408-006 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 1 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAE<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

(a) At Rib 5 LH at STGR 4 and STGR 5 positions, do the procedure that follows:

1

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

Temporarily clamp in position, the Cleats to the STGR's close to the open holes in the STGR's, refer to Fig. A-UBDAE Sheet 01, Views A, B and C.

2 Drill and ream the fastener holes to final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, Views H, J, K and L and Fig. A-UBDAE Sheet 04 fastener table.

NOTE: Do not remove the clamps at this stage.

(b)

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

At Rib 5 LH at STGR 6 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, Views M, N, P and Q and Fig. A-UBDAE Sheet 04 fastener table, drill and ream the fastener holes to the final diameter.



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

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(28) Subtask 571208-250-408-006 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAE<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAE Sheet 01, Fig. A-UBDAE Sheet 02, Fig. A-UBDAE Sheet 03 and Fig. A-UBDAE Sheet 04, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(29) Subtask 571208-831-407-006 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

Material necessary to do the job

Kit 571208B12R04

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 3 | D5725655721000 | 1 | SEALANT | |
| 4 | D5725655721200 | 1 | SEALANT | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 13 | BOLT | |
| 8 | EN6115V4Y7 | 5 | BOLT | |
| 10 | EN6114V4Y17 | 1 | BOLT CSK | |
| 11 | EN6114V4Y18 | 1 | BOLT CSK | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |
| 17 | EN6115V4-3 | 2 | BOLT | |
| 18 | EN6115V3-4 | 4 | BOLT | |
| 19 | EN6115V3-5 | 4 | BOLT | |
| 22 | D5725655721400 | 1 | SEALANT | |
| 24 | ASNA2531-5 | 2 | NUT | |
| 27 | ASNA2531-3 | 8 | NUT | |

NOTE: Kit B12 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

Consumable CMLB01

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |
| | Polysulfide Sealant-Low Density Multi Purpose Bru | 06ACA1 | As required | |
| | Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required | |
| | Non Aqueous Cleaner - General | 08BAA9 | As required | |
| | Textile - Lint Free Cotton | 14SBA1 | As required | |



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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAE<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

(a) At Rib 5 LH at STGR 4 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, View H and K and Fig. A-UBDAE Sheet 04, section A-A and fastener table, install the Metallic Packer, Item (28) as follows:

1 Clean the Metallic Packer, Item (28) with a non-metallic scraper and:

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

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (28):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 10 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 7.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 4 | D5725654720000 | Item (28) | Retained at removal |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6114V4Y17 | Item 10 |
| 1 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Nut | ASNA2531-4 | Item 15 |



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

| | | | |
|---|---|---|---|
| 4 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 LH at STGR 4 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, View H and K and Fig. A-UBDAE Sheet 04, section A-A and fastener table, install the Foam Carrier, Item (1) Foam Sealants, Item 3 and Item 4 as follows:

1 Clean the Foam Carrier, Item (1) and Rib with a non-metallic scraper and:

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

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealants, Item 3 and Item 4, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)
- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealants, Item 3 and Item 4 into the Foam Carrier, Item (1).



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

7 Apply to the mating surfaces of the Foam Carrier, Item (1):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (1) and Foam Sealants, Item 3 and Item 4 in position at Rib 5 LH at STGR 4 with a suitable tool to guide the foam into position on assembly.

9 Make sure the Foam Sealants, Item 3 and Item 4 are not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 4 | D5725655200000 | Item (1) | Retained at removal |
| 1 | Foam Sealant | D5725655721000 | Item 3 | |
| 1 | Foam Sealant | D5725655721200 | Item 4 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4-3 | Item 17 |
| 2 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-5 | Item 19 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 4 | Nut | ASNA2531-3 | Item 27 |
| 1 | Nut | ASNA2531-5 | Item 24 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut, Item 15 if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

11 Remove any excess sealant from the edges of the Foam Carrier, Item (1) and clean with:

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

made moist with



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

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required |

13 Apply a fillet seal to the edges of the Foam Carrier, Item (1), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(c) At Rib 5 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, View J and L and Fig. A-UBDAE Sheet 04, section B-B and fastener table, install the Metallic Packer, Item (30) as follows:

1 Clean the Metallic Packer, Item (30) with a non-metallic scraper and:

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

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (30):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 11 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 8.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725654820000 | Item (30) | Retained at removal |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6114V4Y18 | Item 11 |
| 1 | Bolt | EN6115V4Y7 | Item 8 |



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

| | | | |
|---|---|---|---|
| 2 | Nut | ASNA2531-4 | Item 15 |
| 4 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(d) At Rib 5 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, View J and L and Fig. A-UBDAE Sheet 04, section B-B and fastener table, install the Foam Carrier, Item (20) and Foam Sealant, Item 22 as follows:

1 Clean the Foam Carrier, Item (20) and Rib with a non-metallic scraper and:

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

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealant, Item 22, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)
- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealant, Item 22 into the Foam Carrier, Item (20).



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

7 Apply to the mating surfaces of the Foam Carrier, Item (20):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (20) and Foam Sealant, Item 22 in position at Rib 5 LH at STGR 5 with a suitable tool to guide the foam into position on assembly.

9 Make sure the Foam Sealant, Item 22 is not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 5 | D5725655300000 | Item (20) | Retained at removal |
| 1 | Foam Sealant | D5725655721400 | Item 22 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4-3 | Item 17 |
| 2 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-5 | Item 19 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 4 | Nut | ASNA2531-3 | Item 27 |
| 1 | Nut | ASNA2531-5 | Item 24 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

11 Remove any excess sealant from the edges of the Foam Carrier, Item (20) and clean with:

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

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |



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

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

13 Apply a fillet seal to the edges of the Foam Carrier, Item (20), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(e) At Rib 5 LH at STGR 6 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03 and Fig. A-UBDAE Sheet 04, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 18 | Nut | ASNA2531-4 | Item 15 |
| 36 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(f) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03 and Fig. A-UBDAE Sheet 04, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |



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

**(30) Subtask 571208-020-407-006 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAE<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 RH at STGR 4 thru 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAE Sheet 01 and Fig. A-UBDAE Sheet 02, remove:

| | | | | |
|---|---|---|---|---|
| 14 | Fasteners | | | Discard |
| 1 | Foam Carrier STGR 4 | D5725655200100 | Item (2) | Retain |
| 1 | Foam Carrier STGR 5 | D5725655300100 | Item (21) | Retain |
| 1 | Foam Sealant STGR 4 | D5725655721200 | Item (4) | Discard |
| 1 | Foam Sealant STGR 4 | D5725655721000 | Item (3) | Discard |
| 1 | Foam Sealant STGR 5 | D5725655721400 | Item (22) | Discard |
| 2 | Nut | | Item (23) | Discard |
| 1 | Packer STGR 4 | D5725654720100 | Item (29) | Retain |



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

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725654820100 | Item (31) | Retain |

(b) At Rib 5 RH at STGR 6 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAE Sheet 01 and Fig. A-UBDAE Sheet 02, remove:

| | | |
|---|---|---|
| 18 | Fasteners | Discard |

**(31) Subtask 571208-320-411-001 - Oversize the Fastener Holes of the Metallic Packer Rib 5 RH (On Bench)**

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

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBHAA<br>Enlargement of the Metallic Packer holes | Sheet 01 |

(a) Drill and ream the fastener holes of the packers, Items (29) and (31) to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBHAA Sheet 01.

**(32) Subtask 571208-320-409-006 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAE<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |



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

(a) At Rib 5 RH at STGR 4 and STGR 5 positions, do the procedure that follows:

1

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

Temporarily clamp in position, the Cleats to the STGR's close to the two open holes in the STGR's, refer to Fig. A-UBDAE Sheet 01, Views A, B and C.

2 Drill and ream the fastener holes to final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, Views H, J, K and L and Fig. A-UBDAE Sheet 04 fastener table.

NOTE: Do not remove the clamps at this stage.

(b)

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

At Rib 5 STGR 6 thru 12 and 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, Views M, N, P and Q and Fig. A-UBDAE Sheet 04 fastener table, drill and ream the fastener holes to the final diameter.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(33) Subtask 571208-250-409-006 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



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

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAE<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAE Sheet 01, Fig. A-UBDAE Sheet 02, Fig. A-UBDAE Sheet 03 and Fig. A-UBDAE Sheet 04, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(34) Subtask 571208-831-408-006 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

Kit 571208B12R04

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 3 | D5725655721000 | 1 | SEALANT | |
| 4 | D5725655721200 | 1 | SEALANT | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 13 | BOLT | |
| 8 | EN6115V4Y7 | 5 | BOLT | |



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

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 10 | EN6114V4Y17 | 1 | BOLT CSK | |
| 11 | EN6114V4Y18 | 1 | BOLT CSK | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |
| 17 | EN6115V4-3 | 2 | BOLT | |
| 18 | EN6115V3-4 | 4 | BOLT | |
| 19 | EN6115V3-5 | 4 | BOLT | |
| 22 | D5725655721400 | 1 | SEALANT | |
| 24 | ASNA2531-5 | 2 | NUT | |
| 27 | ASNA2531-3 | 8 | NUT | |

NOTE: Kit B12 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |
| | Polysulfide Sealant-Low Density Multi Purpose Bru | 06ACA1 | As required | |
| | Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required | |
| | Non Aqueous Cleaner - General | 08BAA9 | As required | |
| | Textile - Lint Free Cotton | 14SBA1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAE<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |



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

(a) At Rib 5 RH at STGR 4 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, Views H and K and Fig. A-UBDAE Sheet 04, Section A-A and fastener table, install the Metallic Packer, Item (29) as follows:

1 Clean the Metallic Packer, Item (29) with a non-metallic scraper and:

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

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (29):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 10 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 7.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 4 | D5725654720100 | Item (29) | Retained at removal |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6114V4Y17 | Item 10 |
| 1 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Nut | ASNA2531-4 | Item 15 |
| 4 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



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

(b) At Rib 5 RH at STGR 4 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, View H and K and Fig. A-UBDAE Sheet 04, section A-A and fastener table, install the Foam Carrier, Item (2) Foam Sealants, Item 3 and Item 4 as follows:

1 Clean the Foam Carrier, Item (2) and Rib with a non-metallic scraper and:

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

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealants, Item 3 and Item 4, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)
- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealants, Item 3 and Item 4 into the Foam Carrier, Item (2).

7 Apply to the mating surfaces of the Foam Carrier, Item (2):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (2) and Foam Sealants, Item 3 and Item 4 in position at Rib 5 RH at STGR 4 with a suitable tool to guide the foam into position on assembly.



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

9 Make sure the Foam Sealants, Item 3 and Item 4 are not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 4 | D5725655200100 | Item (2) | Retained at removal |
| 1 | Foam Sealant | D5725655721000 | Item 3 | |
| 1 | Foam Sealant | D5725655721200 | Item 4 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4-3 | Item 17 |
| 2 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-5 | Item 19 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 4 | Nut | ASNA2531-3 | Item 27 |
| 1 | Nut | ASNA2531-5 | Item 24 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut, Item 15 if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

11 Remove any excess sealant from the edges of the Foam Carrier, Item (2) and clean with:

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

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |



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

13 Apply a fillet seal to the edges of the Foam Carrier, Item (2), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(c) At Rib 5 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, Views J and L and Fig. A-UBDAE Sheet 04, section B-B and fastener table, install the Metallic Packer, Item (31) as follows:

1 Clean the Metallic Packer, Item (31) with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (31):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 11 AND FULL INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 8.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725654820100 | Item (31) | Retained at removal |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6114V4Y18 | Item 11 |
| 1 | Bolt | EN6115V4Y7 | Item 8 |
| 2 | Nut | ASNA2531-4 | Item 15 |
| 4 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(d) At Rib 5 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, View J and L and Fig. A-UBDAE Sheet 04, section B-B and fastener table, install the Foam Carrier, Item (21) and Foam Sealant, Item 22 as follows:

1 Clean the Foam Carrier, Item (21) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealant, Item 22, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)
- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealant, Item 22 into the Foam Carrier, Item (21).

7 Apply to the mating surfaces of the Foam Carrier, Item (21):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (21) and Foam Sealant, Item 22 in position at Rib 5 RH at STGR 5 with a suitable tool to guide the foam into position on assembly.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

9 Make sure the Foam Sealant, Item 22 is not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 5 | D5725655300100 | Item (21) | Retained at removal |
| 1 | Foam Sealant | D5725655721400 | Item 22 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4-3 | Item 17 |
| 2 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-5 | Item 19 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 4 | Nut | ASNA2531-3 | Item 27 |
| 1 | Nut | ASNA2531-5 | Item 24 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

11 Remove any excess sealant from the edges of the Foam Carrier, Item (21) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

13 Apply a fillet seal to the edges of the Foam Carrier, Item (21), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(e) At Rib 5 RH at STGR 6 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03 and Fig. A-UBDAE Sheet 04, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 18 | Nut | ASNA2531-4 | Item 15 |
| 36 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(f) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03 and Fig. A-UBDAE Sheet 04, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(35) Subtask 571208-020-408-005 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAE<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAE Sheet 01, remove:

| | | | | |
|---|---|---|---|---|
| 7 | Fastener | | | Discard |
| 1 | Foam Carrier STGR 5 | D5725655100000 | Item (40) | Retain |
| 1 | Foam Sealant STGR 5 | D5725655720000 | Item (12) | Discard |
| 1 | Packer STGR 5 | D5725654920000 | Item (32) | Retain |
| 1 | Nut | | Item (23) | Discard |

(b) At Rib 6 LH at STGRs 6 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAE Sheet 01, remove:

| | | |
|---|---|---|
| 18 | Fastener | Discard |

**(36) Subtask 571208-320-412-002 - Oversize the Fastener Holes of the Metallic Packer Rib 6 LH (On Bench)**

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 1 |
| Subtask elapsed time | 0.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBHAA<br>Enlargement of the Metallic Packer holes | Sheet 01 |

(a) Drill and ream the fastener holes of the packer, Item (32) to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBHAA Sheet 01.

**(37) Subtask 571208-320-414-005 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAE<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 LH at STGR 5 position, do the procedure that follows:

1

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

Temporarily clamp in position, the Cleat to the STGR close to the two open holes in the STGR, refer to Fig. A-UBEAE Sheet 01, Views A and B.

2 Drill and ream all the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02, Views F and G and Fig. A-UBEAE Sheet 03 fastener table.

NOTE: Do not remove the clamps at this stage.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b)

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

At the Rib 6 LH at STGR 6 thru 12 and 15 thru 16 drill and ream the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02, Views H and J and Fig. A-UBEAE Sheet 03, Views K and L and fastener table.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(38) Subtask 571208-250-410-005 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAE<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAE Sheet 01, Fig. A-UBEAE Sheet 02 and Fig. A-UBEAE Sheet 03, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

- If no damage is found, do the worksteps that follow.

**(39) Subtask 571208-831-409-005 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

Material necessary to do the job

Kit 571208B21R03

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 5 | EN6114V3A16 | 1 | BOLT CSK | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 8 | EN6115V4Y7 | 1 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 12 | D5725655720000 | 1 | SEALANT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |
| 18 | EN6115V3-4 | 1 | BOLT | |
| 24 | ASNA2531-5 | 2 | NUT | |
| 25 | EN6115V3-6 | 2 | BOLT | |
| 26 | EN6115V3-8 | 2 | BOLT | |
| 27 | ASNA2531-3 | 5 | NUT | |

NOTE: Kit B21 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

Consumable CMLB01

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Polysulfide Sealant-Low Density Multi Purpose Bru | 06ACA1 | As required | |
| | Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required | |
| | Non Aqueous Cleaner - General | 08BAA9 | As required | |
| | Textile - Lint Free Cotton | 14SBA1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAE<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02, View F and G and Fig. A-UBEAE Sheet 03, section A-A and fastener table, install the Metallic Packer, Item (32) as follows:

1 Clean the Metallic Packer, Item (32) with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (32):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 5 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 8.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725654920000 | Item (32) | Retained at removal |

with:



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |
| 1 | Bolt | EN6115V4Y7 | Item 8 |
| 1 | Bolt | EN6114V3A16 | Item 5 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under nut, Item 15 if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02, View F and G and Fig. A-UBEAE Sheet 03, section A-A and fastener table, install the Foam Carrier, Item (40) and Foam Sealant, Item 12 as follows:

1 Clean the Foam Carrier, Item (40) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealant, Item 12, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)

- The calculated mass can be used as a quality control measure to ensure adequate fill.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealant, Item 12 into the Foam Carrier, Item (40).

7 Apply to the mating surfaces of the Foam Carrier, Item (40):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (40) and Foam Sealant, Item 12 in position at Rib 6 LH at STGR 5 with a suitable tool to guide the foam into position on assembly.

9 Make sure the Foam Sealant, Item 12 is not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 5 | D5725655100000 | Item (40) | Retained at removal |
| 1 | Foam Sealant | D5725655720000 | Item 12 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-6 | Item 25 |
| 2 | Bolt | EN6115V3-8 | Item 26 |
| 2 | Nut | ASNA2531-5 | Item 24 |
| 5 | Nut | ASNA2531-3 | Item 27 |

11 Remove any excess sealant from the edges of the Foam Carrier, Item (40) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

13 Apply a fillet seal to the edges of the Foam Carrier, Item (40), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(c) At Rib 6 LH at STGRs 6 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02 and Fig. A-UBEAE Sheet 03, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 18 | Nut | ASNA2531-4 | Item 15 |
| 36 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(d) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02 and Fig. A-UBEAE Sheet 03, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(40) Subtask 571208-020-409-005 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAE<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAE Sheet 01, remove:

| | | | | |
|---|---|---|---|---|
| 7 | Fastener | | | Discard |
| 1 | Foam Carrier STGR 5 | D5725655100100 | Item (41) | Retain |
| 1 | Foam Sealant STGR 5 | D5725655720000 | Item (12) | Discard |
| 1 | Packer STGR 5 | D5725654920100 | Item (33) | Retain |
| 1 | Nut | | Item (23) | Discard |

(b) At Rib 6 RH at STGRs 6 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAE Sheet 01, remove:

| | | |
|---|---|---|
| 18 | Fastener | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(41) Subtask 571208-320-413-002 - Oversize the Fastener Holes of the Metallic Packer Rib 6 RH (On Bench)**

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 1 |
| Subtask elapsed time | 0.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBHAA<br>Enlargement of the Metallic Packer holes | Sheet 01 |

(a) Drill and ream the fastener holes of the packer, Item (33) to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBHAA Sheet 01.

**(42) Subtask 571208-320-415-005 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAE<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 RH at STGR 5 position, do the procedure that follows:

1



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

Temporarily clamp in position, the Cleat to the STGR close to the two open holes in the STGR, refer to Fig. A-UBEAE Sheet 01, Views A and B.

2 Drill and ream all the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02, Views F and G and Fig. A-UBEAE Sheet 03 fastener table.

NOTE: Do not remove the clamps at this stage.

(b)

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

At Rib 6 RH at STGRs 6 thru 12 and 15 thru 16, drill and ream the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02, Views H and J and Fig. A-UBEAE Sheet 03, Views K and L and fastener table.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(43) Subtask 571208-250-411-005 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAE<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAE Sheet 01, Fig. A-UBEAE Sheet 02 and Fig. A-UBEAE Sheet 03, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(44) Subtask 571208-831-410-005 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B21R03 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 5 | EN6114V3A16 | 1 | BOLT CSK | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 8 | EN6115V4Y7 | 1 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 12 | D5725655720000 | 1 | SEALANT | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |
| 18 | EN6115V3-4 | 1 | BOLT | |
| 24 | ASNA2531-5 | 2 | NUT | |
| 25 | EN6115V3-6 | 2 | BOLT | |
| 26 | EN6115V3-8 | 2 | BOLT | |
| 27 | ASNA2531-3 | 5 | NUT | |

NOTE: Kit B21 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |
| | Polysulfide Sealant-Low Density Multi Purpose Bru | 06ACA1 | As required | |
| | Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required | |
| | Non Aqueous Cleaner - General | 08BAA9 | As required | |
| | Textile - Lint Free Cotton | 14SBA1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAE<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02, View F and G and Fig. A-UBEAE Sheet 03, section A-A and fastener table, install the Metallic Packer, Item (33) as follows:

1 Clean the Metallic Packer, Item (33) with a non-metallic scraper and:

Textile - Lint Free Cotton 14SBA1 As required

made moist with



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (33):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 5 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 8.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725654920100 | Item (33) | Retained at removal |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4Y7 | Item 8 |
| 1 | Bolt | EN6114V3A16 | Item 5 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under nut, Item 15 if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02, View F and G and Fig. A-UBEAE Sheet 03, section A-A and fastener table, install the Foam Carrier, Item (41) and Foam Sealant, Item 12 as follows:

1 Clean the Foam Carrier, Item (41) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

2 Soak the Foam Sealant, Item 12, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)

- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealant, Item 12 into the Foam Carrier, Item (41).

7 Apply to the mating surfaces of the Foam Carrier, Item (41):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (41) and Foam Sealant, Item 12 in position at Rib 6 RH at STGR 5 with a suitable tool to guide the foam into position on assembly.

9 Make sure the Foam Sealant, Item 12 is not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 5 | D5725655100100 | Item (41) | Retained at removal |
| 1 | Foam Sealant | D5725655720000 | Item 12 | |

with:



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |
| 1 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-6 | Item 25 |
| 2 | Bolt | EN6115V3-8 | Item 26 |
| 5 | Nut | ASNA2531-3 | Item 27 |
| 2 | Nut | ASNA2531-5 | Item 24 |

11 Remove any excess sealant from the edges of the Foam Carrier, Item (41) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

13 Apply a fillet seal to the edges of the Foam Carrier, Item (41), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(c) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02 and Fig. A-UBEAE Sheet 03, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 18 | Nut | ASNA2531-4 | Item 15 |
| 36 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(d) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02 and Fig. A-UBEAE Sheet 03, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(45) Subtask 571208-020-410-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBFAB<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 6B LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBFAB Sheet 01, remove:

| | | |
|---|---|---|
| 2 | Fastener | Discard |

**(46) Subtask 571208-320-419-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBFAB<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 LH at STGR 5 in accordance with SRM 51-44-11 and refer to Fig. A-UBFAB Sheet 01 and Fig. A-UBFAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(47) Subtask 571208-250-412-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBFAB<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B LH at STGR 5 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBFAB Sheet 01 and Fig. A-UBFAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(48) Subtask 571208-831-411-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B27R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 1 | EN6115V3A4 | 2 | BOLT | |
| 14 | ASNA2531-3A | 2 | NUT HEX | |

NOTE: Kit B27 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBFAB<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) If the foam seals on the dry bay cleats are found damaged contact AIRBUS.

(b) At Rib 6B LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBFAB Sheet 01 and Fig. A-UBFAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V3A4 | Item 1 |
| 2 | Nut | ASNA2531-3A | Item 14 |

(c) At Rib 6B LH at STGR 5 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBFAB Sheet 01 and Fig. A-UBFAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(49) Subtask 571208-020-411-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBFAB<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6B RH at STGR 5 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBFAB Sheet 01, remove:

| | | |
|---|---|---|
| 2 | Fastener | Discard |

**(50) Subtask 571208-320-418-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBFAB<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6B RH at STGR 5 in accordance with SRM 51-44-11 and refer to Fig. A-UBFAB Sheet 01 and Fig. A-UBFAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(51) Subtask 571208-250-413-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBFAB<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B RH at STGR 5 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBFAB Sheet 01 and Fig. A-UBFAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

- If no damage is found, do the worksteps that follow.

**(52) Subtask 571208-831-412-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B27R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 1 | EN6115V3A4 | 2 | BOLT | |
| 14 | ASNA2531-3A | 2 | NUT HEX | |

NOTE: Kit B27 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBFAB<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) If the foam seals on the dry bay cleats are found damaged contact AIRBUS.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 6B RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBFAB Sheet 01 and Fig. A-UBFAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V3A4 | Item 1 |
| 2 | Nut | ASNA2531-3A | Item 14 |

(c) At Rib 6B RH at STGR 5 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBFAB Sheet 01 and Fig. A-UBFAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(53) Subtask 571208-020-412-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(54) Subtask 571208-320-417-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(55) Subtask 571208-250-414-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(56) Subtask 571208-831-413-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B30R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 18 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B30 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 18 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(57) Subtask 571208-020-413-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(58) Subtask 571208-320-416-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(59) Subtask 571208-250-415-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(60) Subtask 571208-831-414-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B30R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 18 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B30 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 18 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(61) Subtask 571208-960-401-001 - Replace the LP Fuel Filters**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 400 | |

| Manpower Resources | |
|---|---|
| Manhours | 1.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.50 |
| Skills | ENGINE |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 73-11-10-920-001<br>Task 73-12-42-920-010 |

(a) Replace the LP fuel filter elements at Engine 1 (1000EM1), Engine 2 (1000EM2):

- if CFM engines are installed, refer to AMM Task 73-11-10-920-001.
- if IAE engines are installed, refer to AMM Task 73-12-42-920-010.

****CONF 006**

**(1) Subtask 571208-020-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(2) Subtask 571208-320-401-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(3) Subtask 571208-250-402-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(4) Subtask 571208-831-401-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(5) Subtask 571208-000-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(6) Subtask 571208-320-403-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(7) Subtask 571208-250-403-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(8) Subtask 571208-831-402-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(9) Subtask 571208-020-402-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAC Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(10) Subtask 571208-320-404-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(11) Subtask 571208-250-404-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(12) Subtask 571208-831-403-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B05R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 22 | BOLT | |
| 9 | EN6115V4Y8 | 2 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B05 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 22 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(13) Subtask 571208-020-403-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAC Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(14) Subtask 571208-320-405-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(15) Subtask 571208-250-405-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(16) Subtask 571208-831-404-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B05R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 22 | BOLT | |
| 9 | EN6115V4Y8 | 2 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B05 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 22 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(17) Subtask 571208-020-404-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(18) Subtask 571208-320-410-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(19) Subtask 571208-250-406-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(20) Subtask 571208-831-405-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12 install the fasteners from the AFT side of the stringer to make sure that there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(21) Subtask 571208-020-405-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(22) Subtask 571208-320-407-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(23) Subtask 571208-250-407-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(24) Subtask 571208-831-406-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(25) Subtask 571208-020-406-007 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAF<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAF Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(26) Subtask 571208-320-408-007 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAF<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAF Sheet 01 and Fig. A-UBDAF Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(27) Subtask 571208-250-408-007 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAF<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAF Sheet 01 and Fig. A-UBDAF Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(28) Subtask 571208-831-407-007 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B13R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 4 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B13 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAF<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAF Sheet 01 and Fig. A-UBDAF Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 4 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAF Sheet 01 and Fig. A-UBDAF Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(29) Subtask 571208-020-407-007 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAF<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAF Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(30) Subtask 571208-320-409-007 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAF<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAF Sheet 01 and Fig. A-UBDAF Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(31) Subtask 571208-250-409-007 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAF<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAF Sheet 01 and Fig. A-UBDAF Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(32) Subtask 571208-831-408-007 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B13R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 4 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B13 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAF<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAF Sheet 01 and Fig. A-UBDAF Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 4 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAF Sheet 01 and Fig. A-UBDAF Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(33) Subtask 571208-020-408-007 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAF<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAF Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(34) Subtask 571208-320-414-007 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAF<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBEAF Sheet 01 and Fig. A-UBEAF Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(35) Subtask 571208-250-410-007 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAF<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAF Sheet 01 and Fig. A-UBEAF Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(36) Subtask 571208-831-409-007 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B22R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 3 | EN6115V3A6 | 1 | BOLT | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 13 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |

NOTE: Kit B22 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAF<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAF Sheet 01 and Fig. A-UBEAF Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3A6 | Item 3 |
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 13 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 19 | Nut | ASNA2531-4 | Item 15 |
| 38 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAF Sheet 01 and Fig. A-UBEAF Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(37) Subtask 571208-020-409-007 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAF<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAF Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(38) Subtask 571208-320-415-007 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAF<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBEAF Sheet 01 and Fig. A-UBEAF Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(39) Subtask 571208-250-411-007 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAF<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAF Sheet 01 and Fig. A-UBEAF Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(40) Subtask 571208-831-410-007 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B22R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 3 | EN6115V3A6 | 1 | BOLT | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 13 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |

NOTE: Kit B22 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAF<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAF Sheet 01 and Fig. A-UBEAF Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3A6 | Item 3 |
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 13 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 19 | Nut | ASNA2531-4 | Item 15 |
| 38 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAF Sheet 01 and Fig. A-UBEAF Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(41) Subtask 571208-020-412-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(42) Subtask 571208-320-417-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(43) Subtask 571208-250-414-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(44) Subtask 571208-831-413-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B31R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 16 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B31 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 16 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(45) Subtask 571208-020-413-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(46) Subtask 571208-320-416-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(47) Subtask 571208-250-415-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(48) Subtask 571208-831-414-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B31R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 16 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B31 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 16 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(49) Subtask 571208-960-401-001 - Replace the LP Fuel Filters**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 400 | |

| Manpower Resources | |
|---|---|
| Manhours | 1.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.50 |
| Skills | ENGINE |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 73-11-10-920-001<br>Task 73-12-42-920-010 |

(a) Replace the LP fuel filter elements at Engine 1 (1000EM1), Engine 2 (1000EM2):

- if CFM engines are installed, refer to AMM Task 73-11-10-920-001.
- if IAE engines are installed, refer to AMM Task 73-12-42-920-010.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 007

**(1) Subtask 571208-020-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

28 Fasteners Discard

**(2) Subtask 571208-320-401-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(3) Subtask 571208-250-402-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(4) Subtask 571208-831-401-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

Material necessary to do the job

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(5) Subtask 571208-000-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(6) Subtask 571208-320-403-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(7) Subtask 571208-250-403-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(8) Subtask 571208-831-402-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(9) Subtask 571208-020-402-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAC Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(10) Subtask 571208-320-404-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(11) Subtask 571208-250-404-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(12) Subtask 571208-831-403-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B05R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 22 | BOLT | |
| 9 | EN6115V4Y8 | 2 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B05 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 22 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y8 | Item 9 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(13) Subtask 571208-020-403-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAC Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(14) Subtask 571208-320-405-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(15) Subtask 571208-250-405-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(16) Subtask 571208-831-404-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B05R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 22 | BOLT | |
| 9 | EN6115V4Y8 | 2 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B05 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 22 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(17) Subtask 571208-020-404-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(18) Subtask 571208-320-410-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(19) Subtask 571208-250-406-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(20) Subtask 571208-831-405-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12 install the fasteners from the AFT side of the stringer to make sure that there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(21) Subtask 571208-020-405-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(22) Subtask 571208-320-407-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(23) Subtask 571208-250-407-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(24) Subtask 571208-831-406-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(25) Subtask 571208-020-406-008 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAG<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAG Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(26) Subtask 571208-320-408-008 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAG<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAG Sheet 01 and Fig. A-UBDAG Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(27) Subtask 571208-250-408-008 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAG<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAG Sheet 01 and Fig. A-UBDAG Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(28) Subtask 571208-831-407-008 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B14R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 4 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B14 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAG<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAG Sheet 01 and Fig. A-UBDAG Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 4 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAG Sheet 01 and Fig. A-UBDAG Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(29) Subtask 571208-020-407-008 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAG<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAG Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(30) Subtask 571208-320-409-008 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAG<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAG Sheet 01 and Fig. A-UBDAG Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(31) Subtask 571208-250-409-008 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAG<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAG Sheet 01 and Fig. A-UBDAG Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(32) Subtask 571208-831-408-008 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B14R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 4 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B14 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAG<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAG Sheet 01 and Fig. A-UBDAG Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 4 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAG Sheet 01 and Fig. A-UBDAG Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(33) Subtask 571208-020-408-008 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAG<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAG Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(34) Subtask 571208-320-414-008 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAG<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBEAG Sheet 01 and Fig. A-UBEAG Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(35) Subtask 571208-250-410-008 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAG<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAG Sheet 01 and Fig. A-UBEAG Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(36) Subtask 571208-831-409-008 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B23R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B23 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAG<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAG Sheet 01 and Fig. A-UBEAG Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAG Sheet 01 and Fig. A-UBEAG Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(37) Subtask 571208-020-409-008 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAG<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAG Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(38) Subtask 571208-320-415-008 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAG<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBEAG Sheet 01 and Fig. A-UBEAG Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(39) Subtask 571208-250-411-008 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAG<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAG Sheet 01 and Fig. A-UBEAG Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(40) Subtask 571208-831-410-008 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B23R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B23 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAG<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAG Sheet 01 and Fig. A-UBEAG Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAG Sheet 01 and Fig. A-UBEAG Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(41) Subtask 571208-020-412-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(42) Subtask 571208-320-417-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(43) Subtask 571208-250-414-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(44) Subtask 571208-831-413-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B31R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 16 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B31 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 16 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(45) Subtask 571208-020-413-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(46) Subtask 571208-320-416-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(47) Subtask 571208-250-415-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(48) Subtask 571208-831-414-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B31R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 16 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B31 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 16 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(49) Subtask 571208-960-401-001 - Replace the LP Fuel Filters**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 400 | |

| Manpower Resources | |
|---|---|
| Manhours | 1.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.50 |
| Skills | ENGINE |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 73-11-10-920-001<br>Task 73-12-42-920-010 |

(a) Replace the LP fuel filter elements at Engine 1 (1000EM1), Engine 2 (1000EM2):

- if CFM engines are installed, refer to AMM Task 73-11-10-920-001.
- if IAE engines are installed, refer to AMM Task 73-12-42-920-010.

****CONF 008**

**(1) Subtask 571208-020-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(2) Subtask 571208-320-401-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(3) Subtask 571208-250-402-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(4) Subtask 571208-831-401-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(5) Subtask 571208-000-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(6) Subtask 571208-320-403-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(7) Subtask 571208-250-403-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(8) Subtask 571208-831-402-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(9) Subtask 571208-020-402-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAC Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(10) Subtask 571208-320-404-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(11) Subtask 571208-250-404-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(12) Subtask 571208-831-403-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B05R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 22 | BOLT | |
| 9 | EN6115V4Y8 | 2 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B05 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 22 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(13) Subtask 571208-020-403-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAC Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(14) Subtask 571208-320-405-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(15) Subtask 571208-250-405-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(16) Subtask 571208-831-404-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B05R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 22 | BOLT | |
| 9 | EN6115V4Y8 | 2 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B05 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 22 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(17) Subtask 571208-020-404-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(18) Subtask 571208-320-410-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(19) Subtask 571208-250-406-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(20) Subtask 571208-831-405-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12 install the fasteners from the AFT side of the stringer to make sure that there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(21) Subtask 571208-020-405-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(22) Subtask 571208-320-407-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(23) Subtask 571208-250-407-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(24) Subtask 571208-831-406-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(25) Subtask 571208-020-406-009 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAH<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAH Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(26) Subtask 571208-320-408-009 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAH<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAH Sheet 01 and Fig. A-UBDAH Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(27) Subtask 571208-250-408-009 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAH<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAH Sheet 01 and Fig. A-UBDAH Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(28) Subtask 571208-831-407-009 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B15R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 6 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B15 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAH<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAH Sheet 01 and Fig. A-UBDAH Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 6 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAH Sheet 01 and Fig. A-UBDAH Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(29) Subtask 571208-020-407-009 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAH<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAH Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(30) Subtask 571208-320-409-009 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAH<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAH Sheet 01 and Fig. A-UBDAH Sheet 02fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(31) Subtask 571208-250-409-009 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAH<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAH Sheet 01 and Fig. A-UBDAH Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(32) Subtask 571208-831-408-009 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B15R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 6 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B15 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAH<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAH Sheet 01 and Fig. A-UBDAH Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 6 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAH Sheet 01 and Fig. A-UBDAH Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(33) Subtask 571208-020-408-009 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAH<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAH Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(34) Subtask 571208-320-414-009 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAH<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBEAH Sheet 01 and Fig. A-UBEAH Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(35) Subtask 571208-250-410-009 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAH<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAH Sheet 01 and Fig. A-UBEAH Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(36) Subtask 571208-831-409-009 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B24R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 4 | EN6115V3A7 | 1 | BOLT | |
| 6 | EN6115V4Y5 | 3 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |

NOTE: Kit B24 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAH<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAH Sheet 01 and Fig. A-UBEAH Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3A7 | Item 4 |
| 3 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 19 | Nut | ASNA2531-4 | Item 15 |
| 38 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAH Sheet 01 and Fig. A-UBEAH Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(37) Subtask 571208-020-409-009 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAH<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAH Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(38) Subtask 571208-320-415-009 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAH<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBEAH Sheet 01 and Fig. A-UBEAH Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(39) Subtask 571208-250-411-009 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAH<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAH Sheet 01 and Fig. A-UBEAH Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(40) Subtask 571208-831-410-009 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B24R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 4 | EN6115V3A7 | 1 | BOLT | |
| 6 | EN6115V4Y5 | 3 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |

NOTE: Kit B24 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAH<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAH Sheet 01 and Fig. A-UBEAH Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3A7 | Item 4 |
| 3 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 19 | Nut | ASNA2531-4 | Item 15 |
| 38 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAH Sheet 01 and Fig. A-UBEAH Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(41) Subtask 571208-020-410-004 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6B LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBFAC Sheet 01, remove:

| | | |
|---|---|---|
| 2 | Fastener | Discard |

**(42) Subtask 571208-320-419-004 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 LH at STGR 5 in accordance with SRM 51-44-11 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(43) Subtask 571208-250-412-004 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B LH at STGR 5 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(44) Subtask 571208-831-411-004 - Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B28R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 3 | EN6115V3A6 | 2 | BOLT | |
| 14 | ASNA2531-3A | 2 | NUT HEX | |

NOTE: Kit B28 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

to wet install:

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V3A6 | Item 3 |
| 2 | Nut | ASNA2531-3A | Item 14 |

(b) At Rib 6B LH at STGR 5 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(45) Subtask 571208-020-411-004 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6B RH at STGR 5 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBFAC Sheet 01, remove:

| | | |
|---|---|---|
| 2 | Fastener | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(46) Subtask 571208-320-418-004 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6B RH at STGR 5 in accordance with SRM 51-44-11 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(47) Subtask 571208-250-413-004 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B RH at STGR 5 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(48) Subtask 571208-831-412-004 - Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B28R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 3 | EN6115V3A6 | 2 | BOLT | |
| 14 | ASNA2531-3A | 2 | NUT HEX | |

NOTE: Kit B28 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

2 Bolt EN6115V3A6 Item 3

2 Nut ASNA2531-3A Item 14

(b) At Rib 6B RH at STGR 5 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(49) Subtask 571208-020-412-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(50) Subtask 571208-320-417-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(51) Subtask 571208-250-414-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(52) Subtask 571208-831-413-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B31R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 16 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B31 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 16 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(53) Subtask 571208-020-413-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(54) Subtask 571208-320-416-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(55) Subtask 571208-250-415-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(56) Subtask 571208-831-414-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B31R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 16 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B31 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 16 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(57) Subtask 571208-960-401-001 - Replace the LP Fuel Filters**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 400 | |

| Manpower Resources | |
|---|---|
| Manhours | 1.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.50 |
| Skills | ENGINE |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 73-11-10-920-001<br>Task 73-12-42-920-010 |

(a) Replace the LP fuel filter elements at Engine 1 (1000EM1), Engine 2 (1000EM2):

- if CFM engines are installed, refer to AMM Task 73-11-10-920-001.
- if IAE engines are installed, refer to AMM Task 73-12-42-920-010.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 009

**(1) Subtask 571208-020-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

28 Fasteners Discard

**(2) Subtask 571208-320-401-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(3) Subtask 571208-250-402-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(4) Subtask 571208-831-401-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(5) Subtask 571208-000-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(6) Subtask 571208-320-403-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(7) Subtask 571208-250-403-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(8) Subtask 571208-831-402-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(9) Subtask 571208-020-402-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAC Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(10) Subtask 571208-320-404-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(11) Subtask 571208-250-404-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(12) Subtask 571208-831-403-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B05R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 22 | BOLT | |
| 9 | EN6115V4Y8 | 2 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B05 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 22 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y8 | Item 9 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(13) Subtask 571208-020-403-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAC Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(14) Subtask 571208-320-405-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(15) Subtask 571208-250-405-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(16) Subtask 571208-831-404-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B05R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 22 | BOLT | |
| 9 | EN6115V4Y8 | 2 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B05 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 22 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(17) Subtask 571208-020-404-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(18) Subtask 571208-320-410-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(19) Subtask 571208-250-406-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(20) Subtask 571208-831-405-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12 install the fasteners from the AFT side of the stringer to make sure that there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(21) Subtask 571208-020-405-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(22) Subtask 571208-320-407-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(23) Subtask 571208-250-407-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(24) Subtask 571208-831-406-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(25) Subtask 571208-020-406-010 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAJ<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 LH at STGR 4 thru 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAJ Sheet 01 and Fig. A-UBDAJ Sheet 02, remove:

| | | | | |
|---|---|---|---|---|
| 14 | Fasteners | | | Discard |
| 1 | Foam Carrier STGR 4 | D5725655200000 | Item (1) | Retain |
| 1 | Foam Carrier STGR 5 | D5725655300000 | Item (20) | Retain |
| 1 | Foam Sealant STGR 4 | D5725655721000 | Item (3) | Discard |
| 1 | Foam Sealant STGR 4 | D5725655721200 | Item (4) | Discard |
| 1 | Foam Sealant STGR 5 | D5725655721400 | Item (22) | Discard |
| 1 | Packer STGR 4 | D5725660920000 | Item (34) | Retain |
| 1 | Packer STGR 5 | D5725661020000 | Item (36) | Retain |
| 2 | Nut | | Item (23) | Discard |

(b) At Rib 5 LH at STGR 6 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAJ Sheet 01 and Fig. A-UBDAJ Sheet 02, remove:

| | | | | |
|---|---|---|---|---|
| 18 | Fasteners | | | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(26) Subtask 571208-320-406-003 - Oversize the Holes of the Metallic Packer Rib 5 LH (On Bench)**

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 1 |
| Subtask elapsed time | 0.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBHAB<br>Enlargement of the Metallic Packer holes | Sheet 01 |

(a) Drill and ream the holes of the packers, Items, (34) and (36) to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBHAB Sheet 01.

**(27) Subtask 571208-320-408-010 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAJ<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

(a) At Rib 5 LH at STGR 4 and STGR 5 positions, do the procedure that follows:

1



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

Temporarily clamp in position, the Cleats to the STGR's close to the open holes in the STGR's, refer to Fig. A-UBDAJ Sheet 01, Views A, B and C.

2 Drill and ream the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, Views H, J, K and L and Fig. A-UBDAJ Sheet 04 fastener table.

NOTE: Do not remove the clamps at this stage.

(b)

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

At Rib 5 LH AT STGR 6 thru 12 and 15 thru 16 in accordance with SRM 51-44-11 and refer to sheet Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, Views M, N, P and Q and Fig. A-UBDAJ Sheet 04 and fastener table, drill and ream the holes to the final diameter.

NOTE: Make sure that under head radius is cut adjacent to the fastener head.

**(28) Subtask 571208-250-408-010 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAJ<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAJ Sheet 01, Fig. A-UBDAJ Sheet 02, Fig. A-UBDAJ Sheet 03 and Fig. A-UBDAJ Sheet 04, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(29) Subtask 571208-831-407-010 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B16R04 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 3 | D5725655721000 | 1 | SEALANT | |
| 4 | D5725655721200 | 1 | SEALANT | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 13 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 9 | EN6115V4Y8 | 1 | BOLT | |
| 10 | EN6114V4Y17 | 1 | BOLT CSK | |
| 11 | EN6114V4Y18 | 1 | BOLT CSK | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |
| 17 | EN6115V4-3 | 2 | BOLT | |
| 18 | EN6115V3-4 | 4 | BOLT | |
| 19 | EN6115V3-5 | 4 | BOLT | |
| 22 | D5725655721400 | 1 | SEALANT | |
| 24 | ASNA2531-5 | 2 | NUT | |
| 27 | ASNA2531-3 | 8 | NUT | |

NOTE: Kit B16 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |
| | Polysulfide Sealant-Low Density Multi Purpose Bru | 06ACA1 | As required | |
| | Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required | |
| | Non Aqueous Cleaner - General | 08BAA9 | As required | |
| | Textile - Lint Free Cotton | 14SBA1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAJ<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 LH at STGR 4 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, View H and K and Fig. A-UBDAJ Sheet 04, section A-A and fastener table, install the Metallic Packer, Item (34) as follows:

1 Clean the Metallic Packer, Item (34) with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (34):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 10 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 7.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 4 | D5725660920000 | Item (34) | Retained at removal |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6114V4Y17 | Item 10 |
| 1 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Nut | ASNA2531-4 | Item 15 |
| 4 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 5 LH at STGR 4 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, View H and K and Fig. A-UBDAJ Sheet 04, section A-A and fastener table, install the Foam Carrier, Item (1) Foam Sealants, Item 3 and Item 4 as follows:

1 Clean the Foam Carrier, Item (1) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealants, Item 3 and Item 4, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)
- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealants, Item 3 and Item 4 into the Foam Carrier, Item (1).

7 Apply to the mating surfaces of the Foam Carrier, Item (1):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (1) and Foam Sealants, Item 3 and Item 4 in position at Rib 5 LH at STGR 4 with a suitable tool to guide the foam into position on assembly.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

9 Make sure the Foam Sealants, Item 3 and Item 4 are not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 4 | D5725655200000 | Item (1) | Retained at removal |
| 1 | Foam Sealant | D5725655721000 | Item 3 | |
| 1 | Foam Sealant | D5725655721200 | Item 4 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4-3 | Item 17 |
| 2 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-5 | Item 19 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 4 | Nut | ASNA2531-3 | Item 27 |
| 1 | Nut | ASNA2531-5 | Item 24 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut, Item 15 if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

11 Remove any excess sealant from the edges of the Foam Carrier, Item (1) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

13 Apply a fillet seal to the edges of the Foam Carrier, Item (1), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(c) At Rib 5 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, View J and L and Fig. A-UBDAJ Sheet 04, section B-B and fastener table, install the Metallic Packer, Item (36) as follows:

1 Clean the Metallic Packer, Item (36) with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (36):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 11 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 8.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725661020000 | Item (36) | Retained at removal |

with:

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6114V4Y18 | Item 11 |
| 1 | Bolt | EN6115V4Y8 | Item 9 |
| 2 | Nut | ASNA2531-4 | Item 15 |
| 4 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(d) At Rib 5 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, View J and L and Fig. A-UBDAJ Sheet 04, section B-B and fastener table, install the Foam Carrier, Item (20) and Foam Sealant, Item 22 as follows:

1 Clean the Foam Carrier, Item (20) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealant, Item 22, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)
- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealant, Item 22 into the Foam Carrier, Item (20).

7 Apply to the mating surfaces of the Foam Carrier, Item (20):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (20) and Foam Sealant, Item 22 in position at Rib 5 LH at STGR 5 with a suitable tool to guide the foam into position on assembly.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

9 Make sure the Foam Sealant, Item 22 is not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 5 | D5725655300000 | Item (20) | Retained at removal |
| 1 | Foam Sealant | D5725655721400 | Item 22 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4-3 | Item 17 |
| 2 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-5 | Item 19 |
| 4 | Nut | ASNA2531-3 | Item 27 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 1 | Nut | ASNA2531-5 | Item 24 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut, Item 15, if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

11 Remove any excess sealant from the edges of the Foam Carrier, Item (20) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

13 Apply a fillet seal to the edges of the Foam Carrier, Item (20), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(e) At Rib 5 LH at STGR 6 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03 and Fig. A-UBDAJ Sheet 04, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 18 | Nut | ASNA2531-4 | Item 15 |
| 36 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(f) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03 and Fig. A-UBDAJ Sheet 04, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(30) Subtask 571208-020-407-010 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAJ<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 RH at STGR 4 thru 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAJ Sheet 01 and Fig. A-UBDAJ Sheet 02, remove:

| | | | | |
|---|---|---|---|---|
| 14 | Fasteners | | | Discard |
| 1 | Foam Carrier STGR 4 | D5725655200100 | Item (2) | Retain |
| 1 | Foam Carrier STGR 5 | D5725655300100 | Item (21) | Retain |
| 1 | Foam Sealant STGR 4 | D5725655721000 | Item (3) | Discard |
| 1 | Foam Sealant STGR 4 | D5725655721200 | Item (4) | Discard |
| 1 | Foam Sealant STGR 5 | D5725655721400 | Item (22) | Discard |
| 2 | Nut | | Item (23) | Discard |
| 1 | Packer STGR 4 | D5725660920100 | Item (35) | Retain |
| 1 | Packer STGR 5 | D5725661020100 | Item (37) | Retain |

(b) At Rib 5 RH at STGR 6 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAJ Sheet 01 and Fig. A-UBDAJ Sheet 02, remove:

| | | |
|---|---|---|
| 18 | Fasteners | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(31) Subtask 571208-320-411-003 - Oversize the Fastener Holes of the Metallic Packer Rib 5 RH (On Bench)**

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 1 |
| Subtask elapsed time | 0.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBHAB<br>Enlargement of the Metallic Packer holes | Sheet 01 |

(a) Drill and ream the fastener holes of the packers, Items (35) and (37) to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBHAB Sheet 01.

**(32) Subtask 571208-320-409-010 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAJ<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

(a) At Rib 5 RH at STGR 4 and STGR 5 positions, do the procedure that follows:

1



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

Temporarily clamp in position, the Cleats to the STGR's close to the two open holes in the STGR's, refer to Fig. A-UBDAJ Sheet 01, Views A, B and C.

2 Drill and ream the fastener holes to final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, Views H, J, K and L and Fig. A-UBDAJ Sheet 04 fastener table.

NOTE: Do not remove the clamps at this stage.

(b)

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

At Rib 5 RH at STGR 6 thru 12 and 15 thru 16, drill and ream the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, Views M, N, P and Q and Fig. A-UBDAJ Sheet 04 fastener table.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(33) Subtask 571208-250-409-010 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAJ<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAJ Sheet 01, Fig. A-UBDAJ Sheet 02, Fig. A-UBDAJ Sheet 03 and Fig. A-UBDAJ Sheet 04, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(34) Subtask 571208-831-408-010 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B16R04 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 3 | D5725655721000 | 1 | SEALANT | |
| 4 | D5725655721200 | 1 | SEALANT | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 13 | BOLT | |
| 8 | EN6115V4Y7 | 5 | BOLT | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 10 | EN6114V4Y17 | 1 | BOLT CSK | |
| 11 | EN6114V4Y18 | 1 | BOLT CSK | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |
| 17 | EN6115V4-3 | 2 | BOLT | |
| 18 | EN6115V3-4 | 4 | BOLT | |
| 19 | EN6115V3-5 | 4 | BOLT | |
| 22 | D5725655721400 | 1 | SEALANT | |
| 24 | ASNA2531-5 | 3 | NUT | |
| 27 | ASNA2531-3 | 8 | NUT | |

NOTE: Kit B16 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |
| | Polysulfide Sealant-Low Density Multi Purpose Bru | 06ACA1 | As required | |
| | Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required | |
| | Non Aqueous Cleaner - General | 08BAA9 | As required | |
| | Textile - Lint Free Cotton | 14SBA1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAJ<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 RH at STGR 4 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, Views H and K and Fig. A-UBDAJ Sheet 04, Section A-A and fastener table, install the Metallic Packer, Item (35) as follows:

1 Clean the Metallic Packer, Item (35) with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (35):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 10 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 7.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 4 | D5725660920100 | Item (35) | Retained at removal |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6114V4Y17 | Item 10 |
| 1 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Nut | ASNA2531-4 | Item 15 |
| 4 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 5 RH at STGR 4 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, Views H and K and Fig. A-UBDAJ Sheet 04, section A-A and fastener table, install the Foam Carrier, Item (2) Foam Sealants, Item 3 and Item 4 as follows:

1 Clean the Foam Carrier, Item (2) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealants, Item 3 and Item 4, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)
- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealants, Item 3 and Item 4 into the Foam Carrier, Item (2).

7 Apply to the mating surfaces of the Foam Carrier, Item (2):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (2) and Foam Sealants, Item 3 and Item 4 in position at Rib 5 RH at STGR 4 with a suitable tool to guide the foam into position on assembly.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

9 Make sure the Foam Sealants, Item 3 and Item 4 are not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 4 | D5725655200100 | Item (2) | Retained at removal |
| 1 | Foam Sealant | D5725655721000 | Item 3 | |
| 1 | Foam Sealant | D5725655721200 | Item 4 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4-3 | Item 17 |
| 2 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-5 | Item 19 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 4 | Nut | ASNA2531-3 | Item 27 |
| 1 | Nut | ASNA2531-5 | Item 24 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut, Item 15 if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

11 Remove any excess sealant from the edges of the Foam Carrier, Item (2) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

13 Apply a fillet seal to the edges of the Foam Carrier, Item (2), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(c) At Rib 5 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, Views J and L and Fig. A-UBDAJ Sheet 04, section B-B and fastener table, install the Metallic Packer, Item (37) as follows:

1 Clean the Metallic Packer, Item (37) with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (37):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 5 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 8.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725661020100 | Item (37) | Retained at removal |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6114V4Y18 | Item 11 |
| 1 | Bolt | EN6115V4Y7 | Item 8 |
| 2 | Nut | ASNA2531-4 | Item 15 |
| 4 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(d) At Rib 5 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, Views J and L and Fig. A-UBDAJ Sheet 04, section B-B and fastener table, install the Foam Carrier, Item (21) and Foam Sealant, Item 22 as follows:

1 Clean the Foam Carrier, Item (21) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealant, Item 22, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)
- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealant, Item 22 into the Foam Carrier, Item (21).

7 Apply to the mating surfaces of the Foam Carrier, Item (21):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (21) and Foam Sealant, Item 22 in position at Rib 5 RH at STGR 5 with a suitable tool to guide the foam into position on assembly.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

9 Make sure the Foam Sealant, Item 22 is not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 5 | D5725655300100 | Item (21) | Retained at removal |
| 1 | Foam Sealant | D5725655721400 | Item 22 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4-3 | Item 17 |
| 2 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-5 | Item 19 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 2 | Washer | NSA5372-416B | Item 16 |
| 4 | Nut | ASNA2531-3 | Item 27 |
| 2 | Nut | ASNA2531-5 | Item 24 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

11 Remove any excess sealant from the edges of the Foam Carrier, Item (21) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

13 Apply a fillet seal to the edges of the Foam Carrier, Item (21), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(e) At Rib 5 RH at STGR 6 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03 and Fig. A-UBDAJ Sheet 04, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 18 | Nut | ASNA2531-4 | Item 15 |
| 36 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(f) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03 and Fig. A-UBDAJ Sheet 04, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(35) Subtask 571208-020-408-010 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAJ<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAJ Sheet 01, remove:

| | | | | |
|---|---|---|---|---|
| 7 | Fastener | | | Discard |
| 1 | Foam Carrier STGR 5 | D5725655100000 | Item (40) | Retain |
| 1 | Foam Sealant STGR 5 | D5725655720000 | Item (12) | Discard |
| 1 | Packer STGR 5 | D5725660820000 | Item (38) | Retain |
| 1 | Nut | | Item (23) | Discard |

(b) At Rib 6 LH at STGRs 6 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAJ Sheet 01, remove:

| | | |
|---|---|---|
| 18 | Fastener | Discard |

**(36) Subtask 571208-320-412-004 - Oversize the Fastener Holes of the Metallic Packer Rib 6 LH (On Bench)**

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 1 |
| Subtask elapsed time | 0.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBHAB<br>Enlargement of the Metallic Packer holes | Sheet 01 |

(a) Drill and ream the fastener holes of the packer, Item (38) to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBHAB Sheet 01.

**(37) Subtask 571208-320-414-010 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAJ<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 LH at STGR 5 position, do the procedure that follows:

1

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

Temporarily clamp in position, the Cleat to the STGR close to the two open holes in the STGR, refer to Fig. A-UBEAJ Sheet 01, Views A and B.

2 Drill and ream all the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02, Views F and G and Fig. A-UBEAJ Sheet 03 fastener table.

NOTE: Do not remove the clamps at this stage.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b)

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

At Rib 6 LH at STGR 6 thru 12 and 15 thru 16. drill and ream the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02, Views H and J and Fig. A-UBEAJ Sheet 03, Views K and L and fastener table.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(38) Subtask 571208-250-410-010 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAJ<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAJ Sheet 01, Fig. A-UBEAJ Sheet 02 and Fig. A-UBEAJ Sheet 03, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

- If no damage is found, do the worksteps that follow.

**(39) Subtask 571208-831-409-010 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

Material necessary to do the job

Kit 571208B25R03

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 5 | EN6114V3A16 | 1 | BOLT CSK | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 9 | EN6115V4Y8 | 5 | BOLT | |
| 12 | D5725655720000 | 1 | SEALANT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |
| 18 | EN6115V3-4 | 1 | BOLT | |
| 24 | ASNA2531-5 | 1 | NUT | |
| 25 | EN6115V3-6 | 2 | BOLT | |
| 26 | EN6115V3-8 | 2 | BOLT | |
| 27 | ASNA2531-3 | 5 | NUT | |

NOTE: Kit B25 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

Consumable CMLB01

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Polysulfide Sealant-Low Density Multi Purpose Bru | 06ACA1 | As required | |
| | Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required | |
| | Non Aqueous Cleaner - General | 08BAA9 | As required | |
| | Textile - Lint Free Cotton | 14SBA1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAJ<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02, View F and G and Fig. A-UBEAJ Sheet 03, section A-A and fastener table, install the Metallic Packer, Item (38) as follows:

1 Clean the Metallic Packer, Item (38) with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (38):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 5 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 8.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725660820000 | Item (38) | Retained at removal |

with:



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |
| 1 | Bolt | EN6115V4Y8 | Item 9 |
| 1 | Bolt | EN6114V3A16 | Item 5 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under nut, Item 15 if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02, View F and G and Fig. A-UBEAJ Sheet 03, section A-A and fastener table, install the Foam Carrier, Item (40) and Foam Sealant, Item 12 as follows:

1 Clean the Foam Carrier, Item (40) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealant, Item 12, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)

- The calculated mass can be used as a quality control measure to ensure adequate fill.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant-Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealant, Item 12 into the Foam Carrier, Item (40).

7 Apply to the mating surfaces of the Foam Carrier, Item (40):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (40) and Foam Sealant, Item 12 in position at Rib 6 LH at STGR 5 with a suitable tool to guide the foam into position on assembly.

9 Make sure the Foam Sealant, Item 12 is not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

with:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 5 | D5725655100000 | Item (40) | Retained at removal |
| 1 | Foam Sealant | D5725655720000 | Item 12 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-6 | Item 25 |
| 2 | Bolt | EN6115V3-8 | Item 26 |
| 1 | Nut | ASNA2531-5 | Item 24 |
| 5 | Nut | ASNA2531-3 | Item 27 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

11 Remove any excess sealant from the edges of the Foam Carrier, Item (40) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

13 Apply a fillet seal to the edges of the Foam Carrier, Item (40), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(c) At Rib 6 LH at STGRs 6 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02 and Fig. A-UBEAJ Sheet 03, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 18 | Nut | ASNA2531-4 | Item 15 |
| 36 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(d) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02 and Fig. A-UBEAJ Sheet 03, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(40) Subtask 571208-020-409-010 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAJ<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAJ Sheet 01, remove:

| | | | | |
|---|---|---|---|---|
| 7 | Fastener | | | Discard |
| 1 | Foam Carrier STGR 5 | D5725655100100 | Item (41) | Retain |
| 1 | Foam Sealant STGR 5 | D5725655720000 | Item (12) | Discard |
| 1 | Nut | | Item (23) | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725660820100 | Item (39) | Retain |

(b) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAJ Sheet 01, remove:

| | | |
|---|---|---|
| 18 | Fastener | Discard |

**(41) Subtask 571208-320-413-003 - Oversize the Fastener Holes of the Metallic Packer Rib 6 RH (On Bench)**

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 1 |
| Subtask elapsed time | 0.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBHAB<br>Enlargement of the Metallic Packer holes | Sheet 01 |

(a) Drill and ream the fastener holes of the packer, Item (39) to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBHAB Sheet 01.

**(42) Subtask 571208-320-415-010 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAJ<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 RH at STGR 5 position, do the procedure that follows:

1



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

Temporarily clamp in position, the Cleat to the STGR close to the two open holes in the STGR, refer Fig. A-UBEAJ Sheet 01, Views A and B.

2 Drill and ream all the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02, Views F and G and Fig. A-UBEAJ Sheet 03 fastener table.

NOTE: Do not remove the clamps at this stage.

(b)

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

At Rib 6 RH at STGRS 6 thru 12 and 15 thu 16, drill and ream the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02, Views H and J and Fig. A-UBEAJ Sheet 03, Views K and L and fastener table.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(43) Subtask 571208-250-411-010 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAJ<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAJ Sheet 01, Fig. A-UBEAJ Sheet 02 and Fig. A-UBEAJ Sheet 03, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(44) Subtask 571208-831-410-010 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B25R03 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 5 | EN6114V3A16 | 1 | BOLT CSK | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 8 | EN6115V4Y7 | 1 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 12 | D5725655720000 | 1 | SEALANT | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |
| 18 | EN6115V3-4 | 1 | BOLT | |
| 24 | ASNA2531-5 | 2 | NUT | |
| 25 | EN6115V3-6 | 2 | BOLT | |
| 26 | EN6115V3-8 | 2 | BOLT | |
| 27 | ASNA2531-3 | 5 | NUT | |

NOTE: Kit B25 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |
| | Polysulfide Sealant-Low Density Multi Purpose Bru | 06ACA1 | As required | |
| | Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required | |
| | Non Aqueous Cleaner - General | 08BAA9 | As required | |
| | Textile - Lint Free Cotton | 14SBA1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAJ<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02, View F and G and Fig. A-UBEAJ Sheet 03, section A-A and fastener table, install the Metallic Packer, Item (39) as follows:

1 Clean the Metallic Packer, Item (39) with a non-metallic scraper and:

Textile - Lint Free Cotton 14SBA1 As required

made moist with



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (39):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 5 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 8.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725660820100 | Item (39) | Retained at removal |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4Y7 | Item 8 |
| 1 | Bolt | EN6114V3A16 | Item 5 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under nut, Item 15 if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02, View F and G and Fig. A-UBEAJ Sheet 03, section A-A and fastener table, install the Foam Carrier, Item (41) and Foam Sealant, Item 12 as follows:

1 Clean the Foam Carrier, Item (41) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

2 Soak the Foam Sealant, Item 12, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)

- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealant, Item 12 into the Foam Carrier, Item (41).

7 Apply to the mating surfaces of the Foam Carrier, Item (41):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (41) and Foam Sealant, Item 12 in position at Rib 6 RH at STGR 5 with a suitable tool to guide the foam into position on assembly.

9 Make sure the Foam Sealant, Item 12 is not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 5 | D5725655100100 | Item (41) | Retained at removal |
| 1 | Foam Sealant | D5725655720000 | Item 12 | |

with:



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |
| 1 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-6 | Item 25 |
| 2 | Bolt | EN6115V3-8 | Item 26 |
| 2 | Nut | ASNA2531-5 | Item 24 |
| 5 | Nut | ASNA2531-3 | Item 27 |

11 Remove any excess sealant from the edges of the Foam Carrier, Item (41) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

13 Apply a fillet seal to the edges of the Foam Carrier, Item (41), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(c) At Rib 6 RH at STGRs 6 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02 and Fig. A-UBEAJ Sheet 03, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 18 | Nut | ASNA2531-4 | Item 15 |
| 36 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(d) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02 and Fig. A-UBEAJ Sheet 03, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(45) Subtask 571208-020-410-004 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 6B LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBFAC Sheet 01, remove:

| | | |
|---|---|---|
| 2 | Fastener | Discard |

**(46) Subtask 571208-320-419-004 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 LH at STGR 5 in accordance with SRM 51-44-11 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(47) Subtask 571208-250-412-004 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B LH at STGR 5 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(48) Subtask 571208-831-411-005 - Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B28R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 3 | EN6115V3A6 | 2 | BOLT | |
| 14 | ASNA2531-3A | 2 | NUT HEX | |

NOTE: Kit B28 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) If the foam seals on the dry bay cleats are found damaged contact AIRBUS.

(b) At Rib 6B LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V3A6 | Item 3 |
| 2 | Nut | ASNA2531-3A | Item 14 |

(c) At Rib 6B LH at STGR 5 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(49) Subtask 571208-020-411-004 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6B RH at STGR 5 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBFAC Sheet 01, remove:

| | | |
|---|---|---|
| 2 | Fastener | Discard |

**(50) Subtask 571208-320-418-004 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6B RH at STGR 5 in accordance with SRM 51-44-11 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(51) Subtask 571208-250-413-004 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B RH at STGR 5 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

- If no damage is found, do the worksteps that follow.

**(52) Subtask 571208-831-412-004 - Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B28R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 3 | EN6115V3A6 | 2 | BOLT | |
| 14 | ASNA2531-3A | 2 | NUT HEX | |

NOTE: Kit B28 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 6B RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V3A6 | Item 3 |
| 2 | Nut | ASNA2531-3A | Item 14 |

(b) At Rib 6B RH at STGR 5 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(53) Subtask 571208-020-412-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(54) Subtask 571208-320-417-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(55) Subtask 571208-250-414-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(56) Subtask 571208-831-413-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B31R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 16 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B31 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 16 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(57) Subtask 571208-020-413-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(58) Subtask 571208-320-416-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(59) Subtask 571208-250-415-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(60) Subtask 571208-831-414-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B31R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 16 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B31 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 16 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(61) Subtask 571208-960-401-001 - Replace the LP Fuel Filters**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 400 | |

| Manpower Resources | |
|---|---|
| Manhours | 1.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.50 |
| Skills | ENGINE |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 73-11-10-920-001<br>Task 73-12-42-920-010 |

(a) Replace the LP fuel filter elements at Engine 1 (1000EM1), Engine 2 (1000EM2):

- if CFM engines are installed, refer to AMM Task 73-11-10-920-001.
- if IAE engines are installed, refer to AMM Task 73-12-42-920-010.

****CONF 010**

**(1) Subtask 571208-020-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(2) Subtask 571208-320-401-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(3) Subtask 571208-250-402-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(4) Subtask 571208-831-401-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(5) Subtask 571208-000-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(6) Subtask 571208-320-403-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(7) Subtask 571208-250-403-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(8) Subtask 571208-831-402-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(9) Subtask 571208-020-402-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(10) Subtask 571208-320-404-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(11) Subtask 571208-250-404-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(12) Subtask 571208-831-403-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B04R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B04 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(13) Subtask 571208-020-403-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(14) Subtask 571208-320-405-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(15) Subtask 571208-250-405-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(16) Subtask 571208-831-404-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B04R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B04 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(17) Subtask 571208-020-404-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(18) Subtask 571208-320-410-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(19) Subtask 571208-250-406-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(20) Subtask 571208-831-405-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12 install the fasteners from the AFT side of the stringer to make sure that there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(21) Subtask 571208-020-405-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(22) Subtask 571208-320-407-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(23) Subtask 571208-250-407-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(24) Subtask 571208-831-406-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(25) Subtask 571208-020-406-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAC<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAC Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(26) Subtask 571208-320-408-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAC<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAC Sheet 01 and Fig. A-UBDAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(27) Subtask 571208-250-408-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAC<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAC Sheet 01 and Fig. A-UBDAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(28) Subtask 571208-831-407-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B10R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 4 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B10 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAC<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAC Sheet 01 and Fig. A-UBDAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 4 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAC Sheet 01 and Fig. A-UBDAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(29) Subtask 571208-020-407-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAC<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAC Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(30) Subtask 571208-320-409-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAC<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAC Sheet 01 and Fig. A-UBDAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(31) Subtask 571208-250-409-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAC<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAC Sheet 01 and Fig. A-UBDAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(32) Subtask 571208-831-408-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B10R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 4 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B10 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAC<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAC Sheet 01 and Fig. A-UBDAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 4 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAC Sheet 01 and Fig. A-UBDAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(33) Subtask 571208-020-408-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAC<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(34) Subtask 571208-320-414-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAC<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBEAC Sheet 01 and Fig. A-UBEAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(35) Subtask 571208-250-410-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAC<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAC Sheet 01 and Fig. A-UBEAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(36) Subtask 571208-831-409-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B19R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B19 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAC<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAC Sheet 01 and Fig. A-UBEAC Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAC Sheet 01 and Fig. A-UBEAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(37) Subtask 571208-020-409-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAC<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(38) Subtask 571208-320-415-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAC<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBEAC Sheet 01 and Fig. A-UBEAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(39) Subtask 571208-250-411-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAC<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAC Sheet 01 and Fig. A-UBEAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(40) Subtask 571208-831-410-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B19R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B19 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAC<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAC Sheet 01 and Fig. A-UBEAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAC Sheet 01 and Fig. A-UBEAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(41) Subtask 571208-020-412-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(42) Subtask 571208-320-417-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(43) Subtask 571208-250-414-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(44) Subtask 571208-831-413-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B30R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 18 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B30 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 18 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(45) Subtask 571208-020-413-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(46) Subtask 571208-320-416-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(47) Subtask 571208-250-415-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(48) Subtask 571208-831-414-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B30R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 18 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B30 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 18 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(49) Subtask 571208-960-401-001 - Replace the LP Fuel Filters**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 400 | |

| Manpower Resources | |
|---|---|
| Manhours | 1.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.50 |
| Skills | ENGINE |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 73-11-10-920-001<br>Task 73-12-42-920-010 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) Replace the LP fuel filter elements at Engine 1 (1000EM1), Engine 2 (1000EM2):

- if CFM engines are installed, refer to AMM Task 73-11-10-920-001.
- if IAE engines are installed, refer to AMM Task 73-12-42-920-010.

**CONF 011

**(1) Subtask 571208-020-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(2) Subtask 571208-320-401-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(3) Subtask 571208-250-402-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(4) Subtask 571208-831-401-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(5) Subtask 571208-000-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(6) Subtask 571208-320-403-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(7) Subtask 571208-250-403-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(8) Subtask 571208-831-402-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(9) Subtask 571208-020-402-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(10) Subtask 571208-320-404-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(11) Subtask 571208-250-404-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(12) Subtask 571208-831-403-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B04R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B04 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(13) Subtask 571208-020-403-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(14) Subtask 571208-320-405-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(15) Subtask 571208-250-405-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(16) Subtask 571208-831-404-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B04R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B04 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(17) Subtask 571208-020-404-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(18) Subtask 571208-320-410-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(19) Subtask 571208-250-406-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(20) Subtask 571208-831-405-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12 install the fasteners from the AFT side of the stringer to make sure that there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(21) Subtask 571208-020-405-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(22) Subtask 571208-320-407-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(23) Subtask 571208-250-407-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(24) Subtask 571208-831-406-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(25) Subtask 571208-020-406-006 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAE<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 LH at STGR 4 thru 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAE Sheet 01 and Fig. A-UBDAE Sheet 02, remove:

| | | | | |
|---|---|---|---|---|
| 14 | Fasteners | | | Discard |
| 1 | Foam Carrier STGR 4 | D5725655200000 | Item (1) | Retain |
| 1 | Foam Carrier STGR 5 | D5725655300000 | Item (20) | Retain |
| 1 | Foam Sealant STGR 4 | D5725655721000 | Item (3) | Discard |
| 1 | Foam Sealant STGR 4 | D5725655721200 | Item (4) | Discard |
| 1 | Foam Sealant STGR 5 | D5725655721400 | Item (22) | Discard |
| 2 | Nut | | Item (23) | Discard |
| 1 | Packer STGR 4 | D5725654720000 | Item (28) | Retain |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725654820000 | Item (30) | Retain |

(b) At Rib 5 LH at STGR 6 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAE Sheet 01 and Fig. A-UBDAE Sheet 02, remove:

| | | |
|---|---|---|
| 18 | Fasteners | Discard |

**(26) Subtask 571208-320-406-001 - Oversize the Holes of the Metallic Packer Rib 5 LH (On Bench)**

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 1 |
| Subtask elapsed time | 0.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBHAA<br>Enlargement of the Metallic Packer holes | Sheet 01 |

(a) Drill and ream the holes of the packers, Items (28) and (30) to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBHAA Sheet 01.

**(27) Subtask 571208-320-408-006 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 1 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAE<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 LH at STGR 4 and STGR 5 positions, do the procedure that follows:

1

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

Temporarily clamp in position, the Cleats to the STGR's close to the open holes in the STGR's, refer to Fig. A-UBDAE Sheet 01, Views A, B and C.

2 Drill and ream the fastener holes to final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, Views H, J, K and L and Fig. A-UBDAE Sheet 04 fastener table.

NOTE: Do not remove the clamps at this stage.

(b)

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

At Rib 5 LH at STGR 6 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, Views M, N, P and Q and Fig. A-UBDAE Sheet 04 fastener table, drill and ream the fastener holes to the final diameter.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(28) Subtask 571208-250-408-006 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAE<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAE Sheet 01, Fig. A-UBDAE Sheet 02, Fig. A-UBDAE Sheet 03 and Fig. A-UBDAE Sheet 04, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(29) Subtask 571208-831-407-006 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B12R04 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 3 | D5725655721000 | 1 | SEALANT | |
| 4 | D5725655721200 | 1 | SEALANT | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 13 | BOLT | |
| 8 | EN6115V4Y7 | 5 | BOLT | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 10 | EN6114V4Y17 | 1 | BOLT CSK | |
| 11 | EN6114V4Y18 | 1 | BOLT CSK | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |
| 17 | EN6115V4-3 | 2 | BOLT | |
| 18 | EN6115V3-4 | 4 | BOLT | |
| 19 | EN6115V3-5 | 4 | BOLT | |
| 22 | D5725655721400 | 1 | SEALANT | |
| 24 | ASNA2531-5 | 2 | NUT | |
| 27 | ASNA2531-3 | 8 | NUT | |

NOTE: Kit B12 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |
| | Polysulfide Sealant-Low Density Multi Purpose Bru | 06ACA1 | As required | |
| | Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required | |
| | Non Aqueous Cleaner - General | 08BAA9 | As required | |
| | Textile - Lint Free Cotton | 14SBA1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAE<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 LH at STGR 4 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, View H and K and Fig. A-UBDAE Sheet 04, section A-A and fastener table, install the Metallic Packer, Item (28) as follows:

1 Clean the Metallic Packer, Item (28) with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (28):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 10 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 7.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 4 | D5725654720000 | Item (28) | Retained at removal |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6114V4Y17 | Item 10 |
| 1 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Nut | ASNA2531-4 | Item 15 |
| 4 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 5 LH at STGR 4 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, View H and K and Fig. A-UBDAE Sheet 04, section A-A and fastener table, install the Foam Carrier, Item (1) Foam Sealants, Item 3 and Item 4 as follows:

1 Clean the Foam Carrier, Item (1) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealants, Item 3 and Item 4, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)
- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealants, Item 3 and Item 4 into the Foam Carrier, Item (1).

7 Apply to the mating surfaces of the Foam Carrier, Item (1):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (1) and Foam Sealants, Item 3 and Item 4 in position at Rib 5 LH at STGR 4 with a suitable tool to guide the foam into position on assembly.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

9 Make sure the Foam Sealants, Item 3 and Item 4 are not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 4 | D5725655200000 | Item (1) | Retained at removal |
| 1 | Foam Sealant | D5725655721000 | Item 3 | |
| 1 | Foam Sealant | D5725655721200 | Item 4 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4-3 | Item 17 |
| 2 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-5 | Item 19 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 4 | Nut | ASNA2531-3 | Item 27 |
| 1 | Nut | ASNA2531-5 | Item 24 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut, Item 15 if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

11 Remove any excess sealant from the edges of the Foam Carrier, Item (1) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

13 Apply a fillet seal to the edges of the Foam Carrier, Item (1), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(c) At Rib 5 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, View J and L and Fig. A-UBDAE Sheet 04, section B-B and fastener table, install the Metallic Packer, Item (30) as follows:

1 Clean the Metallic Packer, Item (30) with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (30):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 11 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 8.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725654820000 | Item (30) | Retained at removal |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6114V4Y18 | Item 11 |
| 1 | Bolt | EN6115V4Y7 | Item 8 |
| 2 | Nut | ASNA2531-4 | Item 15 |
| 4 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(d) At Rib 5 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, View J and L and Fig. A-UBDAE Sheet 04, section B-B and fastener table, install the Foam Carrier, Item (20) and Foam Sealant, Item 22 as follows:

1 Clean the Foam Carrier, Item (20) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealant, Item 22, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)
- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealant, Item 22 into the Foam Carrier, Item (20).

7 Apply to the mating surfaces of the Foam Carrier, Item (20):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (20) and Foam Sealant, Item 22 in position at Rib 5 LH at STGR 5 with a suitable tool to guide the foam into position on assembly.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

9 Make sure the Foam Sealant, Item 22 is not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 5 | D5725655300000 | Item (20) | Retained at removal |
| 1 | Foam Sealant | D5725655721400 | Item 22 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4-3 | Item 17 |
| 2 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-5 | Item 19 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 4 | Nut | ASNA2531-3 | Item 27 |
| 1 | Nut | ASNA2531-5 | Item 24 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

11 Remove any excess sealant from the edges of the Foam Carrier, Item (20) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

13 Apply a fillet seal to the edges of the Foam Carrier, Item (20), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(e) At Rib 5 LH at STGR 6 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03 and Fig. A-UBDAE Sheet 04, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 18 | Nut | ASNA2531-4 | Item 15 |
| 36 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(f) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03 and Fig. A-UBDAE Sheet 04, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(30) Subtask 571208-020-407-006 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAE<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 RH at STGR 4 thru 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAE Sheet 01 and Fig. A-UBDAE Sheet 02, remove:

| | | | | |
|---|---|---|---|---|
| 14 | Fasteners | | | Discard |
| 1 | Foam Carrier STGR 4 | D5725655200100 | Item (2) | Retain |
| 1 | Foam Carrier STGR 5 | D5725655300100 | Item (21) | Retain |
| 1 | Foam Sealant STGR 4 | D5725655721200 | Item (4) | Discard |
| 1 | Foam Sealant STGR 4 | D5725655721000 | Item (3) | Discard |
| 1 | Foam Sealant STGR 5 | D5725655721400 | Item (22) | Discard |
| 2 | Nut | | Item (23) | Discard |
| 1 | Packer STGR 4 | D5725654720100 | Item (29) | Retain |
| 1 | Packer STGR 5 | D5725654820100 | Item (31) | Retain |

(b) At Rib 5 RH at STGR 6 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAE Sheet 01 and Fig. A-UBDAE Sheet 02, remove:

| | | |
|---|---|---|
| 18 | Fasteners | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(31) Subtask 571208-320-411-001 - Oversize the Fastener Holes of the Metallic Packer Rib 5 RH (On Bench)**

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 1 |
| Subtask elapsed time | 0.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBHAA<br>Enlargement of the Metallic Packer holes | Sheet 01 |

(a) Drill and ream the fastener holes of the packers, Items (29) and (31) to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBHAA Sheet 01.

**(32) Subtask 571208-320-409-006 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAE<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

(a) At Rib 5 RH at STGR 4 and STGR 5 positions, do the procedure that follows:

1



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

Temporarily clamp in position, the Cleats to the STGR's close to the two open holes in the STGR's, refer to Fig. A-UBDAE Sheet 01, Views A, B and C.

2 Drill and ream the fastener holes to final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, Views H, J, K and L and Fig. A-UBDAE Sheet 04 fastener table.

NOTE: Do not remove the clamps at this stage.

(b)

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

At Rib 5 STGR 6 thru 12 and 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, Views M, N, P and Q and Fig. A-UBDAE Sheet 04 fastener table, drill and ream the fastener holes to the final diameter.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(33) Subtask 571208-250-409-006 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAE<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAE Sheet 01, Fig. A-UBDAE Sheet 02, Fig. A-UBDAE Sheet 03 and Fig. A-UBDAE Sheet 04, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(34) Subtask 571208-831-408-006 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B12R04 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 3 | D5725655721000 | 1 | SEALANT | |
| 4 | D5725655721200 | 1 | SEALANT | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 13 | BOLT | |
| 8 | EN6115V4Y7 | 5 | BOLT | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 10 | EN6114V4Y17 | 1 | BOLT CSK | |
| 11 | EN6114V4Y18 | 1 | BOLT CSK | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |
| 17 | EN6115V4-3 | 2 | BOLT | |
| 18 | EN6115V3-4 | 4 | BOLT | |
| 19 | EN6115V3-5 | 4 | BOLT | |
| 22 | D5725655721400 | 1 | SEALANT | |
| 24 | ASNA2531-5 | 2 | NUT | |
| 27 | ASNA2531-3 | 8 | NUT | |

NOTE: Kit B12 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |
| | Polysulfide Sealant-Low Density Multi Purpose Bru | 06ACA1 | As required | |
| | Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required | |
| | Non Aqueous Cleaner - General | 08BAA9 | As required | |
| | Textile - Lint Free Cotton | 14SBA1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAE<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 RH at STGR 4 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, Views H and K and Fig. A-UBDAE Sheet 04, Section A-A and fastener table, install the Metallic Packer, Item (29) as follows:

1 Clean the Metallic Packer, Item (29) with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (29):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 10 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 7.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 4 | D5725654720100 | Item (29) | Retained at removal |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6114V4Y17 | Item 10 |
| 1 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Nut | ASNA2531-4 | Item 15 |
| 4 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 5 RH at STGR 4 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, View H and K and Fig. A-UBDAE Sheet 04, section A-A and fastener table, install the Foam Carrier, Item (2) Foam Sealants, Item 3 and Item 4 as follows:

1 Clean the Foam Carrier, Item (2) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealants, Item 3 and Item 4, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)
- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealants, Item 3 and Item 4 into the Foam Carrier, Item (2).

7 Apply to the mating surfaces of the Foam Carrier, Item (2):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (2) and Foam Sealants, Item 3 and Item 4 in position at Rib 5 RH at STGR 4 with a suitable tool to guide the foam into position on assembly.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

9 Make sure the Foam Sealants, Item 3 and Item 4 are not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 4 | D5725655200100 | Item (2) | Retained at removal |
| 1 | Foam Sealant | D5725655721000 | Item 3 | |
| 1 | Foam Sealant | D5725655721200 | Item 4 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4-3 | Item 17 |
| 2 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-5 | Item 19 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 4 | Nut | ASNA2531-3 | Item 27 |
| 1 | Nut | ASNA2531-5 | Item 24 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut, Item 15 if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

11 Remove any excess sealant from the edges of the Foam Carrier, Item (2) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

13 Apply a fillet seal to the edges of the Foam Carrier, Item (2), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(c) At Rib 5 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, Views J and L and Fig. A-UBDAE Sheet 04, section B-B and fastener table, install the Metallic Packer, Item (31) as follows:

1 Clean the Metallic Packer, Item (31) with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (31):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 11 AND FULL INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 8.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725654820100 | Item (31) | Retained at removal |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6114V4Y18 | Item 11 |
| 1 | Bolt | EN6115V4Y7 | Item 8 |
| 2 | Nut | ASNA2531-4 | Item 15 |
| 4 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(d) At Rib 5 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03, View J and L and Fig. A-UBDAE Sheet 04, section B-B and fastener table, install the Foam Carrier, Item (21) and Foam Sealant, Item 22 as follows:

1 Clean the Foam Carrier, Item (21) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealant, Item 22, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)
- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealant, Item 22 into the Foam Carrier, Item (21).

7 Apply to the mating surfaces of the Foam Carrier, Item (21):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (21) and Foam Sealant, Item 22 in position at Rib 5 RH at STGR 5 with a suitable tool to guide the foam into position on assembly.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

9 Make sure the Foam Sealant, Item 22 is not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 5 | D5725655300100 | Item (21) | Retained at removal |
| 1 | Foam Sealant | D5725655721400 | Item 22 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4-3 | Item 17 |
| 2 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-5 | Item 19 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 4 | Nut | ASNA2531-3 | Item 27 |
| 1 | Nut | ASNA2531-5 | Item 24 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

11 Remove any excess sealant from the edges of the Foam Carrier, Item (21) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

13 Apply a fillet seal to the edges of the Foam Carrier, Item (21), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(e) At Rib 5 RH at STGR 6 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03 and Fig. A-UBDAE Sheet 04, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 18 | Nut | ASNA2531-4 | Item 15 |
| 36 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(f) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAE Sheet 01, View A, Fig. A-UBDAE Sheet 03 and Fig. A-UBDAE Sheet 04, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(35) Subtask 571208-020-408-005 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAE<br>Modification of the Cleat to Stringer<br>Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAE Sheet 01, remove:

| | | | | |
|---|---|---|---|---|
| 7 | Fastener | | | Discard |
| 1 | Foam Carrier STGR 5 | D5725655100000 | Item (40) | Retain |
| 1 | Foam Sealant STGR 5 | D5725655720000 | Item (12) | Discard |
| 1 | Packer STGR 5 | D5725654920000 | Item (32) | Retain |
| 1 | Nut | | Item (23) | Discard |

(b) At Rib 6 LH at STGRs 6 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAE Sheet 01, remove:

| | | |
|---|---|---|
| 18 | Fastener | Discard |

**(36) Subtask 571208-320-412-002 - Oversize the Fastener Holes of the Metallic Packer Rib 6 LH (On Bench)**

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 1 |
| Subtask elapsed time | 0.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBHAA<br>Enlargement of the Metallic Packer holes | Sheet 01 |

(a) Drill and ream the fastener holes of the packer, Item (32) to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBHAA Sheet 01.

**(37) Subtask 571208-320-414-005 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAE<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 LH at STGR 5 position, do the procedure that follows:

1

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

Temporarily clamp in position, the Cleat to the STGR close to the two open holes in the STGR, refer to Fig. A-UBEAE Sheet 01, Views A and B.

2 Drill and ream all the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02, Views F and G and Fig. A-UBEAE Sheet 03 fastener table.

NOTE: Do not remove the clamps at this stage.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b)

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

At the Rib 6 LH at STGR 6 thru 12 and 15 thru 16 drill and ream the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02, Views H and J and Fig. A-UBEAE Sheet 03, Views K and L and fastener table.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(38) Subtask 571208-250-410-005 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAE<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAE Sheet 01, Fig. A-UBEAE Sheet 02 and Fig. A-UBEAE Sheet 03, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

- If no damage is found, do the worksteps that follow.

**(39) Subtask 571208-831-409-005 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

Material necessary to do the job

| Kit 571208B21R03 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 5 | EN6114V3A16 | 1 | BOLT CSK | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 8 | EN6115V4Y7 | 1 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 12 | D5725655720000 | 1 | SEALANT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |
| 18 | EN6115V3-4 | 1 | BOLT | |
| 24 | ASNA2531-5 | 2 | NUT | |
| 25 | EN6115V3-6 | 2 | BOLT | |
| 26 | EN6115V3-8 | 2 | BOLT | |
| 27 | ASNA2531-3 | 5 | NUT | |

NOTE: Kit B21 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Polysulfide Sealant-Low Density Multi Purpose Bru | 06ACA1 | As required | |
| | Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required | |
| | Non Aqueous Cleaner - General | 08BAA9 | As required | |
| | Textile - Lint Free Cotton | 14SBA1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAE<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02, View F and G and Fig. A-UBEAE Sheet 03, section A-A and fastener table, install the Metallic Packer, Item (32) as follows:

1 Clean the Metallic Packer, Item (32) with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (32):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 5 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 8.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725654920000 | Item (32) | Retained at removal |

with:



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |
| 1 | Bolt | EN6115V4Y7 | Item 8 |
| 1 | Bolt | EN6114V3A16 | Item 5 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under nut, Item 15 if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02, View F and G and Fig. A-UBEAE Sheet 03, section A-A and fastener table, install the Foam Carrier, Item (40) and Foam Sealant, Item 12 as follows:

1 Clean the Foam Carrier, Item (40) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealant, Item 12, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)

- The calculated mass can be used as a quality control measure to ensure adequate fill.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealant, Item 12 into the Foam Carrier, Item (40).

7 Apply to the mating surfaces of the Foam Carrier, Item (40):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (40) and Foam Sealant, Item 12 in position at Rib 6 LH at STGR 5 with a suitable tool to guide the foam into position on assembly.

9 Make sure the Foam Sealant, Item 12 is not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 5 | D5725655100000 | Item (40) | Retained at removal |
| 1 | Foam Sealant | D5725655720000 | Item 12 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-6 | Item 25 |
| 2 | Bolt | EN6115V3-8 | Item 26 |
| 2 | Nut | ASNA2531-5 | Item 24 |
| 5 | Nut | ASNA2531-3 | Item 27 |

11 Remove any excess sealant from the edges of the Foam Carrier, Item (40) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

13 Apply a fillet seal to the edges of the Foam Carrier, Item (40), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(c) At Rib 6 LH at STGRs 6 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02 and Fig. A-UBEAE Sheet 03, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 18 | Nut | ASNA2531-4 | Item 15 |
| 36 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(d) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02 and Fig. A-UBEAE Sheet 03, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(40) Subtask 571208-020-409-005 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAE<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAE Sheet 01, remove:

| | | | | |
|---|---|---|---|---|
| 7 | Fastener | | | Discard |
| 1 | Foam Carrier STGR 5 | D5725655100100 | Item (41) | Retain |
| 1 | Foam Sealant STGR 5 | D5725655720000 | Item (12) | Discard |
| 1 | Packer STGR 5 | D5725654920100 | Item (33) | Retain |
| 1 | Nut | | Item (23) | Discard |

(b) At Rib 6 RH at STGRs 6 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAE Sheet 01, remove:

| | | |
|---|---|---|
| 18 | Fastener | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(41) Subtask 571208-320-413-002 - Oversize the Fastener Holes of the Metallic Packer Rib 6 RH (On Bench)**

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 1 |
| Subtask elapsed time | 0.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBHAA<br>Enlargement of the Metallic Packer holes | Sheet 01 |

(a) Drill and ream the fastener holes of the packer, Item (33) to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBHAA Sheet 01.

**(42) Subtask 571208-320-415-005 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAE<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 RH at STGR 5 position, do the procedure that follows:

1



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

Temporarily clamp in position, the Cleat to the STGR close to the two open holes in the STGR, refer to Fig. A-UBEAE Sheet 01, Views A and B.

2 Drill and ream all the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02, Views F and G and Fig. A-UBEAE Sheet 03 fastener table.

NOTE: Do not remove the clamps at this stage.

(b)

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

At Rib 6 RH at STGRs 6 thru 12 and 15 thru 16, drill and ream the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02, Views H and J and Fig. A-UBEAE Sheet 03, Views K and L and fastener table.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(43) Subtask 571208-250-411-005 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAE<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAE Sheet 01, Fig. A-UBEAE Sheet 02 and Fig. A-UBEAE Sheet 03, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(44) Subtask 571208-831-410-005 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B21R03 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 5 | EN6114V3A16 | 1 | BOLT CSK | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 8 | EN6115V4Y7 | 1 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 12 | D5725655720000 | 1 | SEALANT | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |
| 18 | EN6115V3-4 | 1 | BOLT | |
| 24 | ASNA2531-5 | 2 | NUT | |
| 25 | EN6115V3-6 | 2 | BOLT | |
| 26 | EN6115V3-8 | 2 | BOLT | |
| 27 | ASNA2531-3 | 5 | NUT | |

NOTE: Kit B21 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |
| | Polysulfide Sealant-Low Density Multi Purpose Bru | 06ACA1 | As required | |
| | Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required | |
| | Non Aqueous Cleaner - General | 08BAA9 | As required | |
| | Textile - Lint Free Cotton | 14SBA1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAE<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02, View F and G and Fig. A-UBEAE Sheet 03, section A-A and fastener table, install the Metallic Packer, Item (33) as follows:

1 Clean the Metallic Packer, Item (33) with a non-metallic scraper and:

Textile - Lint Free Cotton 14SBA1 As required

made moist with



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (33):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 5 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 8.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725654920100 | Item (33) | Retained at removal |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4Y7 | Item 8 |
| 1 | Bolt | EN6114V3A16 | Item 5 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under nut, Item 15 if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02, View F and G and Fig. A-UBEAE Sheet 03, section A-A and fastener table, install the Foam Carrier, Item (41) and Foam Sealant, Item 12 as follows:

1 Clean the Foam Carrier, Item (41) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

2 Soak the Foam Sealant, Item 12, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)

- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealant, Item 12 into the Foam Carrier, Item (41).

7 Apply to the mating surfaces of the Foam Carrier, Item (41):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (41) and Foam Sealant, Item 12 in position at Rib 6 RH at STGR 5 with a suitable tool to guide the foam into position on assembly.

9 Make sure the Foam Sealant, Item 12 is not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 5 | D5725655100100 | Item (41) | Retained at removal |
| 1 | Foam Sealant | D5725655720000 | Item 12 | |

with:



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |
| 1 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-6 | Item 25 |
| 2 | Bolt | EN6115V3-8 | Item 26 |
| 5 | Nut | ASNA2531-3 | Item 27 |
| 2 | Nut | ASNA2531-5 | Item 24 |

11 Remove any excess sealant from the edges of the Foam Carrier, Item (41) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

13 Apply a fillet seal to the edges of the Foam Carrier, Item (41), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(c) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02 and Fig. A-UBEAE Sheet 03, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 18 | Nut | ASNA2531-4 | Item 15 |
| 36 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(d) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAE Sheet 01, View A, Fig. A-UBEAE Sheet 02 and Fig. A-UBEAE Sheet 03, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(45) Subtask 571208-020-410-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBFAB<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 6B LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBFAB Sheet 01, remove:

| | | |
|---|---|---|
| 2 | Fastener | Discard |

**(46) Subtask 571208-320-419-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBFAB<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 LH at STGR 5 in accordance with SRM 51-44-11 and refer to Fig. A-UBFAB Sheet 01 and Fig. A-UBFAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(47) Subtask 571208-250-412-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBFAB<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B LH at STGR 5 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBFAB Sheet 01 and Fig. A-UBFAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(48) Subtask 571208-831-411-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B27R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 1 | EN6115V3A4 | 2 | BOLT | |
| 14 | ASNA2531-3A | 2 | NUT HEX | |

NOTE: Kit B27 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBFAB<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) If the foam seals on the dry bay cleats are found damaged contact AIRBUS.

(b) At Rib 6B LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBFAB Sheet 01 and Fig. A-UBFAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V3A4 | Item 1 |
| 2 | Nut | ASNA2531-3A | Item 14 |

(c) At Rib 6B LH at STGR 5 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBFAB Sheet 01 and Fig. A-UBFAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(49) Subtask 571208-020-411-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBFAB<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6B RH at STGR 5 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBFAB Sheet 01, remove:

| | | |
|---|---|---|
| 2 | Fastener | Discard |

**(50) Subtask 571208-320-418-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBFAB<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6B RH at STGR 5 in accordance with SRM 51-44-11 and refer to Fig. A-UBFAB Sheet 01 and Fig. A-UBFAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(51) Subtask 571208-250-413-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBFAB<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B RH at STGR 5 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBFAB Sheet 01 and Fig. A-UBFAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

- If no damage is found, do the worksteps that follow.

**(52) Subtask 571208-831-412-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B27R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 1 | EN6115V3A4 | 2 | BOLT | |
| 14 | ASNA2531-3A | 2 | NUT HEX | |

NOTE: Kit B27 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBFAB<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) If the foam seals on the dry bay cleats are found damaged contact AIRBUS.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 6B RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBFAB Sheet 01 and Fig. A-UBFAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V3A4 | Item 1 |
| 2 | Nut | ASNA2531-3A | Item 14 |

(c) At Rib 6B RH at STGR 5 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBFAB Sheet 01 and Fig. A-UBFAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(53) Subtask 571208-020-412-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(54) Subtask 571208-320-417-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(55) Subtask 571208-250-414-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(56) Subtask 571208-831-413-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B30R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 18 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B30 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 18 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(57) Subtask 571208-020-413-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(58) Subtask 571208-320-416-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(59) Subtask 571208-250-415-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(60) Subtask 571208-831-414-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B30R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 18 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B30 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 18 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(61) Subtask 571208-960-401-001 - Replace the LP Fuel Filters**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 400 | |

| Manpower Resources | |
|---|---|
| Manhours | 1.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.50 |
| Skills | ENGINE |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 73-11-10-920-001<br>Task 73-12-42-920-010 |

(a) Replace the LP fuel filter elements at Engine 1 (1000EM1), Engine 2 (1000EM2):

- if CFM engines are installed, refer to AMM Task 73-11-10-920-001.
- if IAE engines are installed, refer to AMM Task 73-12-42-920-010.

****CONF 012**

**(1) Subtask 571208-020-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(2) Subtask 571208-320-401-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(3) Subtask 571208-250-402-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(4) Subtask 571208-831-401-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(5) Subtask 571208-000-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(6) Subtask 571208-320-403-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(7) Subtask 571208-250-403-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(8) Subtask 571208-831-402-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(9) Subtask 571208-020-402-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAC Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(10) Subtask 571208-320-404-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(11) Subtask 571208-250-404-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(12) Subtask 571208-831-403-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B05R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 22 | BOLT | |
| 9 | EN6115V4Y8 | 2 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B05 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 22 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(13) Subtask 571208-020-403-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAC Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(14) Subtask 571208-320-405-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(15) Subtask 571208-250-405-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(16) Subtask 571208-831-404-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B05R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 22 | BOLT | |
| 9 | EN6115V4Y8 | 2 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B05 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 22 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(17) Subtask 571208-020-404-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(18) Subtask 571208-320-410-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(19) Subtask 571208-250-406-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(20) Subtask 571208-831-405-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12 install the fasteners from the AFT side of the stringer to make sure that there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(21) Subtask 571208-020-405-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(22) Subtask 571208-320-407-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(23) Subtask 571208-250-407-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(24) Subtask 571208-831-406-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(25) Subtask 571208-020-406-007 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAG<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to , remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(26) Subtask 571208-320-408-008 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAG<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAG Sheet 01 and Fig. A-UBDAG Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(27) Subtask 571208-250-408-008 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAG<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAG Sheet 01 and Fig. A-UBDAG Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(28) Subtask 571208-831-407-008 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B14R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 4 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B14 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAG<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAG Sheet 01 and Fig. A-UBDAG Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 4 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAG Sheet 01 and Fig. A-UBDAG Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(29) Subtask 571208-020-407-008 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAG<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAG Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(30) Subtask 571208-320-409-008 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAG<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAG Sheet 01 and Fig. A-UBDAG Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(31) Subtask 571208-250-409-008 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAG<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAG Sheet 01 and Fig. A-UBDAG Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(32) Subtask 571208-831-408-008 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B14R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 4 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B14 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAG<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAG Sheet 01 and Fig. A-UBDAG Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 4 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAG Sheet 01 and Fig. A-UBDAG Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(33) Subtask 571208-020-408-008 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAG<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAG Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(34) Subtask 571208-320-414-008 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAG<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBEAG Sheet 01 and Fig. A-UBEAG Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(35) Subtask 571208-250-410-008 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAG<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAG Sheet 01 and Fig. A-UBEAG Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(36) Subtask 571208-831-409-008 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B23R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B23 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAG<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAG Sheet 01 and Fig. A-UBEAG Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAG Sheet 01 and Fig. A-UBEAG Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(37) Subtask 571208-020-409-008 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAG<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAG Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(38) Subtask 571208-320-415-008 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAG<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBEAG Sheet 01 and Fig. A-UBEAG Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(39) Subtask 571208-250-411-007 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAG<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to and , do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(40) Subtask 571208-831-410-008 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B23R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B23 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAG<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAG Sheet 01 and Fig. A-UBEAG Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAG Sheet 01 and Fig. A-UBEAG Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(41) Subtask 571208-020-412-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(42) Subtask 571208-320-417-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(43) Subtask 571208-250-414-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(44) Subtask 571208-831-413-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B31R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 16 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B31 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 16 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(45) Subtask 571208-020-413-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(46) Subtask 571208-320-416-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(47) Subtask 571208-250-415-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(48) Subtask 571208-831-414-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B31R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 16 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B31 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 16 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(49) Subtask 571208-960-401-001 - Replace the LP Fuel Filters**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 400 | |

| Manpower Resources | |
|---|---|
| Manhours | 1.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.50 |
| Skills | ENGINE |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 73-11-10-920-001<br>Task 73-12-42-920-010 |

(a) Replace the LP fuel filter elements at Engine 1 (1000EM1), Engine 2 (1000EM2):

- if CFM engines are installed, refer to AMM Task 73-11-10-920-001.
- if IAE engines are installed, refer to AMM Task 73-12-42-920-010.

****CONF 013**

**(1) Subtask 571208-020-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(2) Subtask 571208-320-401-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(3) Subtask 571208-250-402-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(4) Subtask 571208-831-401-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(5) Subtask 571208-000-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(6) Subtask 571208-320-403-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(7) Subtask 571208-250-403-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(8) Subtask 571208-831-402-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(9) Subtask 571208-020-402-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(10) Subtask 571208-320-404-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(11) Subtask 571208-250-404-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(12) Subtask 571208-831-403-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B04R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B04 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(13) Subtask 571208-020-403-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(14) Subtask 571208-320-405-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(15) Subtask 571208-250-405-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(16) Subtask 571208-831-404-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B04R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B04 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(17) Subtask 571208-020-404-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(18) Subtask 571208-320-410-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(19) Subtask 571208-250-406-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(20) Subtask 571208-831-405-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12 install the fasteners from the AFT side of the stringer to make sure that there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(21) Subtask 571208-020-405-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(22) Subtask 571208-320-407-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(23) Subtask 571208-250-407-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(24) Subtask 571208-831-406-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(25) Subtask 571208-020-406-005 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAD<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAD Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(26) Subtask 571208-320-408-005 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAD<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAD Sheet 01 and Fig. A-UBDAD Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(27) Subtask 571208-250-408-005 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAD<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAD Sheet 01 and Fig. A-UBDAD Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(28) Subtask 571208-831-407-005 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B11R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 4 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B11 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAD<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAD Sheet 01 and Fig. A-UBDAD Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 4 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAD Sheet 01 and Fig. A-UBDAD Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(29) Subtask 571208-020-407-005 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAD<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAD Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(30) Subtask 571208-320-409-005 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAD<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAD Sheet 01 and Fig. A-UBDAD Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(31) Subtask 571208-250-409-005 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAD<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAD Sheet 01 and Fig. A-UBDAD Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(32) Subtask 571208-831-408-005 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B11R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 4 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B11 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAD<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAD Sheet 01 and Fig. A-UBDAD Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 4 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAD Sheet 01 and Fig. A-UBDAD Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(33) Subtask 571208-020-408-004 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAD<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMESAND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAD Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(34) Subtask 571208-320-414-004 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAD<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBEAD Sheet 01 and Fig. A-UBEAD Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(35) Subtask 571208-250-410-004 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAD<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAD Sheet 01 and Fig. A-UBEAD Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(36) Subtask 571208-831-409-004 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

Material necessary to do the job

| Kit 571208B20R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 4 | EN6115V3A7 | 1 | BOLT | |
| 6 | EN6115V4Y5 | 3 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |

NOTE: Kit B20 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAD<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAD Sheet 01 and Fig. A-UBEAD Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3A7 | Item 4 |
| 3 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 19 | Nut | ASNA2531-4 | Item 15 |
| 38 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAD Sheet 01 and Fig. A-UBEAD Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(37) Subtask 571208-020-409-004 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAD<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAD Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(38) Subtask 571208-320-415-004 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAD<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBEAD Sheet 01 and Fig. A-UBEAD Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(39) Subtask 571208-250-411-004 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAD<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAD Sheet 01 and Fig. A-UBEAD Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(40) Subtask 571208-831-410-004 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

Material necessary to do the job

Kit 571208B20R01

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 4 | EN6115V3A7 | 1 | BOLT | |
| 6 | EN6115V4Y5 | 3 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |

NOTE: Kit B20 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

Consumable CMLB01

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAD<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAD Sheet 01 and Fig. A-UBEAD Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3A7 | Item 4 |
| 3 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 19 | Nut | ASNA2531-4 | Item 15 |
| 38 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAD Sheet 01 and Fig. A-UBEAD Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(41) Subtask 571208-020-410-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6B LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBFAA Sheet 01, remove:

| | | |
|---|---|---|
| 2 | Fastener | Discard |

**(42) Subtask 571208-320-419-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH

At Rib 6B LH at STGR 5 in accordance with SRM 51-44-11 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(43) Subtask 571208-250-412-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B LH at STGR 5 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(44) Subtask 571208-831-411-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B26R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 2 | EN6115V3A5 | 2 | BOLT | |
| 14 | ASNA2531-3A | 2 | NUT HEX | |

NOTE: Kit B26 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

to wet install:

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V3A5 | Item 2 |
| 2 | Nut | ASNA2531-3A | Item 14 |

(b) At Rib 6B LH at STGR 5 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(45) Subtask 571208-020-411-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6B RH at STGR 5 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBFAA Sheet 01, remove:

| | | |
|---|---|---|
| 2 | Fastener | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(46) Subtask 571208-320-418-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6B RH at STGR 5 in accordance with SRM 51-44-11 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(47) Subtask 571208-250-413-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B RH at STGR 5 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(48) Subtask 571208-831-412-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B26R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 2 | EN6115V3A5 | 2 | BOLT | |
| 14 | ASNA2531-3A | 2 | NUT HEX | |

NOTE: Kit B26 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBFAA<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

2 Bolt EN6115V3A5 Item 2

2 Nut ASNA2531-3A Item 14

(b) At Rib 6B RH at STGR 5 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBFAA Sheet 01 and Fig. A-UBFAA Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(49) Subtask 571208-020-412-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(50) Subtask 571208-320-417-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(51) Subtask 571208-250-414-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(52) Subtask 571208-831-413-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B30R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 18 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B30 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 18 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(53) Subtask 571208-020-413-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(54) Subtask 571208-320-416-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(55) Subtask 571208-250-415-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(56) Subtask 571208-831-414-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B30R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 18 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B30 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 18 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(57) Subtask 571208-960-401-001 - Replace the LP Fuel Filters**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 400 | |

| Manpower Resources | |
|---|---|
| Manhours | 1.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.50 |
| Skills | ENGINE |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 73-11-10-920-001<br>Task 73-12-42-920-010 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) Replace the LP fuel filter elements at Engine 1 (1000EM1), Engine 2 (1000EM2):

- if CFM engines are installed, refer to AMM Task 73-11-10-920-001.
- if IAE engines are installed, refer to AMM Task 73-12-42-920-010.

**CONF 014

**(1) Subtask 571208-020-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(2) Subtask 571208-320-401-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(3) Subtask 571208-250-402-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(4) Subtask 571208-831-401-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(5) Subtask 571208-000-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(6) Subtask 571208-320-403-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(7) Subtask 571208-250-403-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(8) Subtask 571208-831-402-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(9) Subtask 571208-020-402-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAC Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(10) Subtask 571208-320-404-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(11) Subtask 571208-250-404-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(12) Subtask 571208-831-403-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B05R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 22 | BOLT | |
| 9 | EN6115V4Y8 | 2 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B05 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 22 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(13) Subtask 571208-020-403-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAC Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(14) Subtask 571208-320-405-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(15) Subtask 571208-250-405-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(16) Subtask 571208-831-404-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B05R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 22 | BOLT | |
| 9 | EN6115V4Y8 | 2 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B05 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 22 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y8 | Item 9 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(17) Subtask 571208-020-404-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(18) Subtask 571208-320-410-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(19) Subtask 571208-250-406-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(20) Subtask 571208-831-405-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12 install the fasteners from the AFT side of the stringer to make sure that there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(21) Subtask 571208-020-405-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(22) Subtask 571208-320-407-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(23) Subtask 571208-250-407-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(24) Subtask 571208-831-406-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(25) Subtask 571208-020-406-009 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAH<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAH Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(26) Subtask 571208-320-408-009 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAH<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAH Sheet 01 and Fig. A-UBDAH Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(27) Subtask 571208-250-408-009 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBDAH<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAH Sheet 01 and Fig. A-UBDAH Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(28) Subtask 571208-831-407-009 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

Material necessary to do the job

| Kit 571208B15R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 6 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B15 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAH<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAH Sheet 01 and Fig. A-UBDAH Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 6 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAH Sheet 01 and Fig. A-UBDAH Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(29) Subtask 571208-020-407-009 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAH<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAH Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(30) Subtask 571208-320-409-009 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAH<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAH Sheet 01 and Fig. A-UBDAH Sheet 02fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(31) Subtask 571208-250-409-009 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBDAH<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAH Sheet 01 and Fig. A-UBDAH Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(32) Subtask 571208-831-408-009 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B15R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 6 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B15 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAH<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAH Sheet 01 and Fig. A-UBDAH Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 6 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAH Sheet 01 and Fig. A-UBDAH Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(33) Subtask 571208-020-408-009 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAH<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAH Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(34) Subtask 571208-320-414-009 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAH<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBEAH Sheet 01 and Fig. A-UBEAH Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(35) Subtask 571208-250-410-009 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBEAH<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAH Sheet 01 and Fig. A-UBEAH Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(36) Subtask 571208-831-409-009 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B24R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 4 | EN6115V3A7 | 1 | BOLT | |
| 6 | EN6115V4Y5 | 3 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |

NOTE: Kit B24 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAH<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAH Sheet 01 and Fig. A-UBEAH Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3A7 | Item 4 |
| 3 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 19 | Nut | ASNA2531-4 | Item 15 |
| 38 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAH Sheet 01 and Fig. A-UBEAH Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(37) Subtask 571208-020-409-009 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAH<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAH Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(38) Subtask 571208-320-415-009 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAH<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBEAH Sheet 01 and Fig. A-UBEAH Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(39) Subtask 571208-250-411-009 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAH<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAH Sheet 01 and Fig. A-UBEAH Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(40) Subtask 571208-831-410-009 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B24R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 4 | EN6115V3A7 | 1 | BOLT | |
| 6 | EN6115V4Y5 | 3 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

NOTE: Kit B24 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAH<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAH Sheet 01 and Fig. A-UBEAH Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3A7 | Item 4 |
| 3 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 19 | Nut | ASNA2531-4 | Item 15 |
| 38 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAH Sheet 01 and Fig. A-UBEAH Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(41) Subtask 571208-020-410-004 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6B LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBFAC Sheet 01, remove:

| | | |
|---|---|---|
| 2 | Fastener | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(42) Subtask 571208-320-419-004 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 LH at STGR 5 in accordance with SRM 51-44-11 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(43) Subtask 571208-250-412-004 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B LH at STGR 5 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(44) Subtask 571208-831-411-004 - Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B28R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 3 | EN6115V3A6 | 2 | BOLT | |
| 14 | ASNA2531-3A | 2 | NUT HEX | |

NOTE: Kit B28 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V3A6 | Item 3 |
| 2 | Nut | ASNA2531-3A | Item 14 |

(b) At Rib 6B LH at STGR 5 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(45) Subtask 571208-020-411-004 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6B RH at STGR 5 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBFAC Sheet 01, remove:

| | | |
|---|---|---|
| 2 | Fastener | Discard |

**(46) Subtask 571208-320-418-004 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6B RH at STGR 5 in accordance with SRM 51-44-11 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(47) Subtask 571208-250-413-004 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B RH at STGR 5 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(48) Subtask 571208-831-412-004 - Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B28R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 3 | EN6115V3A6 | 2 | BOLT | |
| 14 | ASNA2531-3A | 2 | NUT HEX | |

NOTE: Kit B28 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

to wet install:

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V3A6 | Item 3 |
| 2 | Nut | ASNA2531-3A | Item 14 |

(b) At Rib 6B RH at STGR 5 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(49) Subtask 571208-020-412-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(50) Subtask 571208-320-417-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(51) Subtask 571208-250-414-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(52) Subtask 571208-831-413-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B31R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 16 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B31 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 16 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(53) Subtask 571208-020-413-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(54) Subtask 571208-320-416-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(55) Subtask 571208-250-415-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(56) Subtask 571208-831-414-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B31R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 16 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B31 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 16 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(57) Subtask 571208-960-401-001 - Replace the LP Fuel Filters**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 400 | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 1.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.50 |
| Skills | ENGINE |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 73-11-10-920-001<br>Task 73-12-42-920-010 |

(a) Replace the LP fuel filter elements at Engine 1 (1000EM1), Engine 2 (1000EM2):

- if CFM engines are installed, refer to AMM Task 73-11-10-920-001.
- if IAE engines are installed, refer to AMM Task 73-12-42-920-010.

**CONF 015

**(1) Subtask 571208-020-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(2) Subtask 571208-320-401-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(3) Subtask 571208-250-402-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(4) Subtask 571208-831-401-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(5) Subtask 571208-000-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(6) Subtask 571208-320-403-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(7) Subtask 571208-250-403-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(8) Subtask 571208-831-402-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(9) Subtask 571208-020-402-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAC Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(10) Subtask 571208-320-404-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(11) Subtask 571208-250-404-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(12) Subtask 571208-831-403-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B05R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 22 | BOLT | |
| 9 | EN6115V4Y8 | 2 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B05 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 22 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(13) Subtask 571208-020-403-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAC Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(14) Subtask 571208-320-405-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(15) Subtask 571208-250-405-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(16) Subtask 571208-831-404-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B05R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 22 | BOLT | |
| 9 | EN6115V4Y8 | 2 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B05 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 22 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(17) Subtask 571208-020-404-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(18) Subtask 571208-320-410-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(19) Subtask 571208-250-406-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(20) Subtask 571208-831-405-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12 install the fasteners from the AFT side of the stringer to make sure that there is clearance with existing electrical conduits.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(21) Subtask 571208-020-405-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(22) Subtask 571208-320-407-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(23) Subtask 571208-250-407-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(24) Subtask 571208-831-406-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(25) Subtask 571208-020-406-010 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAJ<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 LH at STGR 4 thru 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAJ Sheet 01 and Fig. A-UBDAJ Sheet 02, remove:

| | | | | |
|---|---|---|---|---|
| 14 | Fasteners | | | Discard |
| 1 | Foam Carrier STGR 4 | D5725655200000 | Item (1) | Retain |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 5 | D5725655300000 | Item (20) | Retain |
| 1 | Foam Sealant STGR 4 | D5725655721000 | Item (3) | Discard |
| 1 | Foam Sealant STGR 4 | D5725655721200 | Item (4) | Discard |
| 1 | Foam Sealant STGR 5 | D5725655721400 | Item (22) | Discard |
| 1 | Packer STGR 4 | D5725660920000 | Item (34) | Retain |
| 1 | Packer STGR 5 | D5725661020000 | Item (36) | Retain |
| 2 | Nut | | Item (23) | Discard |

(b) At Rib 5 LH at STGR 6 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAJ Sheet 01 and Fig. A-UBDAJ Sheet 02, remove:

| | | |
|---|---|---|
| 18 | Fasteners | Discard |

**(26) Subtask 571208-320-406-003 - Oversize the Holes of the Metallic Packer Rib 5 LH (On Bench)**

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 1 |
| Subtask elapsed time | 0.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBHAB<br>Enlargement of the Metallic Packer holes | Sheet 01 |

(a) Drill and ream the holes of the packers, Items, (34) and (36) to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBHAB Sheet 01.

**(27) Subtask 571208-320-408-010 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAJ<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

(a) At Rib 5 LH at STGR 4 and STGR 5 positions, do the procedure that follows:

1

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

Temporarily clamp in position, the Cleats to the STGR's close to the open holes in the STGR's, refer to Fig. A-UBDAJ Sheet 01, Views A, B and C.

2 Drill and ream the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, Views H, J, K and L and Fig. A-UBDAJ Sheet 04 fastener table.

NOTE: Do not remove the clamps at this stage.

(b)

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

At Rib 5 LH AT STGR 6 thru 12 and 15 thru 16 in accordance with SRM 51-44-11 and refer to sheet Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, Views M, N, P and Q and Fig. A-UBDAJ Sheet 04 and fastener table, drill and ream the holes to the final diameter.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

NOTE: Make sure that under head radius is cut adjacent to the fastener head.

**(28) Subtask 571208-250-408-010 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAJ<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAJ Sheet 01, Fig. A-UBDAJ Sheet 02, Fig. A-UBDAJ Sheet 03 and Fig. A-UBDAJ Sheet 04, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(29) Subtask 571208-831-407-010 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

Material necessary to do the job

Kit 571208B16R04

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 3 | D5725655721000 | 1 | SEALANT | |
| 4 | D5725655721200 | 1 | SEALANT | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 13 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 9 | EN6115V4Y8 | 1 | BOLT | |
| 10 | EN6114V4Y17 | 1 | BOLT CSK | |
| 11 | EN6114V4Y18 | 1 | BOLT CSK | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |
| 17 | EN6115V4-3 | 2 | BOLT | |
| 18 | EN6115V3-4 | 4 | BOLT | |
| 19 | EN6115V3-5 | 4 | BOLT | |
| 22 | D5725655721400 | 1 | SEALANT | |
| 24 | ASNA2531-5 | 2 | NUT | |
| 27 | ASNA2531-3 | 8 | NUT | |

NOTE: Kit B16 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

Consumable CMLB01

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |
| | Polysulfide Sealant-Low Density Multi Purpose Bru | 06ACA1 | As required | |
| | Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required | |
| | Non Aqueous Cleaner - General | 08BAA9 | As required | |
| | Textile - Lint Free Cotton | 14SBA1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAJ<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

(a) At Rib 5 LH at STGR 4 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, View H and K and Fig. A-UBDAJ Sheet 04, section A-A and fastener table, install the Metallic Packer, Item (34) as follows:

1 Clean the Metallic Packer, Item (34) with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (34):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 10 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 7.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 4 | D5725660920000 | Item (34) | Retained at removal |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6114V4Y17 | Item 10 |
| 1 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Nut | ASNA2531-4 | Item 15 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 4 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 LH at STGR 4 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, View H and K and Fig. A-UBDAJ Sheet 04, section A-A and fastener table, install the Foam Carrier, Item (1) Foam Sealants, Item 3 and Item 4 as follows:

1 Clean the Foam Carrier, Item (1) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealants, Item 3 and Item 4, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)
- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealants, Item 3 and Item 4 into the Foam Carrier, Item (1).



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

7 Apply to the mating surfaces of the Foam Carrier, Item (1):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (1) and Foam Sealants, Item 3 and Item 4 in position at Rib 5 LH at STGR 4 with a suitable tool to guide the foam into position on assembly.

9 Make sure the Foam Sealants, Item 3 and Item 4 are not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 4 | D5725655200000 | Item (1) | Retained at removal |
| 1 | Foam Sealant | D5725655721000 | Item 3 | |
| 1 | Foam Sealant | D5725655721200 | Item 4 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4-3 | Item 17 |
| 2 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-5 | Item 19 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 4 | Nut | ASNA2531-3 | Item 27 |
| 1 | Nut | ASNA2531-5 | Item 24 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut, Item 15 if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

11 Remove any excess sealant from the edges of the Foam Carrier, Item (1) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required |

13 Apply a fillet seal to the edges of the Foam Carrier, Item (1), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(c) At Rib 5 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, View J and L and Fig. A-UBDAJ Sheet 04, section B-B and fastener table, install the Metallic Packer, Item (36) as follows:

1 Clean the Metallic Packer, Item (36) with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (36):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 11 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 8.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725661020000 | Item (36) | Retained at removal |

with:

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6114V4Y18 | Item 11 |
| 1 | Bolt | EN6115V4Y8 | Item 9 |
| 2 | Nut | ASNA2531-4 | Item 15 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 4 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(d) At Rib 5 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, View J and L and Fig. A-UBDAJ Sheet 04, section B-B and fastener table, install the Foam Carrier, Item (20) and Foam Sealant, Item 22 as follows:

1 Clean the Foam Carrier, Item (20) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealant, Item 22, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)
- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealant, Item 22 into the Foam Carrier, Item (20).



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

7 Apply to the mating surfaces of the Foam Carrier, Item (20):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (20) and Foam Sealant, Item 22 in position at Rib 5 LH at STGR 5 with a suitable tool to guide the foam into position on assembly.

9 Make sure the Foam Sealant, Item 22 is not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 5 | D5725655300000 | Item (20) | Retained at removal |
| 1 | Foam Sealant | D5725655721400 | Item 22 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4-3 | Item 17 |
| 2 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-5 | Item 19 |
| 4 | Nut | ASNA2531-3 | Item 27 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 1 | Nut | ASNA2531-5 | Item 24 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut, Item 15, if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

11 Remove any excess sealant from the edges of the Foam Carrier, Item (20) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

13 Apply a fillet seal to the edges of the Foam Carrier, Item (20), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(e) At Rib 5 LH at STGR 6 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03 and Fig. A-UBDAJ Sheet 04, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 18 | Nut | ASNA2531-4 | Item 15 |
| 36 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(f) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03 and Fig. A-UBDAJ Sheet 04, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(30) Subtask 571208-020-407-010 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAJ<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 RH at STGR 4 thru 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAJ Sheet 01 and Fig. A-UBDAJ Sheet 02, remove:

| | | | | |
|---|---|---|---|---|
| 14 | Fasteners | | | Discard |
| 1 | Foam Carrier STGR 4 | D5725655200100 | Item (2) | Retain |
| 1 | Foam Carrier STGR 5 | D5725655300100 | Item (21) | Retain |
| 1 | Foam Sealant STGR 4 | D5725655721000 | Item (3) | Discard |
| 1 | Foam Sealant STGR 4 | D5725655721200 | Item (4) | Discard |
| 1 | Foam Sealant STGR 5 | D5725655721400 | Item (22) | Discard |
| 2 | Nut | | Item (23) | Discard |
| 1 | Packer STGR 4 | D5725660920100 | Item (35) | Retain |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725661020100 | Item (37) | Retain |

(b) At Rib 5 RH at STGR 6 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAJ Sheet 01 and Fig. A-UBDAJ Sheet 02, remove:

| | | |
|---|---|---|
| 18 | Fasteners | Discard |

**(31) Subtask 571208-320-411-003 - Oversize the Fastener Holes of the Metallic Packer Rib 5 RH (On Bench)**

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 1 |
| Subtask elapsed time | 0.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBHAB<br>Enlargement of the Metallic Packer holes | Sheet 01 |

(a) Drill and ream the fastener holes of the packers, Items (35) and (37) to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBHAB Sheet 01.

**(32) Subtask 571208-320-409-010 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAJ<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 RH at STGR 4 and STGR 5 positions, do the procedure that follows:

1

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

Temporarily clamp in position, the Cleats to the STGR's close to the two open holes in the STGR's, refer to Fig. A-UBDAJ Sheet 01, Views A, B and C.

2 Drill and ream the fastener holes to final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, Views H, J, K and L and Fig. A-UBDAJ Sheet 04 fastener table.

NOTE: Do not remove the clamps at this stage.

(b)

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

At Rib 5 RH at STGR 6 thru 12 and 15 thru 16, drill and ream the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, Views M, N, P and Q and Fig. A-UBDAJ Sheet 04 fastener table.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(33) Subtask 571208-250-409-010 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAJ<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAJ Sheet 01, Fig. A-UBDAJ Sheet 02, Fig. A-UBDAJ Sheet 03 and Fig. A-UBDAJ Sheet 04, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(34) Subtask 571208-831-408-010 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B16R04 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 3 | D5725655721000 | 1 | SEALANT | |
| 4 | D5725655721200 | 1 | SEALANT | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 13 | BOLT | |
| 8 | EN6115V4Y7 | 5 | BOLT | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 10 | EN6114V4Y17 | 1 | BOLT CSK | |
| 11 | EN6114V4Y18 | 1 | BOLT CSK | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |
| 17 | EN6115V4-3 | 2 | BOLT | |
| 18 | EN6115V3-4 | 4 | BOLT | |
| 19 | EN6115V3-5 | 4 | BOLT | |
| 22 | D5725655721400 | 1 | SEALANT | |
| 24 | ASNA2531-5 | 3 | NUT | |
| 27 | ASNA2531-3 | 8 | NUT | |

NOTE: Kit B16 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |
| | Polysulfide Sealant-Low Density Multi Purpose Bru | 06ACA1 | As required | |
| | Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required | |
| | Non Aqueous Cleaner - General | 08BAA9 | As required | |
| | Textile - Lint Free Cotton | 14SBA1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAJ<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02<br>Sheet 03<br>Sheet 04 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 RH at STGR 4 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, Views H and K and Fig. A-UBDAJ Sheet 04, Section A-A and fastener table, install the Metallic Packer, Item (35) as follows:

1 Clean the Metallic Packer, Item (35) with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (35):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 10 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 7.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 4 | D5725660920100 | Item (35) | Retained at removal |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6114V4Y17 | Item 10 |
| 1 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Nut | ASNA2531-4 | Item 15 |
| 4 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 5 RH at STGR 4 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, Views H and K and Fig. A-UBDAJ Sheet 04, section A-A and fastener table, install the Foam Carrier, Item (2) Foam Sealants, Item 3 and Item 4 as follows:

1 Clean the Foam Carrier, Item (2) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealants, Item 3 and Item 4, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)
- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealants, Item 3 and Item 4 into the Foam Carrier, Item (2).

7 Apply to the mating surfaces of the Foam Carrier, Item (2):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (2) and Foam Sealants, Item 3 and Item 4 in position at Rib 5 RH at STGR 4 with a suitable tool to guide the foam into position on assembly.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

9 Make sure the Foam Sealants, Item 3 and Item 4 are not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 4 | D5725655200100 | Item (2) | Retained at removal |
| 1 | Foam Sealant | D5725655721000 | Item 3 | |
| 1 | Foam Sealant | D5725655721200 | Item 4 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4-3 | Item 17 |
| 2 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-5 | Item 19 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 4 | Nut | ASNA2531-3 | Item 27 |
| 1 | Nut | ASNA2531-5 | Item 24 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut, Item 15 if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

11 Remove any excess sealant from the edges of the Foam Carrier, Item (2) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

13 Apply a fillet seal to the edges of the Foam Carrier, Item (2), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(c) At Rib 5 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, Views J and L and Fig. A-UBDAJ Sheet 04, section B-B and fastener table, install the Metallic Packer, Item (37) as follows:

1 Clean the Metallic Packer, Item (37) with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (37):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 5 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 8.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725661020100 | Item (37) | Retained at removal |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6114V4Y18 | Item 11 |
| 1 | Bolt | EN6115V4Y7 | Item 8 |
| 2 | Nut | ASNA2531-4 | Item 15 |
| 4 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(d) At Rib 5 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03, Views J and L and Fig. A-UBDAJ Sheet 04, section B-B and fastener table, install the Foam Carrier, Item (21) and Foam Sealant, Item 22 as follows:

1 Clean the Foam Carrier, Item (21) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealant, Item 22, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)
- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealant, Item 22 into the Foam Carrier, Item (21).

7 Apply to the mating surfaces of the Foam Carrier, Item (21):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (21) and Foam Sealant, Item 22 in position at Rib 5 RH at STGR 5 with a suitable tool to guide the foam into position on assembly.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

9 Make sure the Foam Sealant, Item 22 is not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 5 | D5725655300100 | Item (21) | Retained at removal |
| 1 | Foam Sealant | D5725655721400 | Item 22 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4-3 | Item 17 |
| 2 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-5 | Item 19 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 2 | Washer | NSA5372-416B | Item 16 |
| 4 | Nut | ASNA2531-3 | Item 27 |
| 2 | Nut | ASNA2531-5 | Item 24 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

11 Remove any excess sealant from the edges of the Foam Carrier, Item (21) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

13 Apply a fillet seal to the edges of the Foam Carrier, Item (21), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(e) At Rib 5 RH at STGR 6 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03 and Fig. A-UBDAJ Sheet 04, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 18 | Nut | ASNA2531-4 | Item 15 |
| 36 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(f) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAJ Sheet 01, View A, Fig. A-UBDAJ Sheet 03 and Fig. A-UBDAJ Sheet 04, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(35) Subtask 571208-020-408-010 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAJ<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAJ Sheet 01, remove:

| | | | | |
|---|---|---|---|---|
| 7 | Fastener | | | Discard |
| 1 | Foam Carrier STGR 5 | D5725655100000 | Item (40) | Retain |
| 1 | Foam Sealant STGR 5 | D5725655720000 | Item (12) | Discard |
| 1 | Packer STGR 5 | D5725660820000 | Item (38) | Retain |
| 1 | Nut | | Item (23) | Discard |

(b) At Rib 6 LH at STGRs 6 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAJ Sheet 01, remove:

| | | |
|---|---|---|
| 18 | Fastener | Discard |

**(36) Subtask 571208-320-412-004 - Oversize the Fastener Holes of the Metallic Packer Rib 6 LH (On Bench)**

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 1 |
| Subtask elapsed time | 0.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBHAB<br>Enlargement of the Metallic Packer holes | Sheet 01 |

(a) Drill and ream the fastener holes of the packer, Item (38) to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBHAB Sheet 01.

**(37) Subtask 571208-320-414-010 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAJ<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 LH at STGR 5 position, do the procedure that follows:

1

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

Temporarily clamp in position, the Cleat to the STGR close to the two open holes in the STGR, refer to Fig. A-UBEAJ Sheet 01, Views A and B.

2 Drill and ream all the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02, Views F and G and Fig. A-UBEAJ Sheet 03 fastener table.

NOTE: Do not remove the clamps at this stage.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b)

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

At Rib 6 LH at STGR 6 thru 12 and 15 thru 16. drill and ream the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02, Views H and J and Fig. A-UBEAJ Sheet 03, Views K and L and fastener table.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(38) Subtask 571208-250-410-010 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAJ<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAJ Sheet 01, Fig. A-UBEAJ Sheet 02 and Fig. A-UBEAJ Sheet 03, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

- If no damage is found, do the worksteps that follow.

**(39) Subtask 571208-831-409-010 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

Material necessary to do the job

| Kit 571208B25R03 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 5 | EN6114V3A16 | 1 | BOLT CSK | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 9 | EN6115V4Y8 | 5 | BOLT | |
| 12 | D5725655720000 | 1 | SEALANT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |
| 18 | EN6115V3-4 | 1 | BOLT | |
| 24 | ASNA2531-5 | 1 | NUT | |
| 25 | EN6115V3-6 | 2 | BOLT | |
| 26 | EN6115V3-8 | 2 | BOLT | |
| 27 | ASNA2531-3 | 5 | NUT | |

NOTE: Kit B25 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Polysulfide Sealant-Low Density Multi Purpose Bru | 06ACA1 | As required | |
| | Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required | |
| | Non Aqueous Cleaner - General | 08BAA9 | As required | |
| | Textile - Lint Free Cotton | 14SBA1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAJ<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02, View F and G and Fig. A-UBEAJ Sheet 03, section A-A and fastener table, install the Metallic Packer, Item (38) as follows:

1 Clean the Metallic Packer, Item (38) with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (38):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 5 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 8.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725660820000 | Item (38) | Retained at removal |

with:



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |
| 1 | Bolt | EN6115V4Y8 | Item 9 |
| 1 | Bolt | EN6114V3A16 | Item 5 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under nut, Item 15 if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02, View F and G and Fig. A-UBEAJ Sheet 03, section A-A and fastener table, install the Foam Carrier, Item (40) and Foam Sealant, Item 12 as follows:

1 Clean the Foam Carrier, Item (40) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Soak the Foam Sealant, Item 12, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)

- The calculated mass can be used as a quality control measure to ensure adequate fill.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealant, Item 12 into the Foam Carrier, Item (40).

7 Apply to the mating surfaces of the Foam Carrier, Item (40):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (40) and Foam Sealant, Item 12 in position at Rib 6 LH at STGR 5 with a suitable tool to guide the foam into position on assembly.

9 Make sure the Foam Sealant, Item 12 is not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

with:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 5 | D5725655100000 | Item (40) | Retained at removal |
| 1 | Foam Sealant | D5725655720000 | Item 12 | |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-6 | Item 25 |
| 2 | Bolt | EN6115V3-8 | Item 26 |
| 1 | Nut | ASNA2531-5 | Item 24 |
| 5 | Nut | ASNA2531-3 | Item 27 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

11 Remove any excess sealant from the edges of the Foam Carrier, Item (40) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

13 Apply a fillet seal to the edges of the Foam Carrier, Item (40), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(c) At Rib 6 LH at STGRs 6 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02 and Fig. A-UBEAJ Sheet 03, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 18 | Nut | ASNA2531-4 | Item 15 |
| 36 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(d) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02 and Fig. A-UBEAJ Sheet 03, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(40) Subtask 571208-020-409-010 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAJ<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAJ Sheet 01, remove:

| | | | | |
|---|---|---|---|---|
| 7 | Fastener | | | Discard |
| 1 | Foam Carrier STGR 5 | D5725655100100 | Item (41) | Retain |
| 1 | Foam Sealant STGR 5 | D5725655720000 | Item (12) | Discard |
| 1 | Nut | | Item (23) | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725660820100 | Item (39) | Retain |

(b) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAJ Sheet 01, remove:

| | | |
|---|---|---|
| 18 | Fastener | Discard |

**(41) Subtask 571208-320-413-003 - Oversize the Fastener Holes of the Metallic Packer Rib 6 RH (On Bench)**

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 1 |
| Subtask elapsed time | 0.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBHAB<br>Enlargement of the Metallic Packer holes | Sheet 01 |

(a) Drill and ream the fastener holes of the packer, Item (39) to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBHAB Sheet 01.

**(42) Subtask 571208-320-415-010 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAJ<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 RH at STGR 5 position, do the procedure that follows:

1



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

Temporarily clamp in position, the Cleat to the STGR close to the two open holes in the STGR, refer Fig. A-UBEAJ Sheet 01, Views A and B.

2 Drill and ream all the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02, Views F and G and Fig. A-UBEAJ Sheet 03 fastener table.

NOTE: Do not remove the clamps at this stage.

(b)

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

At Rib 6 RH at STGRS 6 thru 12 and 15 thu 16, drill and ream the fastener holes to the final diameter in accordance with SRM 51-44-11 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02, Views H and J and Fig. A-UBEAJ Sheet 03, Views K and L and fastener table.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(43) Subtask 571208-250-411-010 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAJ<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAJ Sheet 01, Fig. A-UBEAJ Sheet 02 and Fig. A-UBEAJ Sheet 03, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(44) Subtask 571208-831-410-010 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B25R03 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 5 | EN6114V3A16 | 1 | BOLT CSK | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 8 | EN6115V4Y7 | 1 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 12 | D5725655720000 | 1 | SEALANT | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
|---|---|---|---|---|
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |
| 18 | EN6115V3-4 | 1 | BOLT | |
| 24 | ASNA2531-5 | 2 | NUT | |
| 25 | EN6115V3-6 | 2 | BOLT | |
| 26 | EN6115V3-8 | 2 | BOLT | |
| 27 | ASNA2531-3 | 5 | NUT | |

NOTE: Kit B25 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |
| | Polysulfide Sealant-Low Density Multi Purpose Bru | 06ACA1 | As required | |
| | Adhesion Promoter-For Polysulfide Sealant | 06PAG1 | As required | |
| | Non Aqueous Cleaner - General | 08BAA9 | As required | |
| | Textile - Lint Free Cotton | 14SBA1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAJ<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02<br>Sheet 03 |

(a) At Rib 6 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02, View F and G and Fig. A-UBEAJ Sheet 03, section A-A and fastener table, install the Metallic Packer, Item (39) as follows:

1 Clean the Metallic Packer, Item (39) with a non-metallic scraper and:

Textile - Lint Free Cotton 14SBA1 As required

made moist with



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

2 Apply to the mating surfaces of the Metallic Packer, Item (39):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

3

CAUTION: REMOVE ONLY THE CLAMP ADJACENT TO BOLT, ITEM 5 AND FULLY INSTALL THIS FASTENER FIRST. THEN REMOVE THE CLAMP THAT REMAINS AND INSTALL BOLT, ITEM 8.

Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Packer STGR 5 | D5725660820100 | Item (39) | Retained at removal |

with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V4Y7 | Item 8 |
| 1 | Bolt | EN6114V3A16 | Item 5 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 1 | Nut | ASNA2531-4 | Item 15 |
| 2 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under nut, Item 15 if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02, View F and G and Fig. A-UBEAJ Sheet 03, section A-A and fastener table, install the Foam Carrier, Item (41) and Foam Sealant, Item 12 as follows:

1 Clean the Foam Carrier, Item (41) and Rib with a non-metallic scraper and:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

2 Soak the Foam Sealant, Item 12, with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

Use compression to make sure of an even distribution of sealant throughout the foam matrix.

3 Make sure enough sealant is applied to get a minimum of 70% fill. This can be calculated as follows:

- Foam component volume (cm3) x Chosen sealant density (g/cm3) x 0.7 = Sealant mass required to fill to 70% (g)

- The calculated mass can be used as a quality control measure to ensure adequate fill.

4 Apply adhesion promoter to the carrier and the metallic packer, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

5 Prime the carrier and the metallic packer with a thin layer of sealant, use:

| | | |
|---|---|---|
| Polysulfide Sealant- Low Density Multi Purpose Bru | 06ACA1 | As required |

6 Install the Foam Sealant, Item 12 into the Foam Carrier, Item (41).

7 Apply to the mating surfaces of the Foam Carrier, Item (41):

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

8 Put the Foam Carrier, Item (41) and Foam Sealant, Item 12 in position at Rib 6 RH at STGR 5 with a suitable tool to guide the foam into position on assembly.

9 Make sure the Foam Sealant, Item 12 is not creased or distorted and not caught on any surrounding structure, otherwise remove the carrier and relocate the foam.

10 Wet install:

| | | | | |
|---|---|---|---|---|
| 1 | Foam Carrier STGR 5 | D5725655100100 | Item (41) | Retained at removal |
| 1 | Foam Sealant | D5725655720000 | Item 12 | |

with:



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |
| 1 | Bolt | EN6115V3-4 | Item 18 |
| 2 | Bolt | EN6115V3-6 | Item 25 |
| 2 | Bolt | EN6115V3-8 | Item 26 |
| 2 | Nut | ASNA2531-5 | Item 24 |
| 5 | Nut | ASNA2531-3 | Item 27 |

11 Remove any excess sealant from the edges of the Foam Carrier, Item (41) and clean with:

| | | |
|---|---|---|
| Textile - Lint Free Cotton | 14SBA1 | As required |

made moist with

| | | |
|---|---|---|
| Non Aqueous Cleaner - General | 08BAA9 | As required |

12 Apply adhesion promoter to the carrier edges for a fillet seal, use:

| | | |
|---|---|---|
| Adhesion Promoter- For Polysulfide Sealant | 06PAG1 | As required |

13 Apply a fillet seal to the edges of the Foam Carrier, Item (41), with:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

(c) At Rib 6 RH at STGRs 6 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02 and Fig. A-UBEAJ Sheet 03, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 18 | Nut | ASNA2531-4 | Item 15 |
| 36 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(d) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAJ Sheet 01, View A, Fig. A-UBEAJ Sheet 02 and Fig. A-UBEAJ Sheet 03, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(45) Subtask 571208-020-410-004 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 6B LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBFAC Sheet 01, remove:

| | | |
|---|---|---|
| 2 | Fastener | Discard |

**(46) Subtask 571208-320-419-004 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 LH at STGR 5 in accordance with SRM 51-44-11 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(47) Subtask 571208-250-412-004 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B LH at STGR 5 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(48) Subtask 571208-831-411-005 - Install the Fasteners of the Cleat to Stringer Webs RIB 6B LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B28R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 3 | EN6115V3A6 | 2 | BOLT | |
| 14 | ASNA2531-3A | 2 | NUT HEX | |

NOTE: Kit B28 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) If the foam seals on the dry bay cleats are found damaged contact AIRBUS.

(b) At Rib 6B LH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V3A6 | Item 3 |
| 2 | Nut | ASNA2531-3A | Item 14 |

(c) At Rib 6B LH at STGR 5 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(49) Subtask 571208-020-411-004 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6B RH at STGR 5 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBFAC Sheet 01, remove:

| | | |
|---|---|---|
| 2 | Fastener | Discard |

**(50) Subtask 571208-320-418-004 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6B RH at STGR 5 in accordance with SRM 51-44-11 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(51) Subtask 571208-250-413-004 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |

(a) At Rib 6B RH at STGR 5 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

- If no damage is found, do the worksteps that follow.

**(52) Subtask 571208-831-412-004 - Install the Fasteners of the Cleat to Stringer Webs RIB 6B RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6B<br>Stringer 5 |

| Manpower Resources | |
|---|---|
| Manhours | 0.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B28R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 3 | EN6115V3A6 | 2 | BOLT | |
| 14 | ASNA2531-3A | 2 | NUT HEX | |

NOTE: Kit B28 contains sufficient parts to accomplish this Service Bulletin on Rib 6B LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBFAC<br>Modification of the Cleat to Stringer Webs RIB 6B | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 6B RH at STGR 5 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 2 | Bolt | EN6115V3A6 | Item 3 |
| 2 | Nut | ASNA2531-3A | Item 14 |

(b) At Rib 6B RH at STGR 5 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBFAC Sheet 01 and Fig. A-UBFAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(53) Subtask 571208-020-412-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(54) Subtask 571208-320-417-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(55) Subtask 571208-250-414-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(56) Subtask 571208-831-413-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B31R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 16 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B31 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 16 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(57) Subtask 571208-020-413-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(58) Subtask 571208-320-416-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(59) Subtask 571208-250-415-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(60) Subtask 571208-831-414-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B31R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 16 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B31 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 16 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(61) Subtask 571208-960-401-001 - Replace the LP Fuel Filters**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 400 | |

| Manpower Resources | |
|---|---|
| Manhours | 1.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.50 |
| Skills | ENGINE |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 73-11-10-920-001<br>Task 73-12-42-920-010 |

(a) Replace the LP fuel filter elements at Engine 1 (1000EM1), Engine 2 (1000EM2):

- if CFM engines are installed, refer to AMM Task 73-11-10-920-001.
- if IAE engines are installed, refer to AMM Task 73-12-42-920-010.

****CONF 016**

**(1) Subtask 571208-020-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(2) Subtask 571208-320-401-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(3) Subtask 571208-250-402-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(4) Subtask 571208-831-401-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(5) Subtask 571208-000-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(6) Subtask 571208-320-403-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(7) Subtask 571208-250-403-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(8) Subtask 571208-831-402-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(9) Subtask 571208-020-402-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(10) Subtask 571208-320-404-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(11) Subtask 571208-250-404-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(12) Subtask 571208-831-403-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B04R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B04 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(13) Subtask 571208-020-403-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(14) Subtask 571208-320-405-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(15) Subtask 571208-250-405-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(16) Subtask 571208-831-404-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B04R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B04 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAB<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAB Sheet 01 and Fig. A-UBBAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(17) Subtask 571208-020-404-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(18) Subtask 571208-320-410-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(19) Subtask 571208-250-406-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(20) Subtask 571208-831-405-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12 install the fasteners from the AFT side of the stringer to make sure that there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(21) Subtask 571208-020-405-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(22) Subtask 571208-320-407-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(23) Subtask 571208-250-407-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(24) Subtask 571208-831-406-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(25) Subtask 571208-020-406-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAB<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAB Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(26) Subtask 571208-320-408-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAB<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAB Sheet 01 and Fig. A-UBDAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(27) Subtask 571208-250-408-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAB<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAB Sheet 01 and Fig. A-UBDAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(28) Subtask 571208-831-407-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B09R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 6 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B09 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAB<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAB Sheet 01 and Fig. A-UBDAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 6 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAB Sheet 01 and Fig. A-UBDAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(29) Subtask 571208-020-407-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAB<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIME SAND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAB Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(30) Subtask 571208-320-409-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAB<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAB Sheet 01 and Fig. A-UBDAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(31) Subtask 571208-250-409-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBDAB<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAB Sheet 01 and Fig. A-UBDAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(32) Subtask 571208-831-408-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B09R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 6 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B09 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAB<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAB Sheet 01 and Fig. A-UBDAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 6 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAB Sheet 01 and Fig. A-UBDAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(33) Subtask 571208-020-408-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAB<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(34) Subtask 571208-320-414-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAB<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBEAB Sheet 01 and Fig. A-UBEAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(35) Subtask 571208-250-410-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAB<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAB Sheet 01 and Fig. A-UBEAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(36) Subtask 571208-831-409-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B18R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 2 | EN6115V3A5 | 1 | BOLT | |
| 6 | EN6115V4Y5 | 3 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |

NOTE: Kit B18 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAB<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAB Sheet 01 and Fig. A-UBEAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3A5 | Item 2 |
| 3 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 19 | Nut | ASNA2531-4 | Item 15 |
| 38 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAB Sheet 01 and Fig. A-UBEAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(37) Subtask 571208-020-409-002 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAB<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(38) Subtask 571208-320-415-002 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAB<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBEAB Sheet 01 and Fig. A-UBEAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(39) Subtask 571208-250-411-002 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAB<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAB Sheet 01 and Fig. A-UBEAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(40) Subtask 571208-831-410-002 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B18R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 2 | EN6115V3A5 | 1 | BOLT | |
| 6 | EN6115V4Y5 | 3 | BOLT | |
| 7 | EN6115V4Y6 | 12 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |

NOTE: Kit B18 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAB<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAB Sheet 01 and Fig. A-UBEAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3A5 | Item 2 |
| 3 | Bolt | EN6115V4Y5 | Item 6 |
| 12 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 19 | Nut | ASNA2531-4 | Item 15 |
| 38 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAB Sheet 01 and Fig. A-UBEAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(41) Subtask 571208-020-412-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(42) Subtask 571208-320-417-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(43) Subtask 571208-250-414-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(44) Subtask 571208-831-413-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B30R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 18 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B30 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 18 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(45) Subtask 571208-020-413-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAB Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(46) Subtask 571208-320-416-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(47) Subtask 571208-250-415-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(48) Subtask 571208-831-414-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B30R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 18 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B30 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAB<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 18 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAB Sheet 01 and Fig. A-UBGAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(49) Subtask 571208-960-401-001 - Replace the LP Fuel Filters**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 400 | |

| Manpower Resources | |
|---|---|
| Manhours | 1.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.50 |
| Skills | ENGINE |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 73-11-10-920-001<br>Task 73-12-42-920-010 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) Replace the LP fuel filter elements at Engine 1 (1000EM1), Engine 2 (1000EM2):

- if CFM engines are installed, refer to AMM Task 73-11-10-920-001.
- if IAE engines are installed, refer to AMM Task 73-12-42-920-010.

**CONF 017

**(1) Subtask 571208-020-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(2) Subtask 571208-320-401-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(3) Subtask 571208-250-402-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(4) Subtask 571208-831-401-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 LH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(5) Subtask 571208-000-401-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBAAB Sheet 01, remove:

| | | |
|---|---|---|
| 28 | Fasteners | Discard |

**(6) Subtask 571208-320-403-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-44-11 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(7) Subtask 571208-250-403-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(8) Subtask 571208-831-402-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 2 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 2<br>from Stringer 2 to Stringer 12<br>from Stringer 15 to Stringer 17 |

| Manpower Resources | |
|---|---|
| Manhours | 3.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.50 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B02R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 26 | BOLT | |
| 8 | EN6115V4Y7 | 2 | BOLT | |
| 15 | ASNA2531-4 | 28 | NUT HEX | |
| 16 | NSA5372-416B | 56 | WASHER | |

NOTE: Kit B02 contains sufficient parts to accomplish this Service Bulletin on Rib 2 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBAAB<br>Modification of the Cleat to Stringer Webs RIB 2 | Sheet 01<br>Sheet 02 |

(a) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 26 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y7 | Item 8 |
| 28 | Nut | ASNA2531-4 | Item 15 |
| 56 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 2 RH between STGRs 2 thru 12 and STGRs 15 thru 17 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBAAB Sheet 01 and Fig. A-UBAAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(9) Subtask 571208-020-402-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAC Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(10) Subtask 571208-320-404-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(11) Subtask 571208-250-404-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(12) Subtask 571208-831-403-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B05R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 22 | BOLT | |
| 9 | EN6115V4Y8 | 2 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B05 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 22 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y8 | Item 9 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(13) Subtask 571208-020-403-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBBAC Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(14) Subtask 571208-320-405-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT EXCEPT STGR 14, WHICH IS FROM AFT TO FWD) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(15) Subtask 571208-250-405-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(16) Subtask 571208-831-404-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 3 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 3<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B05R02 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 22 | BOLT | |
| 9 | EN6115V4Y8 | 2 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B05 contains sufficient parts to accomplish this Service Bulletin on Rib 3 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBBAC<br>Modification of the Cleat to Stringer Webs RIB 3 | Sheet 01<br>Sheet 02 |

(a) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, use:

| | | |
|---|---|---|
| Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required |

to wet install:

| | | | |
|---|---|---|---|
| 22 | Bolt | EN6115V4Y6 | Item 7 |
| 2 | Bolt | EN6115V4Y8 | Item 9 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| | | | |
|---|---|---|---|
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 3 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBBAC Sheet 01 and Fig. A-UBBAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(17) Subtask 571208-020-404-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |

**(18) Subtask 571208-320-410-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(19) Subtask 571208-250-406-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(20) Subtask 571208-831-405-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12 install the fasteners from the AFT side of the stringer to make sure that there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 LH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(21) Subtask 571208-020-405-001 - Remove the Fasteners from the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBCAB Sheet 01, remove:

| | | |
|---|---|---|
| 24 | Fasteners | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(22) Subtask 571208-320-407-001 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(23) Subtask 571208-250-407-001 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(24) Subtask 571208-831-406-001 - Install the Fasteners of the Cleat to Stringer Webs RIB 4 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 4<br>from Stringer 3 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B07R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 20 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 24 | NUT HEX | |
| 16 | NSA5372-416B | 48 | WASHER | |

NOTE: Kit B07 contains sufficient parts to accomplish this Service Bulletin on Rib 4 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBCAB<br>Modification of the Cleat to Stringer Webs RIB 4 | Sheet 01<br>Sheet 02 |

(a) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 20 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 24 | Nut | ASNA2531-4 | Item 15 |
| 48 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 4 RH between STGRs 3 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBCAB Sheet 01 and Fig. A-UBCAB Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(25) Subtask 571208-020-406-008 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAF<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to , remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(26) Subtask 571208-320-408-007 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAF<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAF Sheet 01 and Fig. A-UBDAF Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(27) Subtask 571208-250-408-007 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBDAF<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAF Sheet 01 and Fig. A-UBDAF Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(28) Subtask 571208-831-407-007 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B13R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 4 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B13 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAF<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAF Sheet 01 and Fig. A-UBDAF Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 4 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 LH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAF Sheet 01 and Fig. A-UBDAF Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(29) Subtask 571208-020-407-007 - Remove the Fasteners from the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBDAF<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBDAF Sheet 01, remove:

| | | |
|---|---|---|
| 22 | Fasteners | Discard |

**(30) Subtask 571208-320-409-007 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBDAF<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBDAF Sheet 01 and Fig. A-UBDAF Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(31) Subtask 571208-250-409-007 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBDAF<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBDAF Sheet 01 and Fig. A-UBDAF Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(32) Subtask 571208-831-408-007 - Install the Fasteners of the Cleat to Stringer Webs RIB 5 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 5<br>from Stringer 4 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B13R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 6 | EN6115V4Y5 | 4 | BOLT | |
| 7 | EN6115V4Y6 | 14 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 22 | NUT HEX | |
| 16 | NSA5372-416B | 44 | WASHER | |

NOTE: Kit B13 contains sufficient parts to accomplish this Service Bulletin on Rib 5 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
|---|---|---|---|---|
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBDAF<br>Modification of the Cleat to Stringer Webs RIB 5 | Sheet 01<br>Sheet 02 |

(a) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBDAF Sheet 01 and Fig. A-UBDAF Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 4 | Bolt | EN6115V4Y5 | Item 6 |
| 14 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 22 | Nut | ASNA2531-4 | Item 15 |
| 44 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 5 RH at STGR 4 thru 12 and STGR 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBDAF Sheet 01 and Fig. A-UBDAF Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(33) Subtask 571208-020-408-007 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAF<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAF Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(34) Subtask 571208-320-414-007 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAF<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBEAF Sheet 01 and Fig. A-UBEAF Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(35) Subtask 571208-250-410-007 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBEAF<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBEAF Sheet 01 and Fig. A-UBEAF Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.
- If no damage is found, do the worksteps that follow.

**(36) Subtask 571208-831-409-007 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B22R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 3 | EN6115V3A6 | 1 | BOLT | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 13 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |

NOTE: Kit B22 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAF<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAF Sheet 01 and Fig. A-UBEAF Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3A6 | Item 3 |
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 13 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 19 | Nut | ASNA2531-4 | Item 15 |
| 38 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 6 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAF Sheet 01 and Fig. A-UBEAF Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(37) Subtask 571208-020-409-007 - Remove the Fasteners from the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBEAF<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBEAF Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(38) Subtask 571208-320-415-007 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBEAF<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-44-11 and refer to Fig. A-UBEAF Sheet 01 and Fig. A-UBEAF Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(39) Subtask 571208-250-411-008 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBEAF<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with NTM Task 51-10-01-250-801 and refer to and , do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(40) Subtask 571208-831-410-007 - Install the Fasteners of the Cleat to Stringer Webs RIB 6 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 6<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.00 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B22R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 3 | EN6115V3A6 | 1 | BOLT | |
| 6 | EN6115V4Y5 | 2 | BOLT | |
| 7 | EN6115V4Y6 | 13 | BOLT | |
| 9 | EN6115V4Y8 | 4 | BOLT | |
| 14 | ASNA2531-3A | 1 | NUT HEX | |
| 15 | ASNA2531-4 | 19 | NUT HEX | |
| 16 | NSA5372-416B | 38 | WASHER | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

NOTE: Kit B22 contains sufficient parts to accomplish this Service Bulletin on Rib 6 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBEAF<br>Modification of the Cleat to Stringer Webs RIB 6 | Sheet 01<br>Sheet 02 |

(a) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBEAF Sheet 01 and Fig. A-UBEAF Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9, 10 and 12, install the fasteners from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 1 | Bolt | EN6115V3A6 | Item 3 |
| 2 | Bolt | EN6115V4Y5 | Item 6 |
| 13 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y8 | Item 9 |
| 1 | Nut | ASNA2531-3A | Item 14 |
| 19 | Nut | ASNA2531-4 | Item 15 |
| 38 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) At Rib 6 RH at STGRs 5 thru 12 and STGRs 15 thru 16 in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBEAF Sheet 01 and Fig. A-UBEAF Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

| | | |
|---|---|---|
| Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required |

**(41) Subtask 571208-020-412-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(42) Subtask 571208-320-417-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(43) Subtask 571208-250-414-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(44) Subtask 571208-831-413-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 LH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 570 | Access | Panel 540AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B31R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 16 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B31 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

| | | | |
|---|---|---|---|
| 16 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 LH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**(45) Subtask 571208-020-413-003 - Remove the Fasteners from the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-42-00<br>51-42-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: CLAMP THE CLEAT TO THE STRINGER WEB BEFORE FASTENER REMOVAL, MAKE SURE THAT ONE FASTENER REMAINS INSTALLED THROUGH THE STGR AT ALL TIMES AND KEEP THE JOINT CLAMPED DURING OVERSIZE DRILLING OPERATIONS, TO MAKE SURE OF JOINT INTEGRITY.

CAUTION: MAKE SURE THAT ALL DEBRIS / F.O.D. IS REMOVED FROM THE FUEL TANK.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11 and refer to Fig. A-UBGAC Sheet 01, remove:

| | | |
|---|---|---|
| 20 | Fastener | Discard |

**(46) Subtask 571208-320-416-003 - Oversize the Fastener positions in the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-44-11 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

CAUTION: AS WELL AS CLAMPING, MAKE SURE THAT ONE FASTENER IS FULLY INSTALLED IN THE CLEAT AT ALL TIMES.

CAUTION: DRILL FROM THE CLEAT THROUGH THE STRINGER (FROM FWD TO AFT) AT EACH FASTENER POSITION TO PREVENT BURRS ON THE STRINGER THAT YOU CANNOT ACCESS ON THE STRINGER CLEAT INTERFACE.

NOTE: BURRS ON THE INACCESSIBLE FACE OF THE CLEAT ARE ACCEPTABLE.

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-44-11 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02 fastener table, drill the holes of the removed fasteners.

NOTE: Make sure that the under head radius is cut adjacent to the fastener head.

**(47) Subtask 571208-250-415-003 - Do an Eddy Current Inspection of the Fastener Positions of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | NON DESTRUCTIVE TESTING |

| References | |
|---|---|
| Non Destructive Test Manual (NTM) | Task 51-10-01-250-801 |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with NTM Task 51-10-01-250-801 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, do a HFEC inspection of the holes of the removed fasteners.

- If damage is found contact AIRBUS.

- If no damage is found, do the worksteps that follow.

**(48) Subtask 571208-831-414-003 - Install the Fasteners of the Cleat to Stringer Webs RIB 7 RH**

| Work Zones and Access Panels | | | |
|---|---|---|---|
| | Zone | Access/Work location | |
| | 670 | Access | Panel 640AB |
| | | Work location | Rib 7<br>from Stringer 5 to Stringer 12<br>from Stringer 15 to Stringer 16 |

| Manpower Resources | |
|---|---|
| Manhours | 2.50 |
| Minimum number of person | 2 |
| Subtask elapsed time | 1.25 |
| Skills | AIRFRAME |

| Material necessary to do the job |
|---|

| Kit 571208B31R01 | | | | |
|---|---|---|---|---|
| ITEM | NEW PART N° | QTY (UM) | KEYWORD | SEE NOTES |
| 7 | EN6115V4Y6 | 16 | BOLT | |
| 8 | EN6115V4Y7 | 4 | BOLT | |
| 15 | ASNA2531-4 | 20 | NUT HEX | |
| 16 | NSA5372-416B | 40 | WASHER | |

NOTE: Kit B31 contains sufficient parts to accomplish this Service Bulletin on Rib 7 LH and RH wings.

| Consumable CMLB01 | | | | |
|---|---|---|---|---|
| ITEM | DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | SEE NOTES |
| | Primer Epoxy Paint - Corrosion Inhibiting Structure | 04DAB2 | As required | |
| | Polysulfide Sealant - Fuel Tank Fillet | 06ABB1 | As required | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Structural Repair Manual (SRM) | 51-23-11<br>51-23-12<br>51-42-00<br>51-42-11<br>51-76-12 |
| Fig. A-UBGAC<br>Modification of the Cleat to Stringer Webs RIB 7 | Sheet 01<br>Sheet 02 |

(a) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-42-00, SRM 51-42-11, SRM 51-76-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, use:

Polysulfide Sealant - Fuel Tank Fillet 06ABB1 As required

to wet install:

NOTE: At STGRs 9 thru 12 install the fasteners, Item 7, from the AFT side of the stringer to make sure there is clearance with existing electrical conduits.

| | | | |
|---|---|---|---|
| 16 | Bolt | EN6115V4Y6 | Item 7 |
| 4 | Bolt | EN6115V4Y7 | Item 8 |
| 20 | Nut | ASNA2531-4 | Item 15 |
| 40 | Washer | NSA5372-416B | Item 16 |

NOTE: A maximum of 2 Washers, Item 16 to be installed under each nut if necessary. Washers may be installed for correct fastener grip length in accordance with SRM Chapter 51.

(b) At Rib 7 RH at STGRs 5 thru 12 and STGRs 15 thru 16 and in accordance with SRM 51-23-11, SRM 51-23-12 and refer to Fig. A-UBGAC Sheet 01 and Fig. A-UBGAC Sheet 02, to the heads, washers and cadmium plated steel nuts of all the installed fasteners, apply:

Primer Epoxy Paint - Corrosion Inhibiting Structure 04DAB2 As required

**(49) Subtask 571208-960-401-001 - Replace the LP Fuel Filters**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 400 | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Manhours | 1.00 |
| Minimum number of person | 2 |
| Subtask elapsed time | 0.50 |
| Skills | ENGINE |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 73-11-10-920-001<br>Task 73-12-42-920-010 |

(a) Replace the LP fuel filter elements at Engine 1 (1000EM1), Engine 2 (1000EM2):

- if CFM engines are installed, refer to AMM Task 73-11-10-920-001.
- if IAE engines are installed, refer to AMM Task 73-12-42-920-010.

****CONF ALL**

**D. TEST**

NOTE: The listed subtasks are not in sequence with the work steps. The operator can change the sequence.

****CONF 001**

**(1) Subtask 571208-720-401-001 - Test**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 28-11-00-790-008 |

(a) Do a fuel leak test, refer to AMM Task 28-11-00-790-008.

NOTE: Check the manhole access panels you have installed for leaks. Make sure there are no leaks.

****CONF 002**

**(1) Subtask 571208-720-401-001 - Test**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 28-11-00-790-008 |

(a) Do a fuel leak test, refer to AMM Task 28-11-00-790-008.

NOTE: Check the manhole access panels you have installed for leaks. Make sure there are no leaks.

**CONF 003

**(1) Subtask 571208-720-401-001 - Test**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 28-11-00-790-008 |

(a) Do a fuel leak test, refer to AMM Task 28-11-00-790-008.

NOTE: Check the manhole access panels you have installed for leaks. Make sure there are no leaks.

**CONF 004

**(1) Subtask 571208-720-401-001 - Test**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 28-11-00-790-008 |

(a) Do a fuel leak test, refer to AMM Task 28-11-00-790-008.

NOTE: Check the manhole access panels you have installed for leaks. Make sure there are no leaks.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 005

(1) **Subtask 571208-720-401-001 - Test**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 28-11-00-790-008 |

(a) Do a fuel leak test, refer to AMM Task 28-11-00-790-008.

NOTE: Check the manhole access panels you have installed for leaks. Make sure there are no leaks.

**CONF 006

(1) **Subtask 571208-720-401-001 - Test**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 28-11-00-790-008 |

(a) Do a fuel leak test, refer to AMM Task 28-11-00-790-008.

NOTE: Check the manhole access panels you have installed for leaks. Make sure there are no leaks.

**CONF 007

(1) **Subtask 571208-720-401-001 - Test**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 28-11-00-790-008 |

(a) Do a fuel leak test, refer to AMM Task 28-11-00-790-008.

NOTE: Check the manhole access panels you have installed for leaks. Make sure there are no leaks.

**CONF 008

**(1) Subtask 571208-720-401-001 - Test**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 28-11-00-790-008 |

(a) Do a fuel leak test, refer to AMM Task 28-11-00-790-008.

NOTE: Check the manhole access panels you have installed for leaks. Make sure there are no leaks.

**CONF 009

**(1) Subtask 571208-720-401-001 - Test**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 28-11-00-790-008 |

(a) Do a fuel leak test, refer to AMM Task 28-11-00-790-008.

NOTE: Check the manhole access panels you have installed for leaks. Make sure there are no leaks.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 010

(1) **Subtask 571208-720-401-001 - Test**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 28-11-00-790-008 |

(a) Do a fuel leak test, refer to AMM Task 28-11-00-790-008.

NOTE: Check the manhole access panels you have installed for leaks. Make sure there are no leaks.

**CONF 011

(1) **Subtask 571208-720-401-001 - Test**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 28-11-00-790-008 |

(a) Do a fuel leak test, refer to AMM Task 28-11-00-790-008.

NOTE: Check the manhole access panels you have installed for leaks. Make sure there are no leaks.

**CONF 012

(1) **Subtask 571208-720-401-001 - Test**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 28-11-00-790-008 |

(a) Do a fuel leak test, refer to AMM Task 28-11-00-790-008.

NOTE: Check the manhole access panels you have installed for leaks. Make sure there are no leaks.

**CONF 013

**(1) Subtask 571208-720-401-001 - Test**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 28-11-00-790-008 |

(a) Do a fuel leak test, refer to AMM Task 28-11-00-790-008.

NOTE: Check the manhole access panels you have installed for leaks. Make sure there are no leaks.

**CONF 014

**(1) Subtask 571208-720-401-001 - Test**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 28-11-00-790-008 |

(a) Do a fuel leak test, refer to AMM Task 28-11-00-790-008.

NOTE: Check the manhole access panels you have installed for leaks. Make sure there are no leaks.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 015

(1) **Subtask 571208-720-401-001 - Test**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 28-11-00-790-008 |

(a) Do a fuel leak test, refer to AMM Task 28-11-00-790-008.

NOTE: Check the manhole access panels you have installed for leaks. Make sure there are no leaks.

**CONF 016

(1) **Subtask 571208-720-401-001 - Test**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 28-11-00-790-008 |

(a) Do a fuel leak test, refer to AMM Task 28-11-00-790-008.

NOTE: Check the manhole access panels you have installed for leaks. Make sure there are no leaks.

**CONF 017

(1) **Subtask 571208-720-401-001 - Test**

| Work Zones and Access Panels | | |
|---|---|---|
| | Zone | Access/Work location |
| | 570 | |
| | 670 | |

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 28-11-00-790-008 |

(a) Do a fuel leak test, refer to AMM Task 28-11-00-790-008.

NOTE: Check the manhole access panels you have installed for leaks. Make sure there are no leaks.

**CONF ALL

**E. CLOSE-UP**

**CONF 001

**(1) Subtask 571208-942-401-002 - Close-Up**

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-002<br>Task 12-11-28-650-003<br>Task 32-00-00-410-001<br>Task 57-27-11-400-001<br>Task 57-27-11-400-007 |

(a) Between STGRs 13 and 14 (vent box area) do a check to make sure all swarf and blind bolt heads are removed.

(b) Make sure that the work areas are clean and clear of tools and other items of equipment.

(c) Remove the ground safety locks from the MLG, refer to AMM Task 32-00-00-410-001.

(d) Install access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(e) Install access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-400-007.

(f) Remove the access platform(s).

(g) Lower the aircraft off the jacks, refer to AMM Task 07-11-00-581-002.

(h) Refuel the aircraft, refer to AMM Task 12-11-28-650-003.

(i) Put the aircraft back to its initial configuration.

**CONF 002

**(1) Subtask 571208-942-401-001 - Close-Up**

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-002<br>Task 12-11-28-650-003<br>Task 32-00-00-410-001<br>Task 57-27-11-400-001<br>Task 57-27-11-400-007 |

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Remove the ground safety locks from the MLG, refer to AMM Task 32-00-00-410-001.

(c) Install access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(d) Install access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-400-007.

(e) Remove the access platform(s).

(f) Lower the aircraft off the jacks, refer to AMM Task 07-11-00-581-002.

(g) Refuel the aircraft, refer to AMM Task 12-11-28-650-003.

(h) Put the aircraft back to its initial configuration.

****CONF 003**

**(1) Subtask 571208-942-401-001 - Close-Up**

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-002<br>Task 12-11-28-650-003<br>Task 32-00-00-410-001<br>Task 57-27-11-400-001<br>Task 57-27-11-400-007 |

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Remove the ground safety locks from the MLG, refer to AMM Task 32-00-00-410-001.

(c) Install access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(d) Install access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-400-007.

(e) Remove the access platform(s).

(f) Lower the aircraft off the jacks, refer to AMM Task 07-11-00-581-002.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(g) Refuel the aircraft, refer to AMM Task 12-11-28-650-003.

(h) Put the aircraft back to its initial configuration.

**CONF 004

**(1) Subtask 571208-942-401-001 - Close-Up**

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-002<br>Task 12-11-28-650-003<br>Task 32-00-00-410-001<br>Task 57-27-11-400-001<br>Task 57-27-11-400-007 |

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Remove the ground safety locks from the MLG, refer to AMM Task 32-00-00-410-001.

(c) Install access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(d) Install access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-400-007.

(e) Remove the access platform(s).

(f) Lower the aircraft off the jacks, refer to AMM Task 07-11-00-581-002.

(g) Refuel the aircraft, refer to AMM Task 12-11-28-650-003.

(h) Put the aircraft back to its initial configuration.

**CONF 005

**(1) Subtask 571208-942-401-001 - Close-Up**

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-002<br>Task 12-11-28-650-003<br>Task 32-00-00-410-001<br>Task 57-27-11-400-001<br>Task 57-27-11-400-007 |

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) Remove the ground safety locks from the MLG, refer to AMM Task 32-00-00-410-001.

(c) Install access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(d) Install access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-400-007.

(e) Remove the access platform(s).

(f) Lower the aircraft off the jacks, refer to AMM Task 07-11-00-581-002.

(g) Refuel the aircraft, refer to AMM Task 12-11-28-650-003.

(h) Put the aircraft back to its initial configuration.

****CONF 006**

**(1) Subtask 571208-942-401-001 - Close-Up**

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-002<br>Task 12-11-28-650-003<br>Task 32-00-00-410-001<br>Task 57-27-11-400-001<br>Task 57-27-11-400-007 |

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Remove the ground safety locks from the MLG, refer to AMM Task 32-00-00-410-001.

(c) Install access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(d) Install access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-400-007.

(e) Remove the access platform(s).

(f) Lower the aircraft off the jacks, refer to AMM Task 07-11-00-581-002.

(g) Refuel the aircraft, refer to AMM Task 12-11-28-650-003.

(h) Put the aircraft back to its initial configuration.

****CONF 007**

**(1) Subtask 571208-942-401-001 - Close-Up**

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-002<br>Task 12-11-28-650-003<br>Task 32-00-00-410-001<br>Task 57-27-11-400-001<br>Task 57-27-11-400-007 |

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Remove the ground safety locks from the MLG, refer to AMM Task 32-00-00-410-001.

(c) Install access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(d) Install access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-400-007.

(e) Remove the access platform(s).

(f) Lower the aircraft off the jacks, refer to AMM Task 07-11-00-581-002.

(g) Refuel the aircraft, refer to AMM Task 12-11-28-650-003.

(h) Put the aircraft back to its initial configuration.

****CONF 008**

**(1) Subtask 571208-942-401-001 - Close-Up**

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-002<br>Task 12-11-28-650-003<br>Task 32-00-00-410-001<br>Task 57-27-11-400-001<br>Task 57-27-11-400-007 |

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Remove the ground safety locks from the MLG, refer to AMM Task 32-00-00-410-001.

(c) Install access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(d) Install access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-400-007.

(e) Remove the access platform(s).

(f) Lower the aircraft off the jacks, refer to AMM Task 07-11-00-581-002.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(g) Refuel the aircraft, refer to AMM Task 12-11-28-650-003.

(h) Put the aircraft back to its initial configuration.

**CONF 009

**(1) Subtask 571208-942-401-001 - Close-Up**

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-002<br>Task 12-11-28-650-003<br>Task 32-00-00-410-001<br>Task 57-27-11-400-001<br>Task 57-27-11-400-007 |

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Remove the ground safety locks from the MLG, refer to AMM Task 32-00-00-410-001.

(c) Install access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(d) Install access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-400-007.

(e) Remove the access platform(s).

(f) Lower the aircraft off the jacks, refer to AMM Task 07-11-00-581-002.

(g) Refuel the aircraft, refer to AMM Task 12-11-28-650-003.

(h) Put the aircraft back to its initial configuration.

**CONF 010

**(1) Subtask 571208-942-401-001 - Close-Up**

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-002<br>Task 12-11-28-650-003<br>Task 32-00-00-410-001<br>Task 57-27-11-400-001<br>Task 57-27-11-400-007 |

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) Remove the ground safety locks from the MLG, refer to AMM Task 32-00-00-410-001.

(c) Install access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(d) Install access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-400-007.

(e) Remove the access platform(s).

(f) Lower the aircraft off the jacks, refer to AMM Task 07-11-00-581-002.

(g) Refuel the aircraft, refer to AMM Task 12-11-28-650-003.

(h) Put the aircraft back to its initial configuration.

****CONF 011**

**(1) Subtask 571208-942-401-001 - Close-Up**

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-002<br>Task 12-11-28-650-003<br>Task 32-00-00-410-001<br>Task 57-27-11-400-001<br>Task 57-27-11-400-007 |

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Remove the ground safety locks from the MLG, refer to AMM Task 32-00-00-410-001.

(c) Install access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(d) Install access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-400-007.

(e) Remove the access platform(s).

(f) Lower the aircraft off the jacks, refer to AMM Task 07-11-00-581-002.

(g) Refuel the aircraft, refer to AMM Task 12-11-28-650-003.

(h) Put the aircraft back to its initial configuration.

****CONF 012**

**(1) Subtask 571208-942-401-001 - Close-Up**

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-002<br>Task 12-11-28-650-003<br>Task 32-00-00-410-001<br>Task 57-27-11-400-001<br>Task 57-27-11-400-007 |

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Remove the ground safety locks from the MLG, refer to AMM Task 32-00-00-410-001.

(c) Install access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(d) Install access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-400-007.

(e) Remove the access platform(s).

(f) Lower the aircraft off the jacks, refer to AMM Task 07-11-00-581-002.

(g) Refuel the aircraft, refer to AMM Task 12-11-28-650-003.

(h) Put the aircraft back to its initial configuration.

****CONF 013**

**(1) Subtask 571208-942-401-001 - Close-Up**

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-002<br>Task 12-11-28-650-003<br>Task 32-00-00-410-001<br>Task 57-27-11-400-001<br>Task 57-27-11-400-007 |

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Remove the ground safety locks from the MLG, refer to AMM Task 32-00-00-410-001.

(c) Install access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(d) Install access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-400-007.

(e) Remove the access platform(s).

(f) Lower the aircraft off the jacks, refer to AMM Task 07-11-00-581-002.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(g) Refuel the aircraft, refer to AMM Task 12-11-28-650-003.

(h) Put the aircraft back to its initial configuration.

**CONF 014

**(1) Subtask 571208-942-401-001 - Close-Up**

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-002<br>Task 12-11-28-650-003<br>Task 32-00-00-410-001<br>Task 57-27-11-400-001<br>Task 57-27-11-400-007 |

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Remove the ground safety locks from the MLG, refer to AMM Task 32-00-00-410-001.

(c) Install access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(d) Install access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-400-007.

(e) Remove the access platform(s).

(f) Lower the aircraft off the jacks, refer to AMM Task 07-11-00-581-002.

(g) Refuel the aircraft, refer to AMM Task 12-11-28-650-003.

(h) Put the aircraft back to its initial configuration.

**CONF 015

**(1) Subtask 571208-942-401-001 - Close-Up**

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-002<br>Task 12-11-28-650-003<br>Task 32-00-00-410-001<br>Task 57-27-11-400-001<br>Task 57-27-11-400-007 |

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(b) Remove the ground safety locks from the MLG, refer to AMM Task 32-00-00-410-001.

(c) Install access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(d) Install access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-400-007.

(e) Remove the access platform(s).

(f) Lower the aircraft off the jacks, refer to AMM Task 07-11-00-581-002.

(g) Refuel the aircraft, refer to AMM Task 12-11-28-650-003.

(h) Put the aircraft back to its initial configuration.

****CONF 016**

**(1) Subtask 571208-942-401-001 - Close-Up**

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-002<br>Task 12-11-28-650-003<br>Task 32-00-00-410-001<br>Task 57-27-11-400-001<br>Task 57-27-11-400-007 |

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Remove the ground safety locks from the MLG, refer to AMM Task 32-00-00-410-001.

(c) Install access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(d) Install access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-400-007.

(e) Remove the access platform(s).

(f) Lower the aircraft off the jacks, refer to AMM Task 07-11-00-581-002.

(g) Refuel the aircraft, refer to AMM Task 12-11-28-650-003.

(h) Put the aircraft back to its initial configuration.

****CONF 017**

**(1) Subtask 571208-942-401-001 - Close-Up**

| Manpower Resources | |
|---|---|
| Skills | AIRFRAME |



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

| References | |
|---|---|
| Aircraft Maintenance Manual (AMM) | Task 07-11-00-581-002<br>Task 12-11-28-650-003<br>Task 32-00-00-410-001<br>Task 57-27-11-400-001<br>Task 57-27-11-400-007 |

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Remove the ground safety locks from the MLG, refer to AMM Task 32-00-00-410-001.

(c) Install access panels 540AB and 640AB, refer to AMM Task 57-27-11-400-001.

(d) Install access panels 540CZ and 640CZ, refer to AMM Task 57-27-11-400-007.

(e) Remove the access platform(s).

(f) Lower the aircraft off the jacks, refer to AMM Task 07-11-00-581-002.

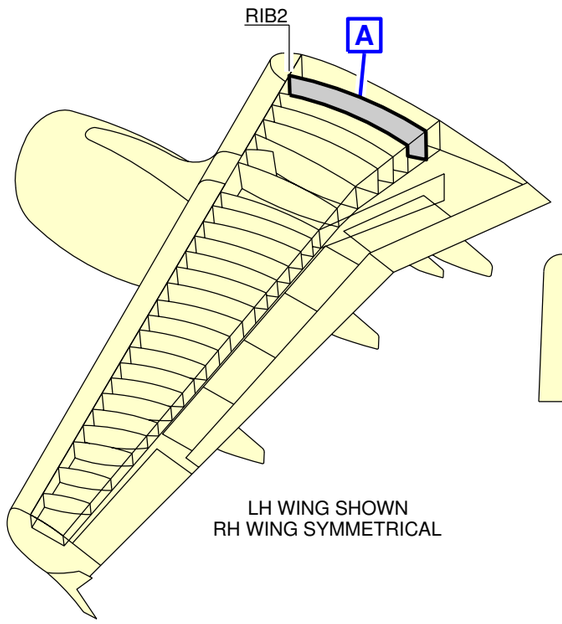
(g) Refuel the aircraft, refer to AMM Task 12-11-28-650-003.

(h) Put the aircraft back to its initial configuration.

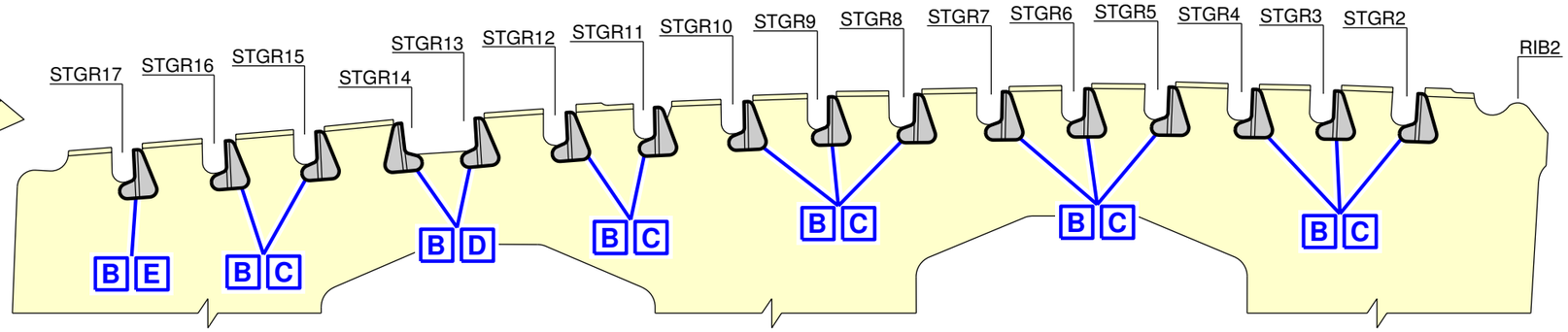


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 001



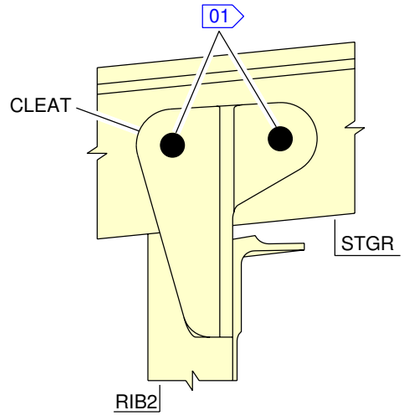

LH WING SHOWN
RH WING SYMMETRICAL




FWD A

VIEW LOOKING OUTBOARD

## BEFORE




INBD B

TYPICAL FOR
STGRS 2 THRU 17

| | FASTENER TABLE | NOTE |
|---|---|---|
| ● | REMOVE AND DISCARD | 01 |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

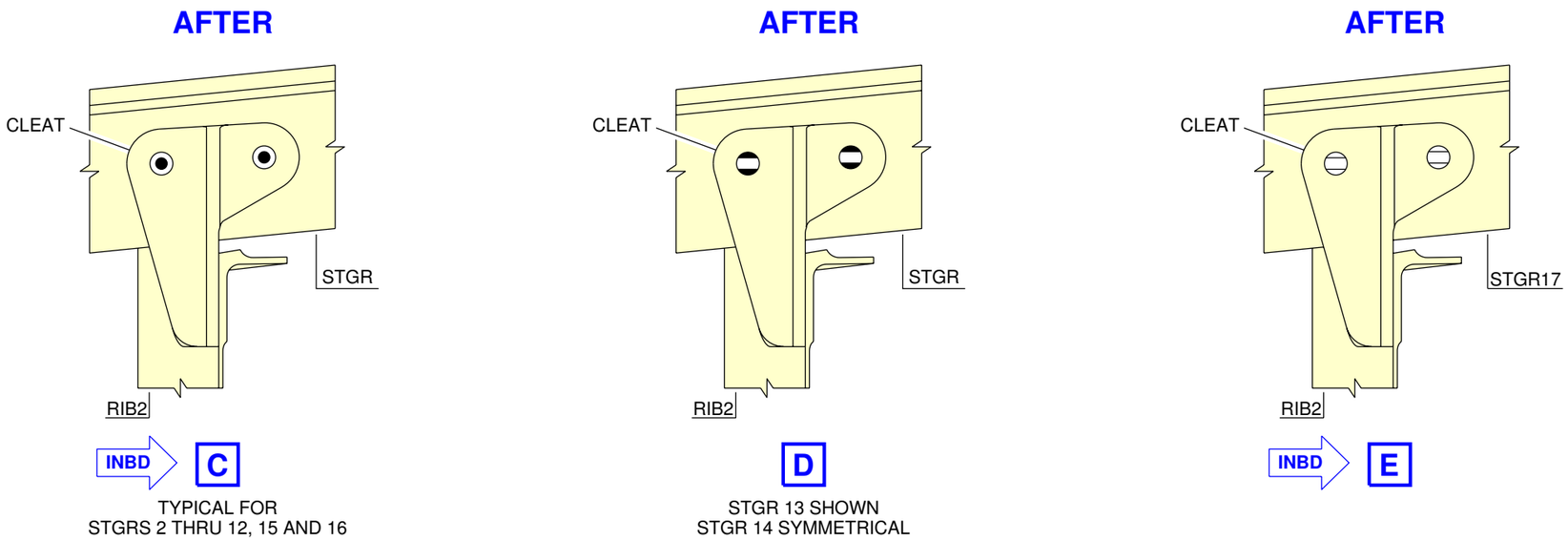
N_SB_571208_7_BAAA_01_03

Figure A-UBAAA - Sheet 01
Modification of the Cleat to Stringer Webs RIB 2



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 001




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER | | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | | | | | MIN | MAX | | |
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊖ | – | 8 | EN6115V4Y7 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⬬ | – | 12 | NAS1751–4L5 | BOLT | 7.010 mm (0.2760 in) | 7.060 mm (0.2779 in) | 1ST OVERSIZE CLEARANCE FIT | – |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

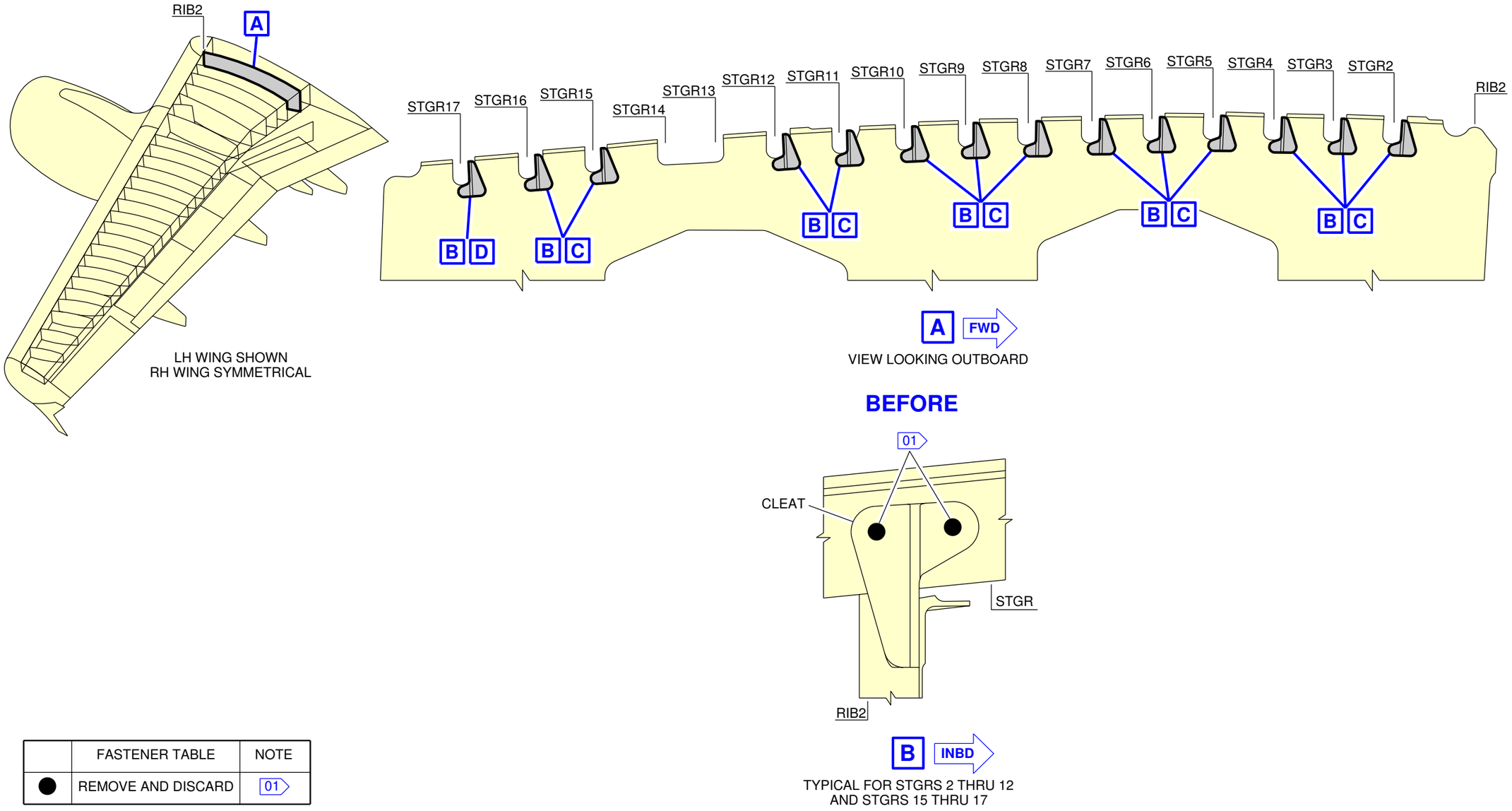
N_SB_571208_7_BAAA_02_04

Figure A-UBAAA - Sheet 02
Modification of the Cleat to Stringer Webs RIB 2



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 002 thru 017




| | FASTENER TABLE | NOTE |
|---|---|---|
| ● | REMOVE AND DISCARD | 01 |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

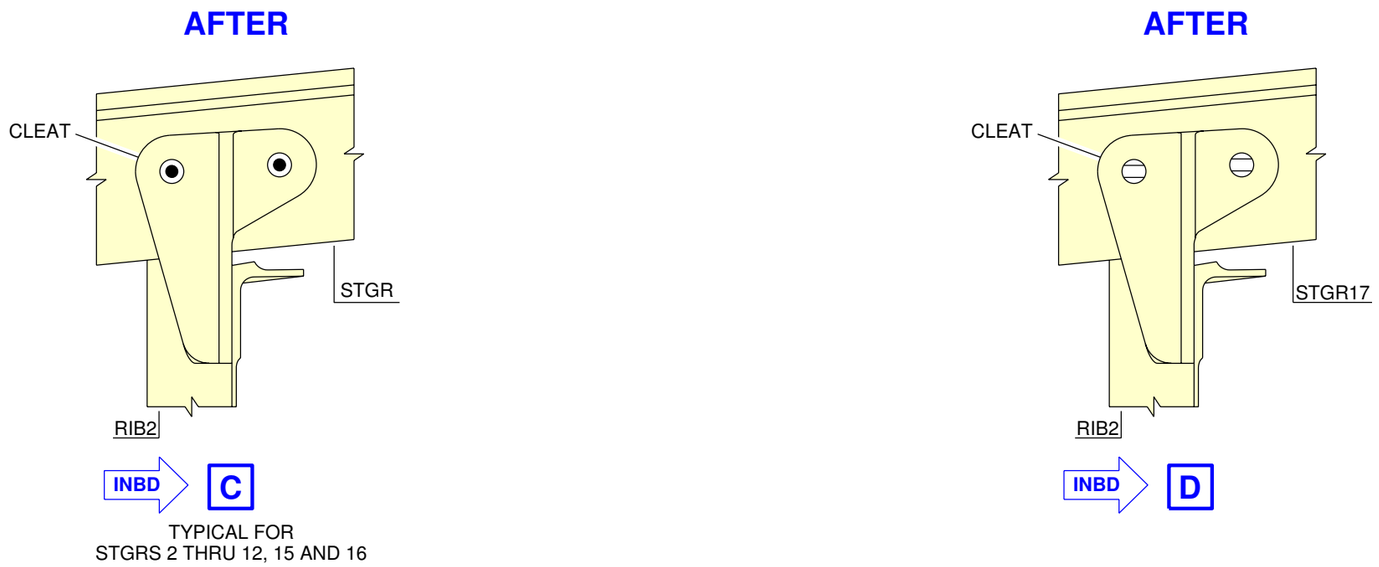
N_SB_571208_7_BAAB_01_05

Figure A-UBAAB - Sheet 01
Modification of the Cleat to Stringer Webs RIB 2



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 002 thru 017




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER | | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | | | | | MIN | MAX | | |
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊖ | – | 8 | EN6115V4Y7 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

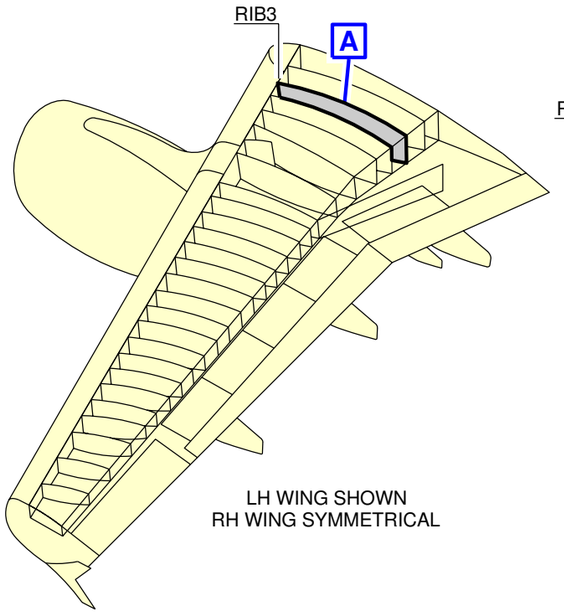
N_SB_571208_7_BAAB_02_03

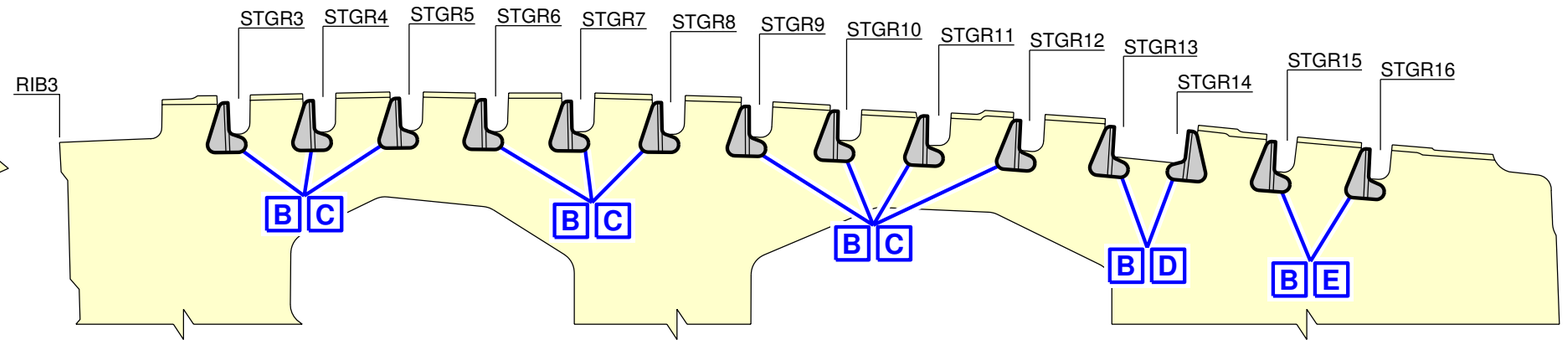
Figure A-UBAAB - Sheet 02
Modification of the Cleat to Stringer Webs RIB 2



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

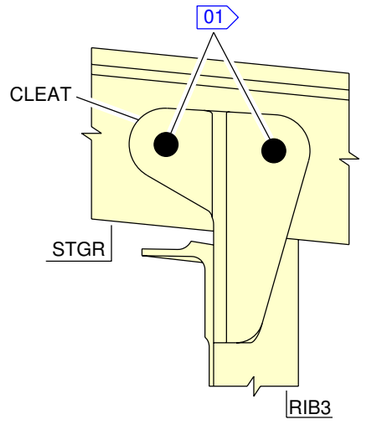
**CONF 001



VIEW LOOKING INBOARD

## BEFORE



TYPICAL FOR
STGRS 3 THRU 16

| | FASTENER TABLE | NOTE |
|---|---|---|
| ● | REMOVE AND DISCARD | 01 |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

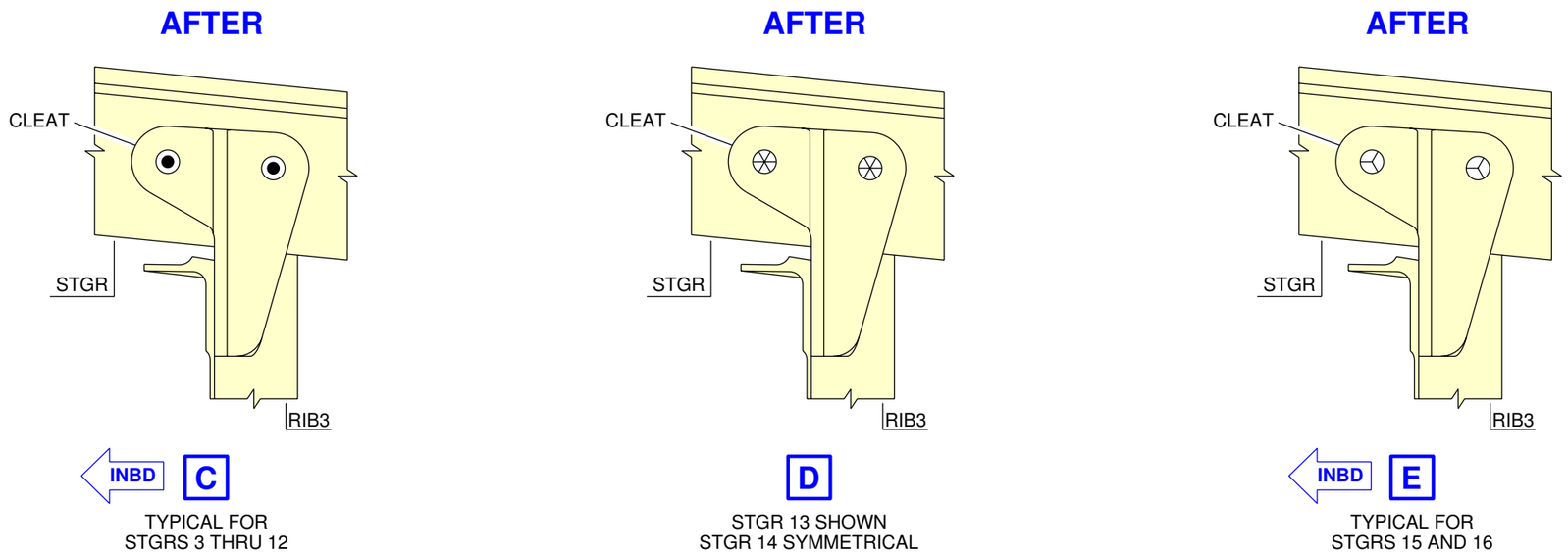
N_SB_571208_7_BBAA_01_03

Figure A-UBBAA - Sheet 01
Modification of the Cleat to Stringer Webs RIB 3



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 001




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER | | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | | | | | MIN | MAX | | |
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊘ | – | 9 | EN6115V4Y8 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊛ | – | 13 | NAS1751–4L6 | BOLT | 7.010 mm (0.2760 in) | 7.060 mm (0.2779 in) | 1ST OVERSIZE CLEARANCE FIT | – |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

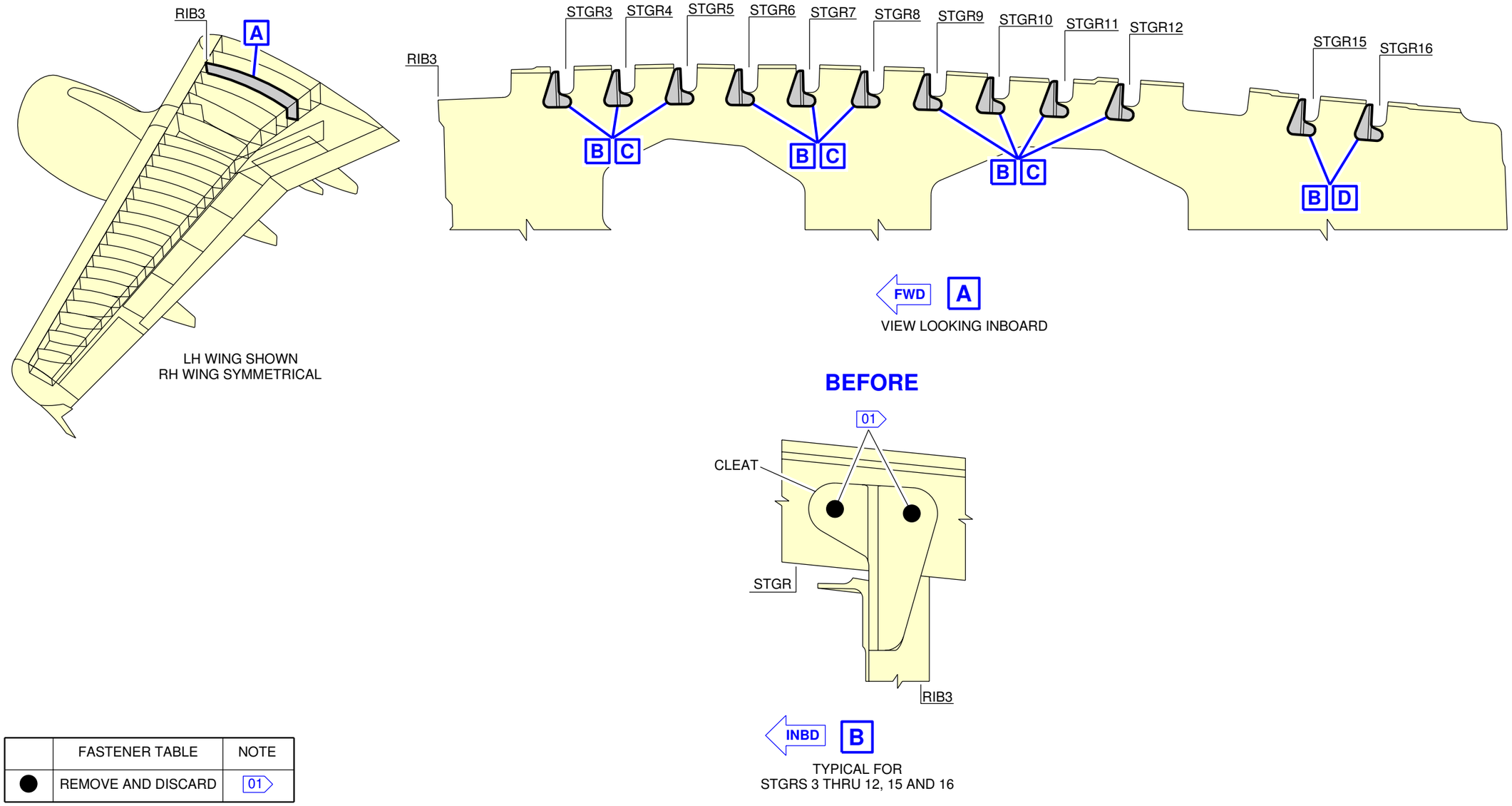
N_SB_571208_7_BBAA_02_04

Figure A-UBBAA - Sheet 02
Modification of the Cleat to Stringer Webs RIB 3



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 002 thru 005, 010 thru 011, 013, 016




| | FASTENER TABLE | NOTE |
|---|---|---|
| ● | REMOVE AND DISCARD | 01 |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

N_SB_571208_7_BBAB_01_03

Figure A-UBBAB - Sheet 01
Modification of the Cleat to Stringer Webs RIB 3



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 002 thru 005, 010 thru 011, 013, 016

| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER | | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | | | | | MIN | MAX | | |
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊘ | – | 9 | EN6115V4Y8 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

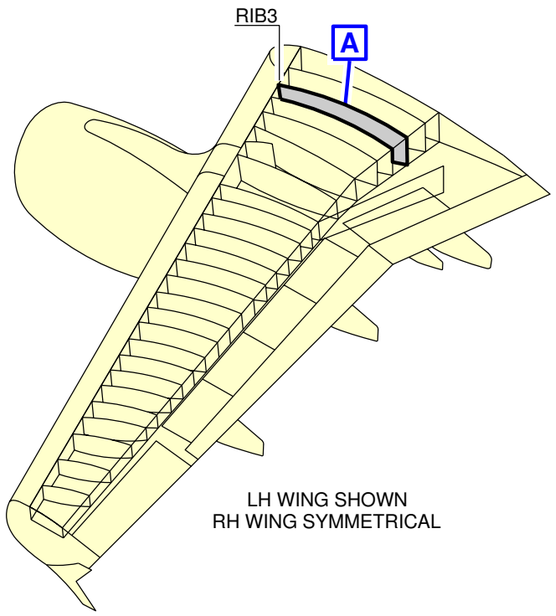
N_SB_571208_7_BBAB_02_03

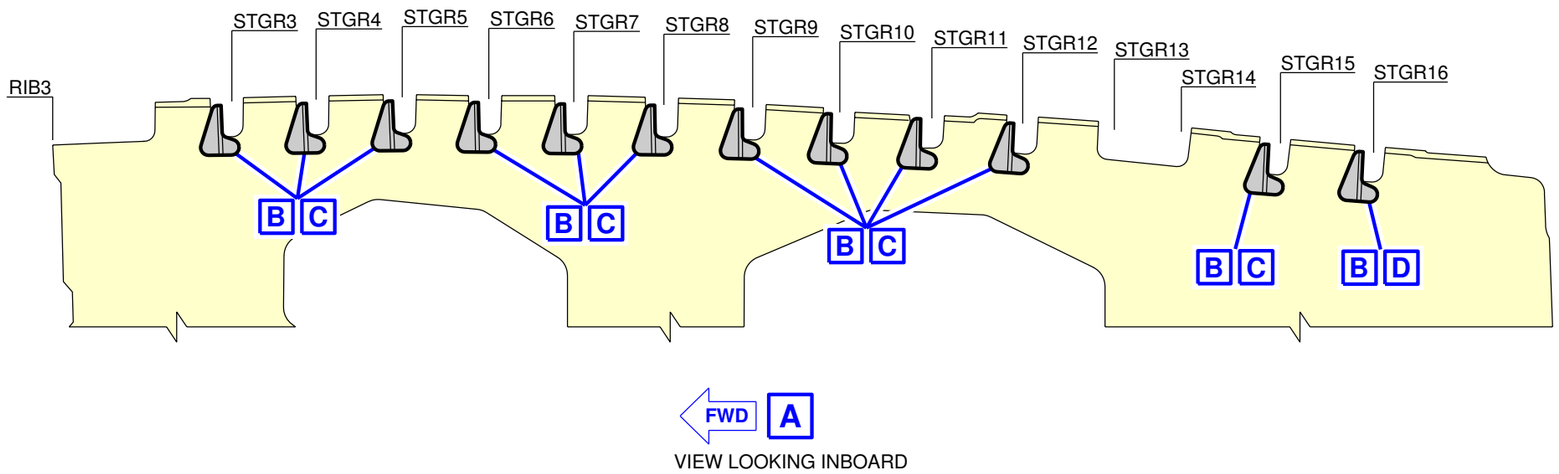
Figure A-UBBAB - Sheet 02
Modification of the Cleat to Stringer Webs RIB 3



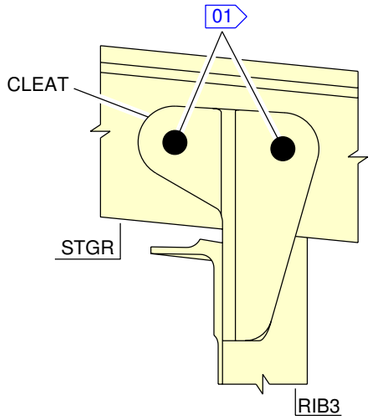
Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 006 thru 009, 012, 014 thru 015, 017




**BEFORE**




TYPICAL FOR
STGRS 3 THRU 12, 15 AND 16

| | FASTENER TABLE | NOTE |
|---|---|---|
| ● | REMOVE AND DISCARD | 01 |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

N_SB_571208_7_BBAC_01_03

Figure A-UBBAC - Sheet 01
Modification of the Cleat to Stringer Webs RIB 3



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 006 thru 009, 012, 014 thru 015, 017

| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER | | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | | | | | MIN | MAX | | |
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊘ | – | 9 | EN6115V4Y8 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

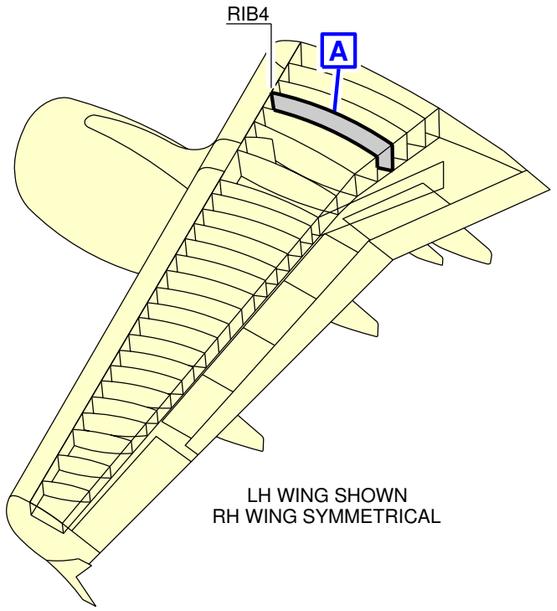
N_SB_571208_7_BBAC_02_03

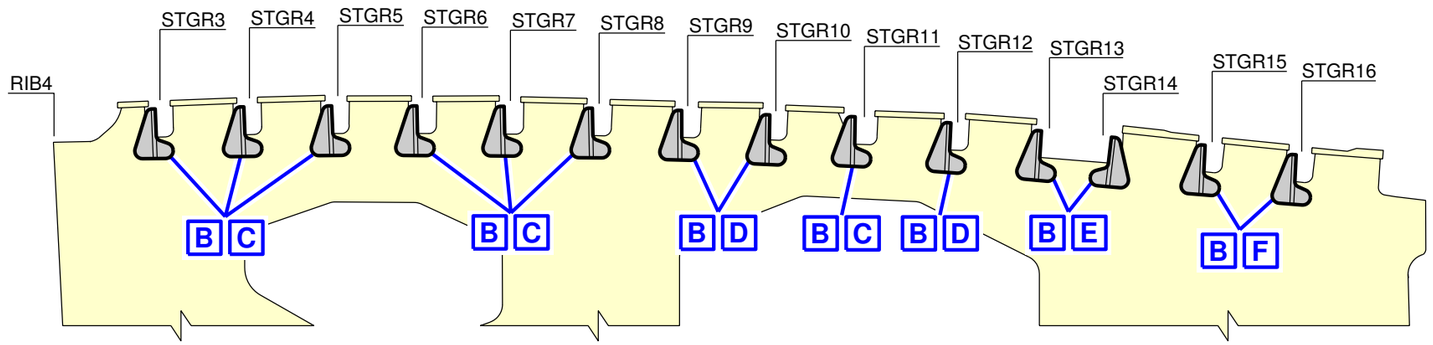
Figure A-UBBAC - Sheet 02
Modification of the Cleat to Stringer Webs RIB 3



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

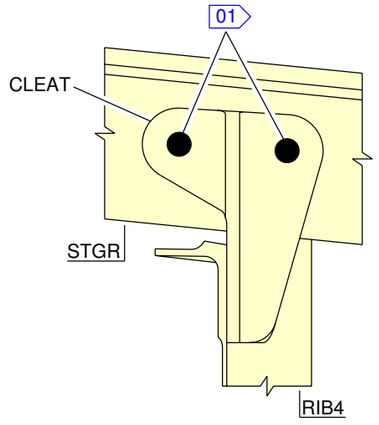
**CONF 001



VIEW LOOKING INBOARD

## BEFORE



TYPICAL FOR
STGRS 3 THRU 16

| | FASTENER TABLE | NOTE |
|---|---|---|
| ● | REMOVE AND DISCARD | 01 |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

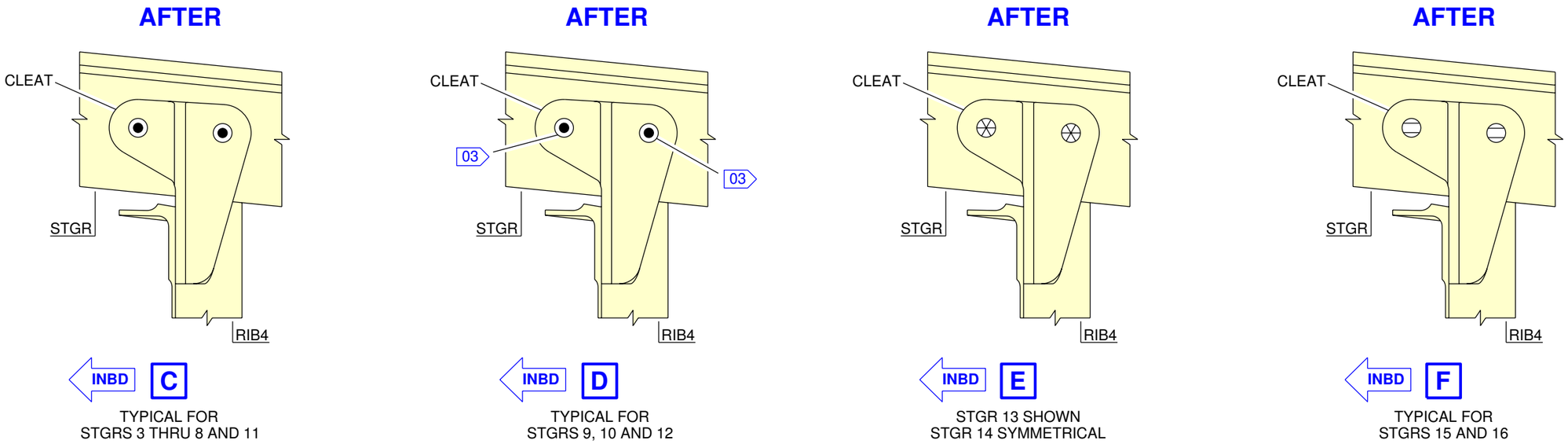
N_SB_571208_7_BCAA_01_02

Figure A-UBCAA - Sheet 01
Modification of the Cleat to Stringer Webs RIB 4



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 001




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER MIN | FINAL HOLE DIAMETER MAX | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊖ | – | 8 | EN6115V4Y7 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊗ | – | 13 | NAS1751–4L6 | BOLT | 7.010 mm (0.2760 in) | 7.060 mm (0.2779 in) | 1ST OVERSIZE CLEARANCE FIT | – |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

03 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

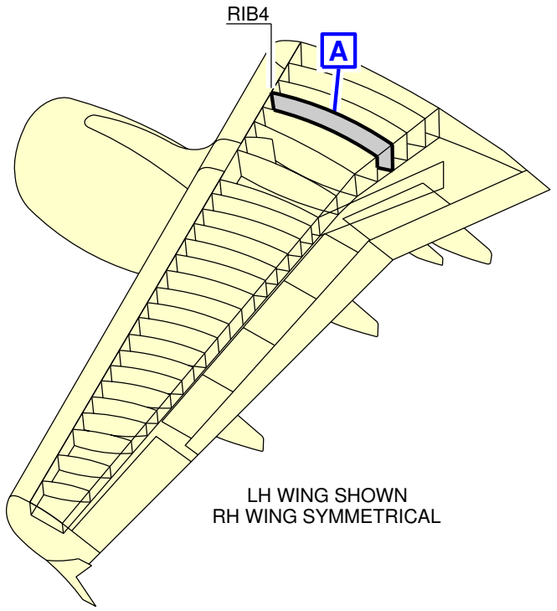
N_SB_571208_7_BCAA_02_04

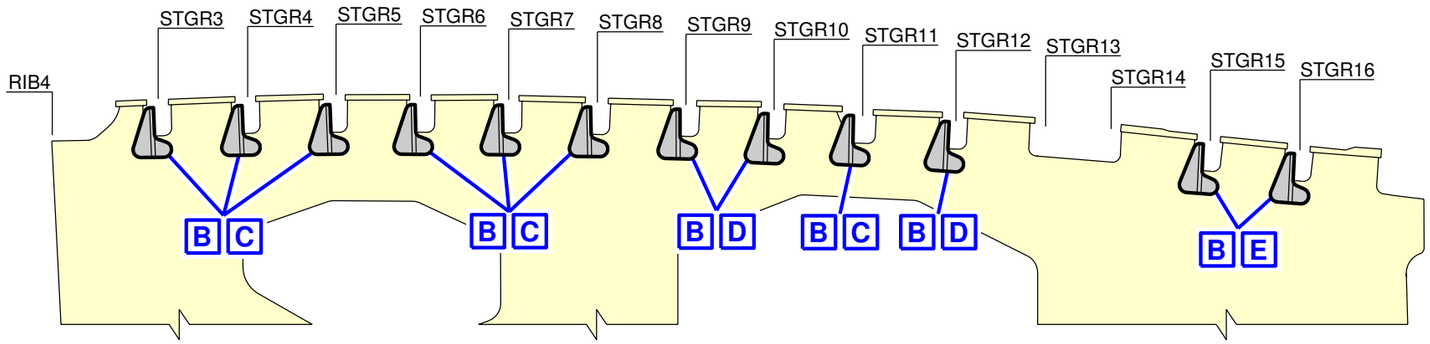
Figure A-UBCAA - Sheet 02
Modification of the Cleat to Stringer Webs RIB 4



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

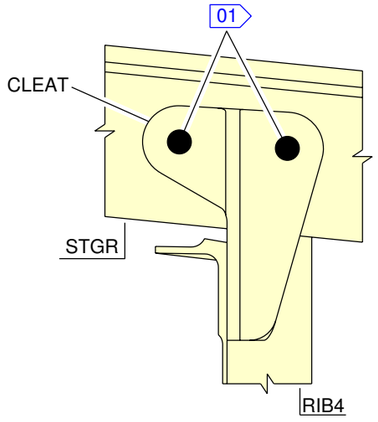
**CONF 002 thru 017



VIEW LOOKING INBOARD

## BEFORE



TYPICAL FOR
STGRS 3 THRU 12, 15 AND 16

| | FASTENER TABLE | NOTE |
|---|---|---|
| ● | REMOVE AND DISCARD | 01 |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

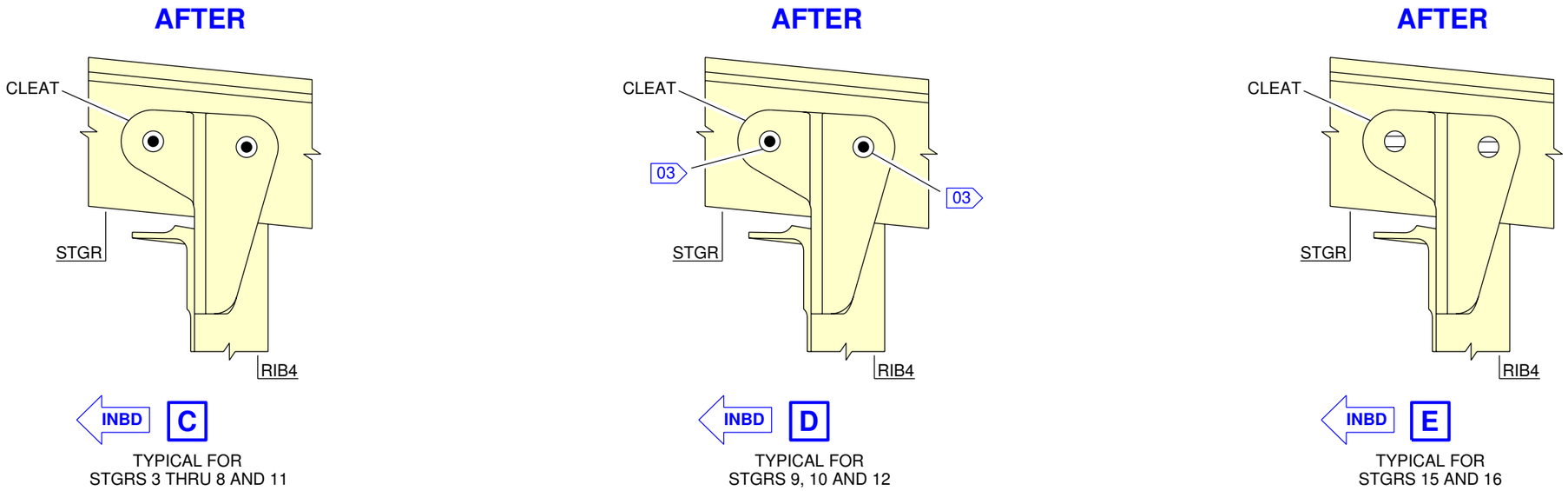
N_SB_571208_7_BCAB_01_03

Figure A-UBCAB - Sheet 01
Modification of the Cleat to Stringer Webs RIB 4



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 002 thru 017




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER MIN | FINAL HOLE DIAMETER MAX | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊖ | – | 8 | EN6115V4Y7 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

03 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

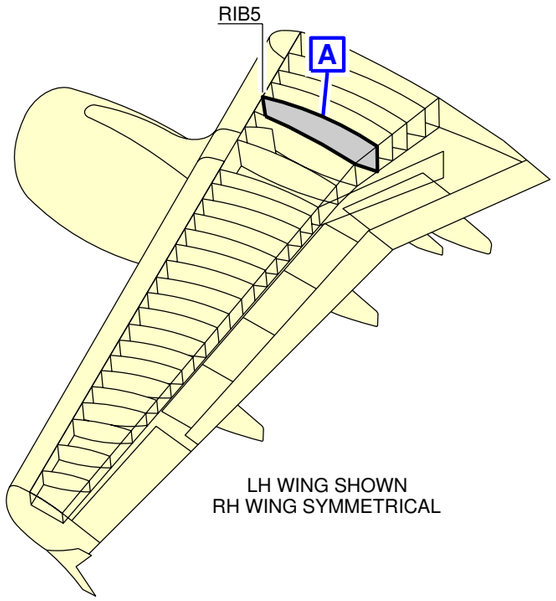
N_SB_571208_7_BCAB_02_03

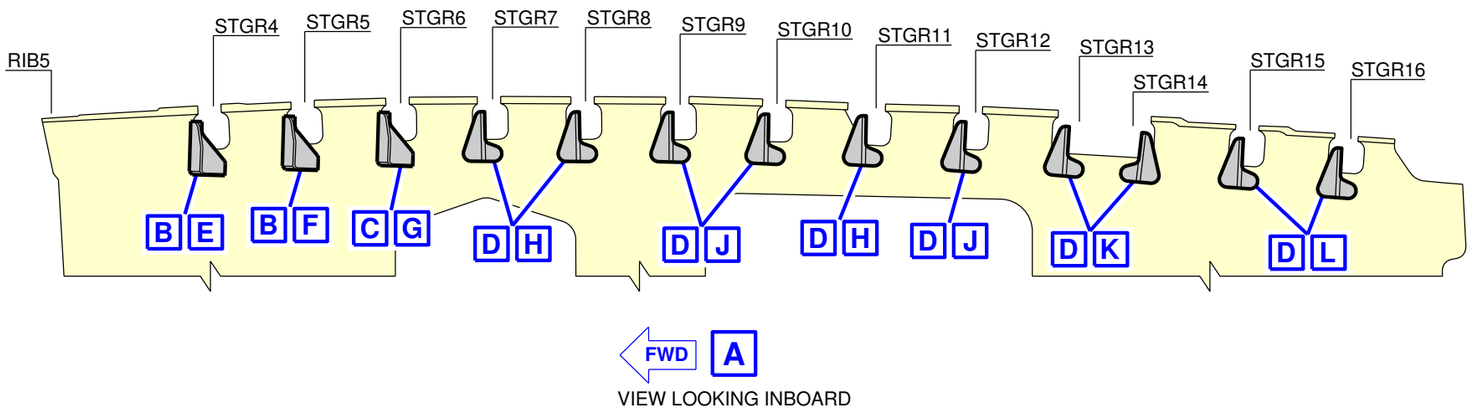
Figure A-UBCAB - Sheet 02
Modification of the Cleat to Stringer Webs RIB 4

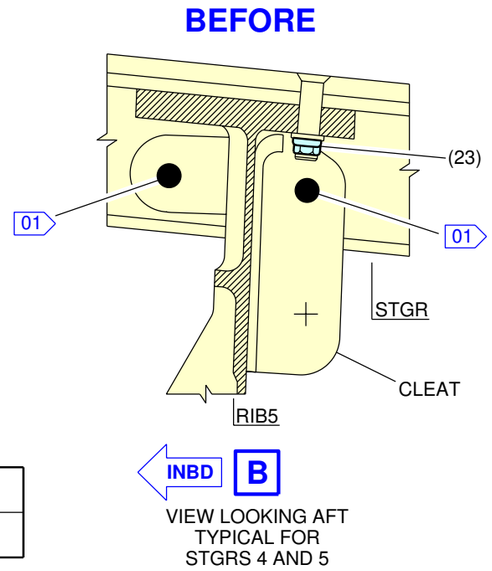


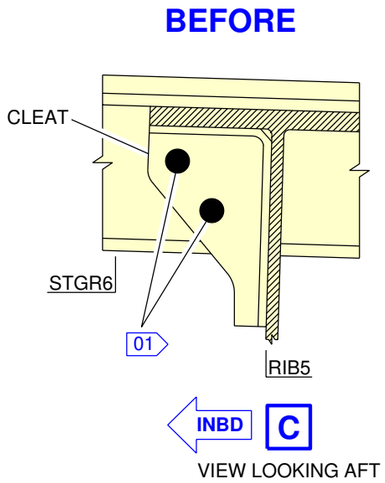
Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

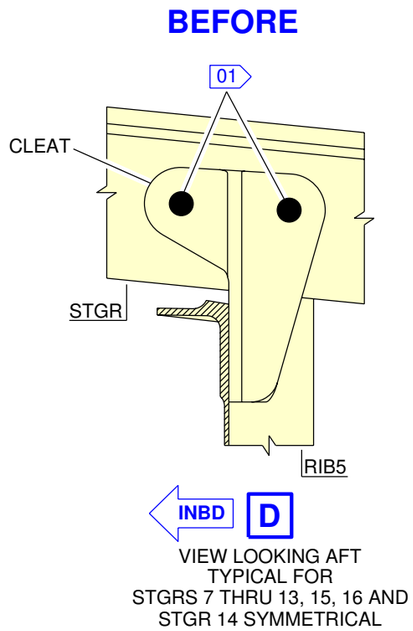
**CONF 001




| | FASTENER TABLE | NOTE |
|---|---|---|
| ● | REMOVE AND DISCARD | 01 |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

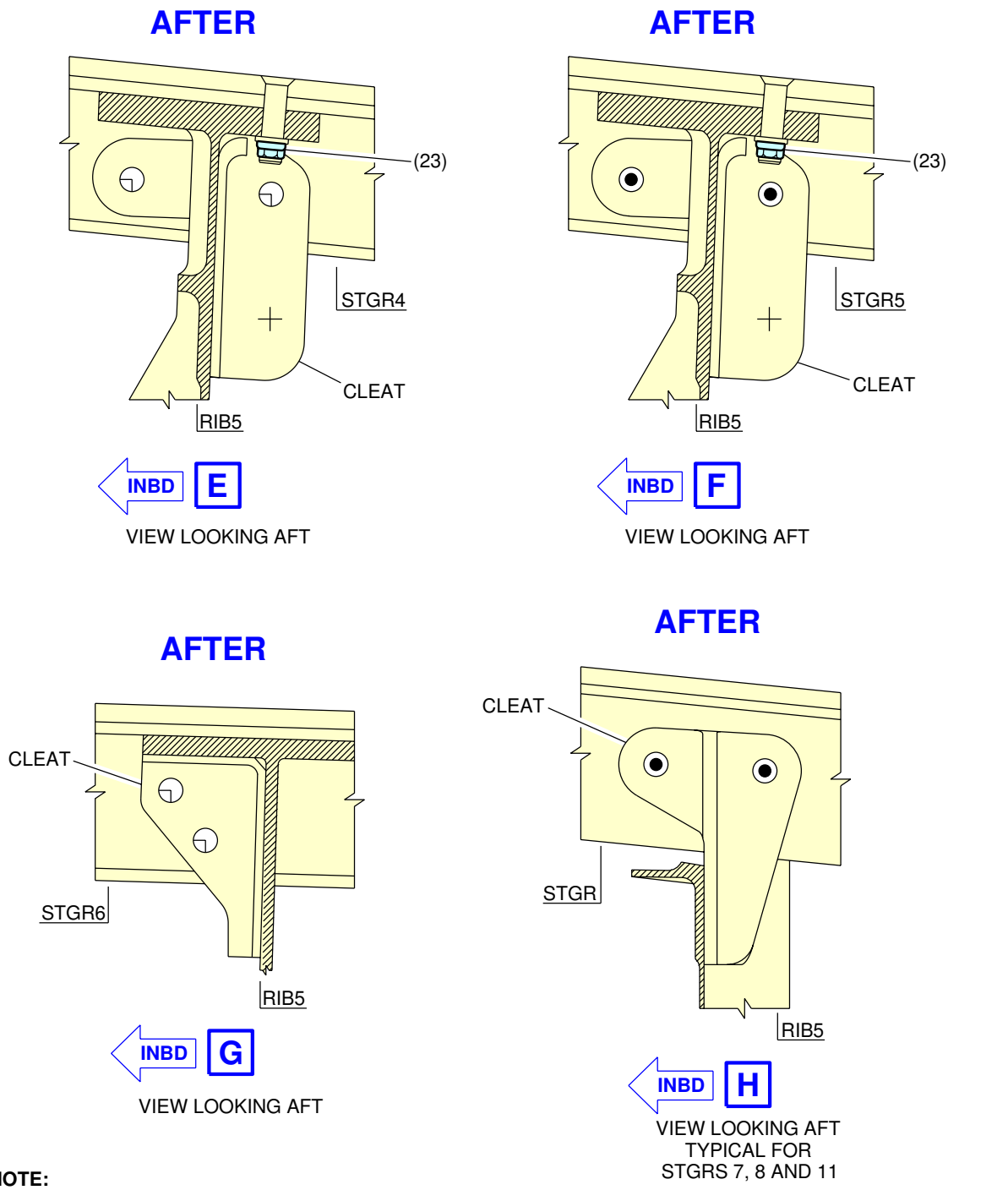
N_SB_571208_7_BDAA_01_03

Figure A-UBDAA - Sheet 01
Modification of the Cleat to Stringer Webs RIB 5



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 001




**NOTE:**
FOR FASTENER TABLE SEE SHEET 3.

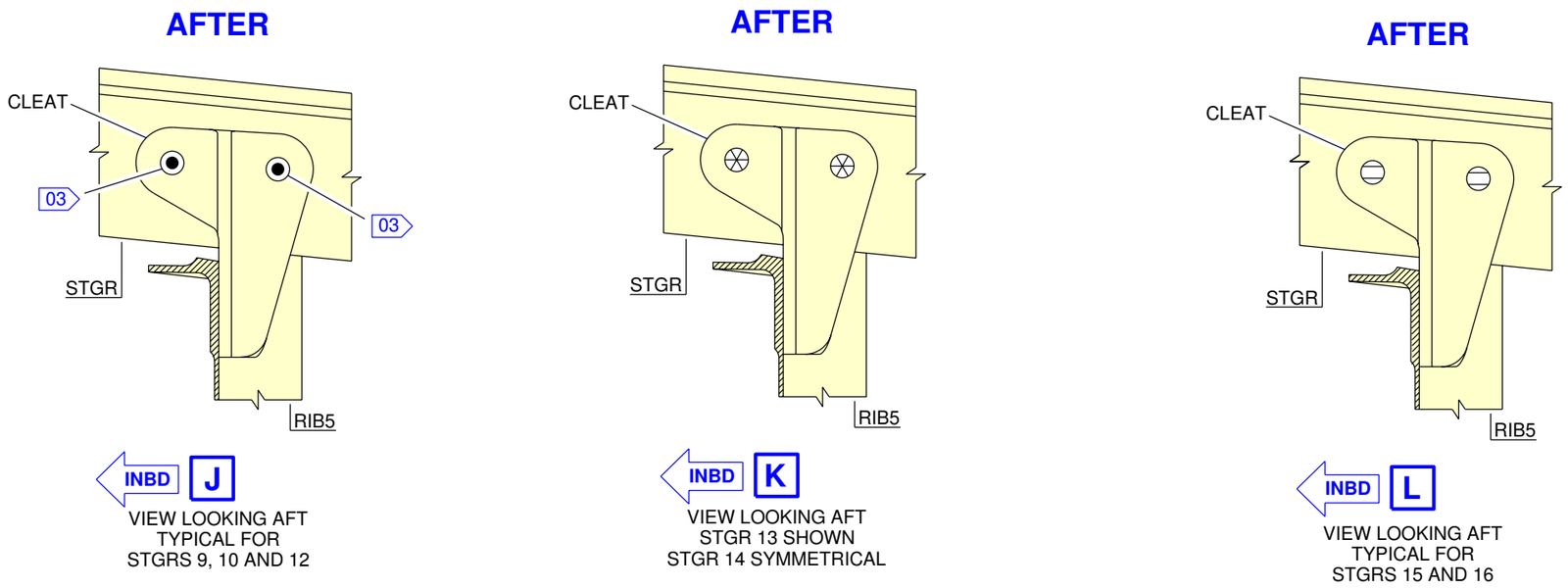
N_SB_571208_7_BDAA_02_05

Figure A-UBDAA - Sheet 02
Modification of the Cleat to Stringer Webs RIB 5



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 001




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER | | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | | | | | MIN | MAX | | |
| | – | 6 | EN6115V4Y5 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 8 | EN6115V4Y7 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 13 | NAS1751–4L6 | BOLT | 7.010 mm (0.2760 in) | 7.060 mm (0.2779 in) | 1ST OVERSIZE CLEARANCE FIT | – |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

03 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

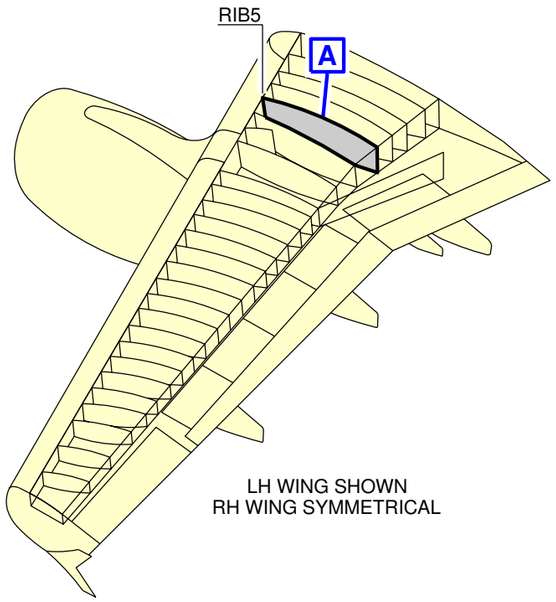
N_SB_571208_7_BDAA_03_01

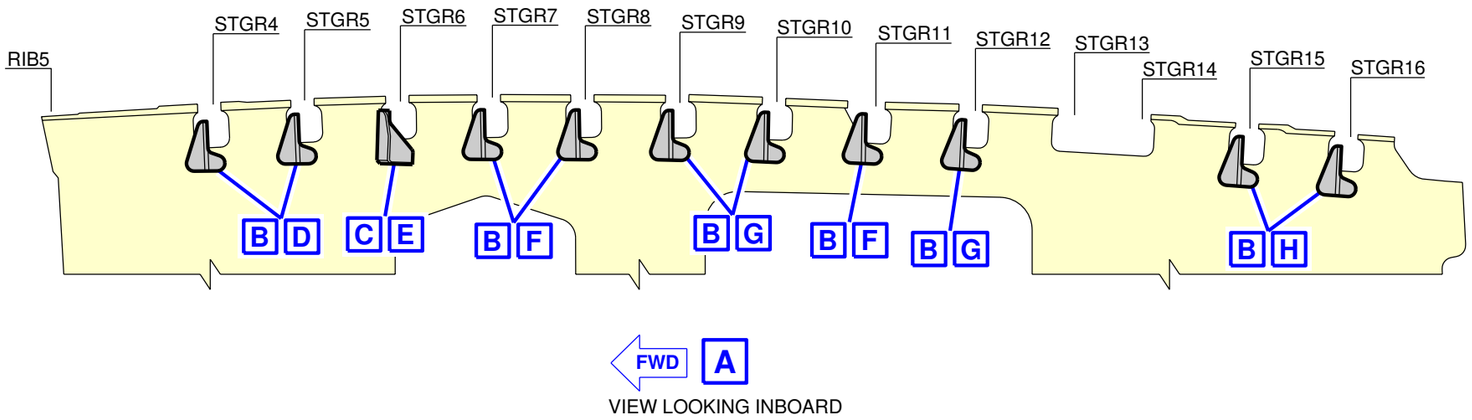
Figure A-UBDAA - Sheet 03
Modification of the Cleat to Stringer Webs RIB 5



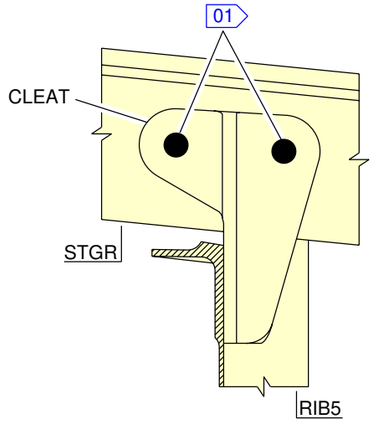
Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 002, 016

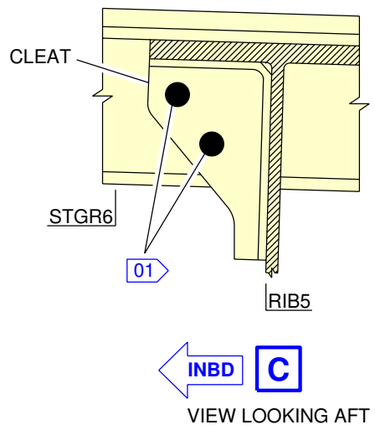



**BEFORE**




**BEFORE**




| | FASTENER TABLE | NOTE |
|---|---|---|
| ● | REMOVE AND DISCARD | 01 |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

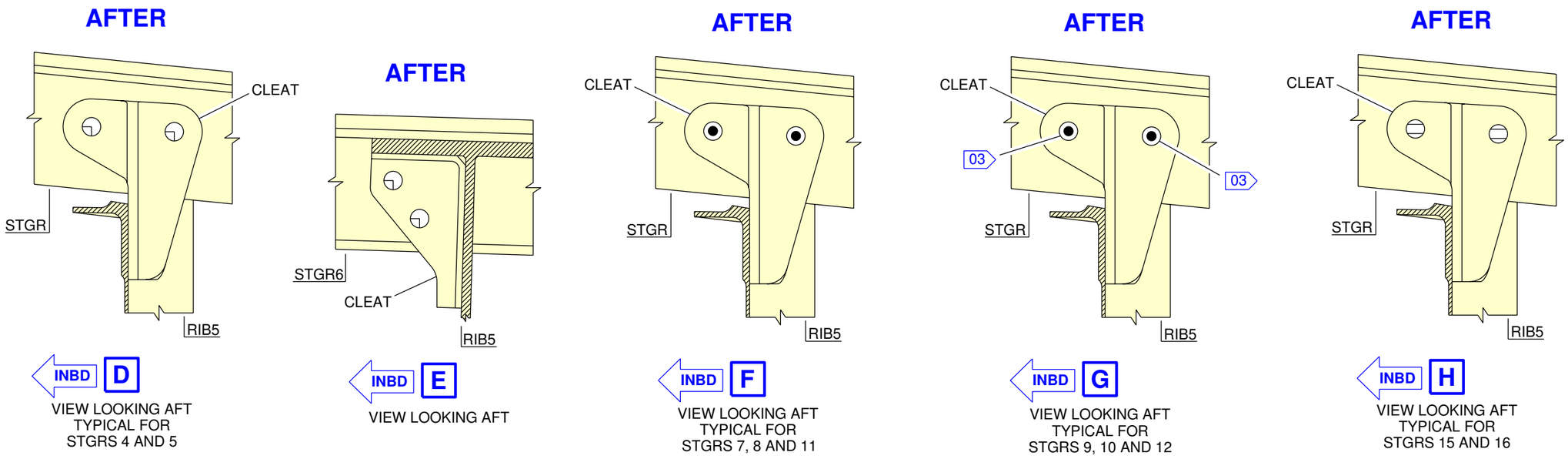
N_SB_571208_7_BDAB_01_03

Figure A-UBDAB - Sheet 01
Modification of the Cleat to Stringer Webs RIB 5



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 002, 016




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER MIN | FINAL HOLE DIAMETER MAX | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| ⊖ | – | 6 | EN6115V4Y5 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊖ | – | 8 | EN6115V4Y7 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

03 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

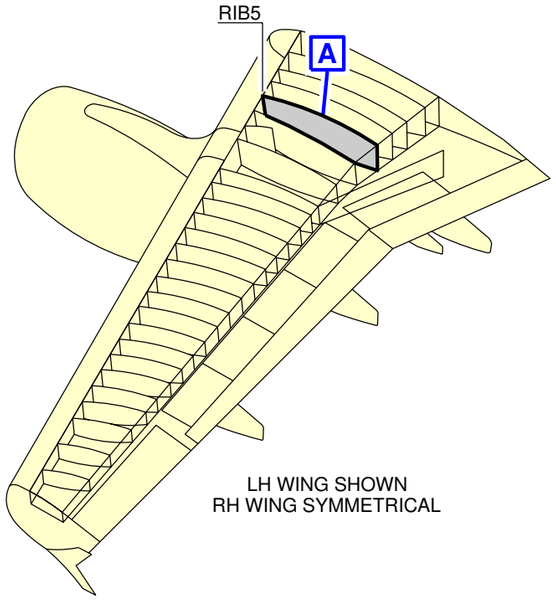
N_SB_571208_7_BDAB_02_04

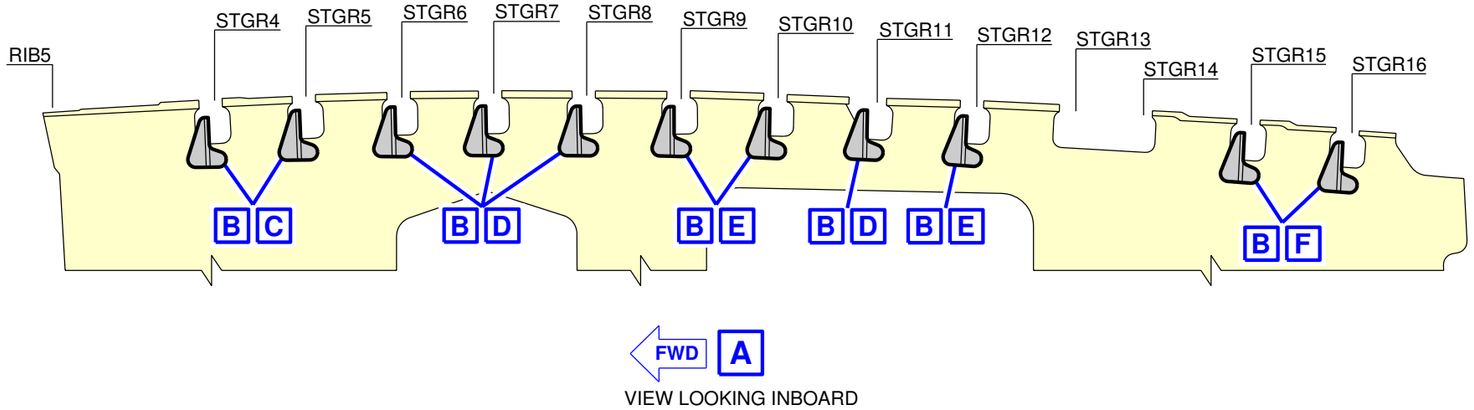
Figure A-UBDAB - Sheet 02
Modification of the Cleat to Stringer Webs RIB 5



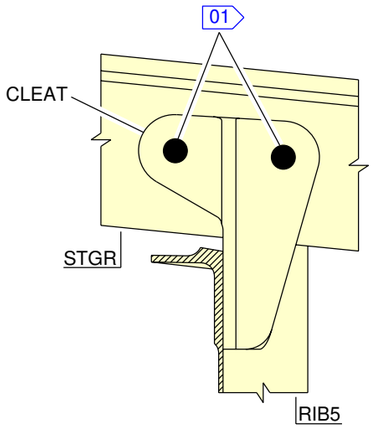
Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 003, 010




**BEFORE**




VIEW LOOKING AFT
TYPICAL FOR
STGRS 4 THRU 12, 15 AND 16

| | FASTENER TABLE | NOTE |
|---|---|---|
| ● | REMOVE AND DISCARD | 01 |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

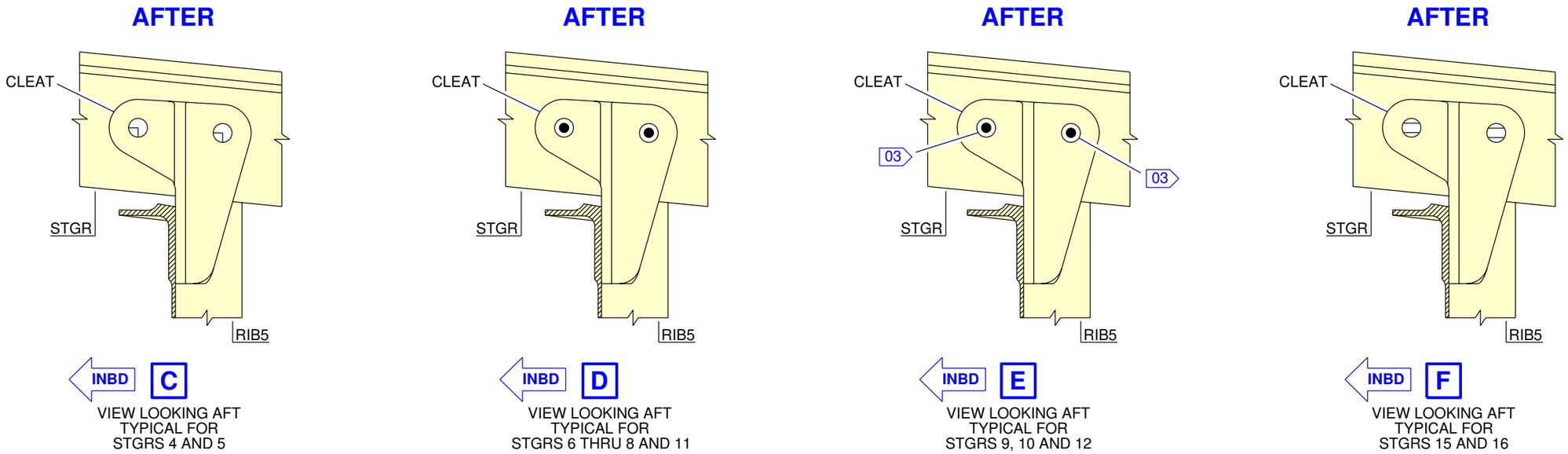
N_SB_571208_7_BDAC_01_03

Figure A-UBDAC - Sheet 01
Modification of the Cleat to Stringer Webs RIB 5



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 003, 010




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER | | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | | | | | MIN | MAX | | |
| ⊖ | – | 6 | EN6115V4Y5 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊖ | – | 8 | EN6115V4Y7 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

03 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

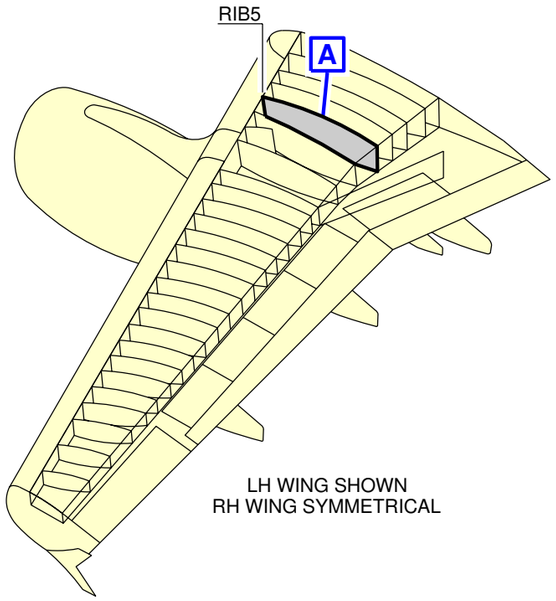
N_SB_571208_7_BDAC_02_04

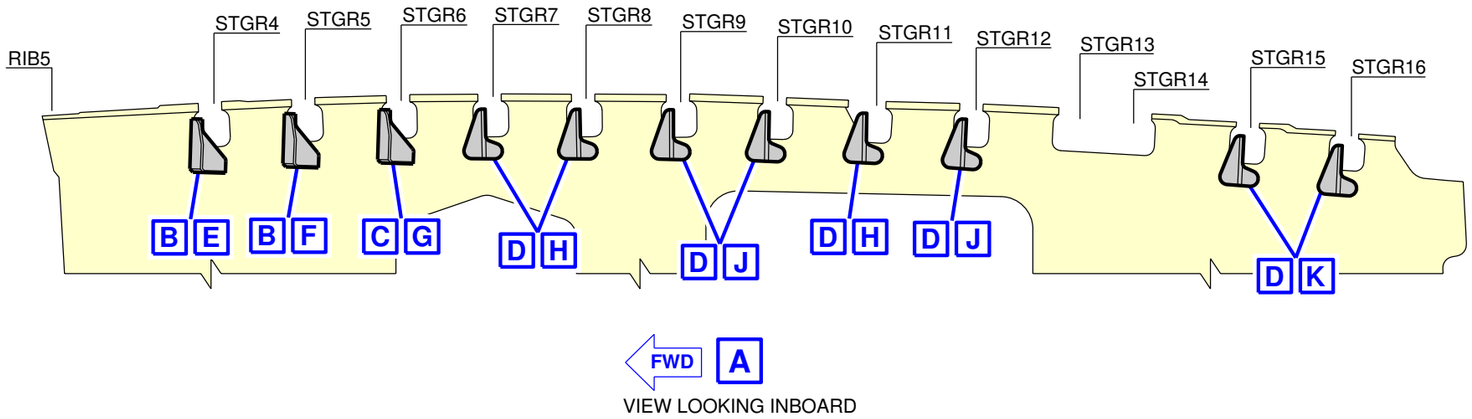
Figure A-UBDAC - Sheet 02
Modification of the Cleat to Stringer Webs RIB 5

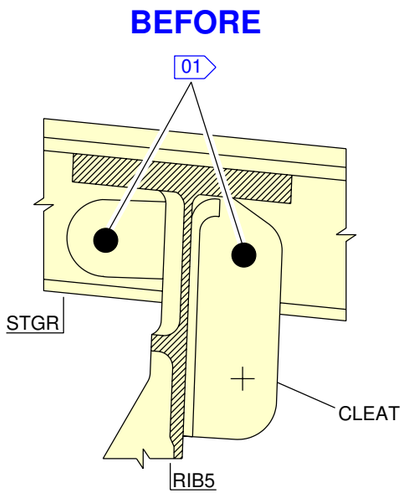


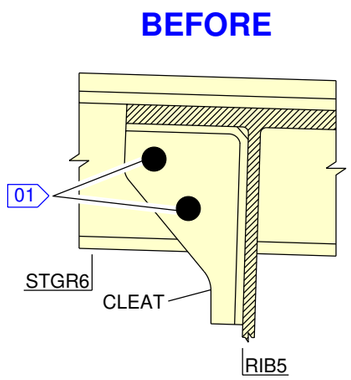
Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

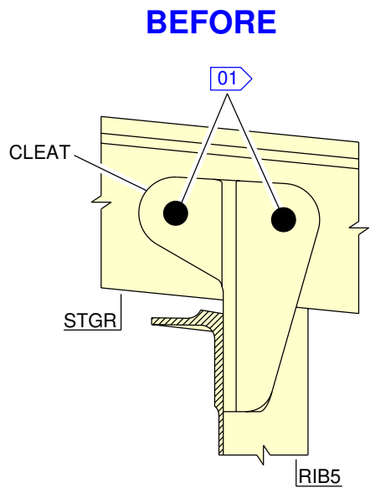
**CONF 004, 013




| FASTENER TABLE | |
|---|---|
| ● | REMOVE AND DISCARD |
| + | FOR REFERENCE ONLY |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

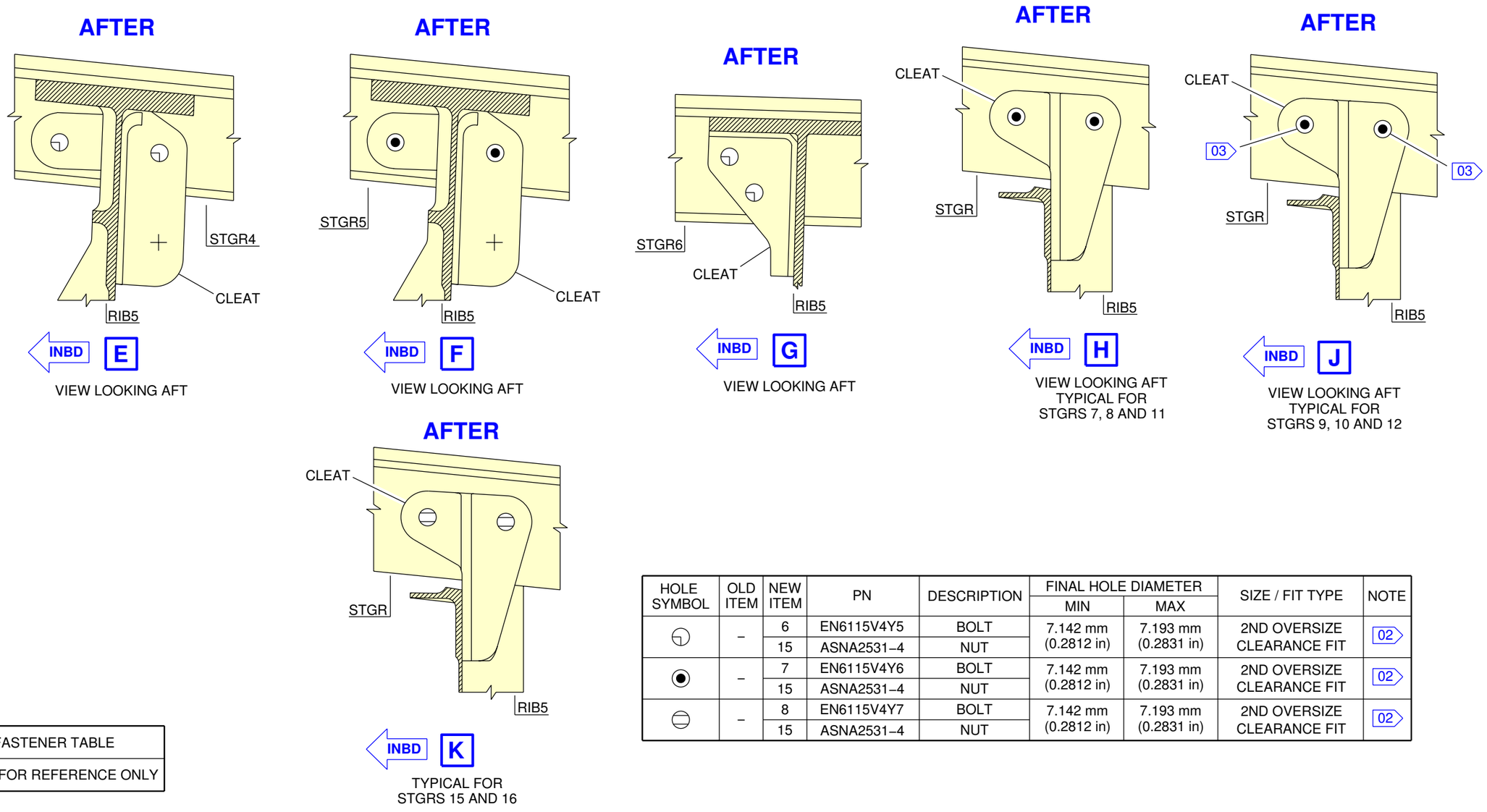
N_SB_571208_7_BDAD_01_04

Figure A-UBDAD - Sheet 01
Modification of the Cleat to Stringer Webs RIB 5



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 004, 013




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER | | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | | | | | MIN | MAX | | |
| ◶ | – | 6 | EN6115V4Y5 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊖ | – | 8 | EN6115V4Y7 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |

| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

03 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

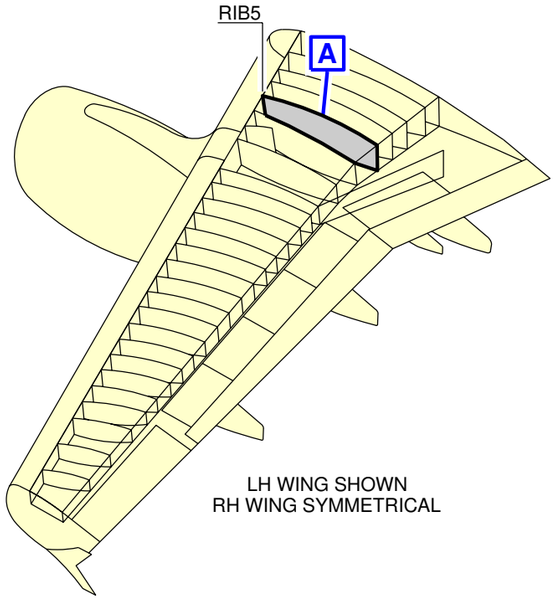
N_SB_571208_7_BDAD_02_04

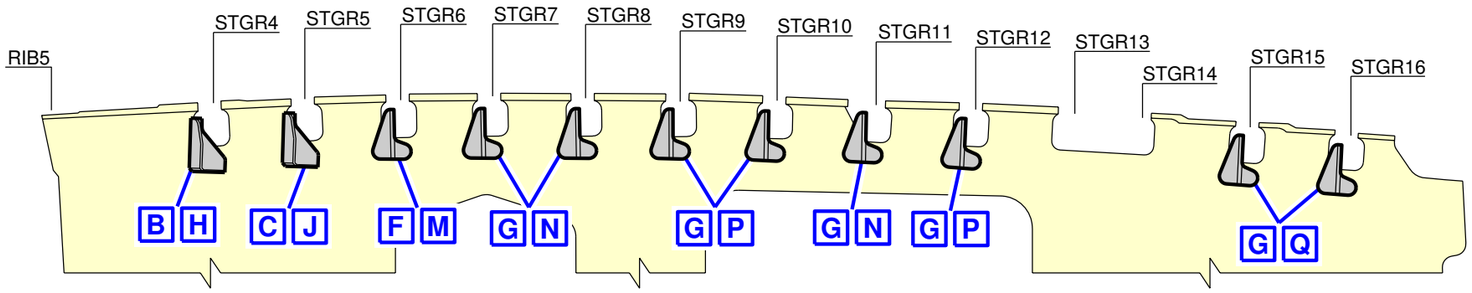
Figure A-UBDAD - Sheet 02
Modification of the Cleat to Stringer Webs RIB 5

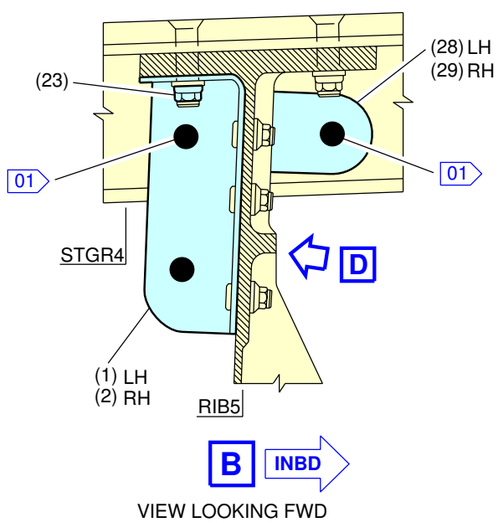


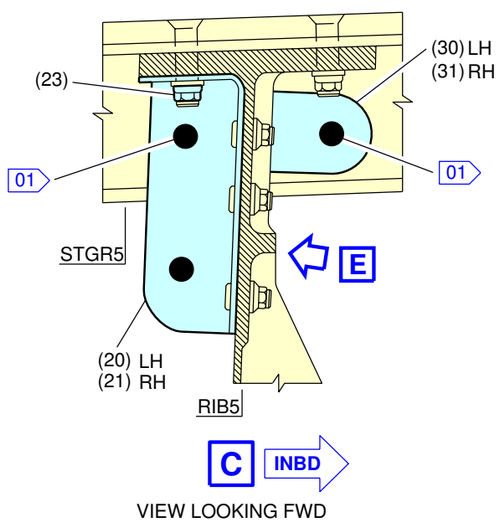
Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

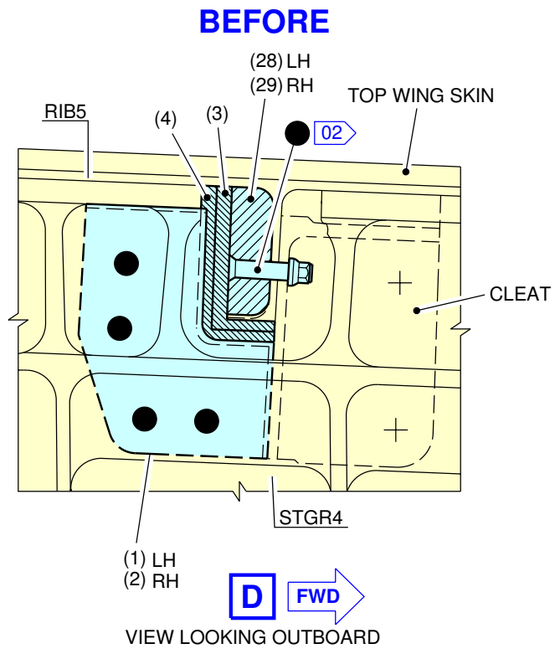
**CONF 005, 011




| FASTENER TABLE | |
|---|---|
| ● | REMOVE AND DISCARD |
| + | FOR REFERENCE ONLY |

**NOTE:**

01 THE TWO SIDES OF THE CLEAT MUST BE SUFFICIENTLY CLAMPED NEAR TO THE HOLES AT ALL TIMES DURING OVERSIZING OPERATION.

02 FOAM CARRIER, ITEM (1) LH, ITEM (2) RH, AND FOAM SEALANT, ITEM (3) AND ITEM (4), MUST BE REMOVED TO GET ACCESS TO THE FASTENER INSTALLED THROUGH THE METALLIC PACKER.

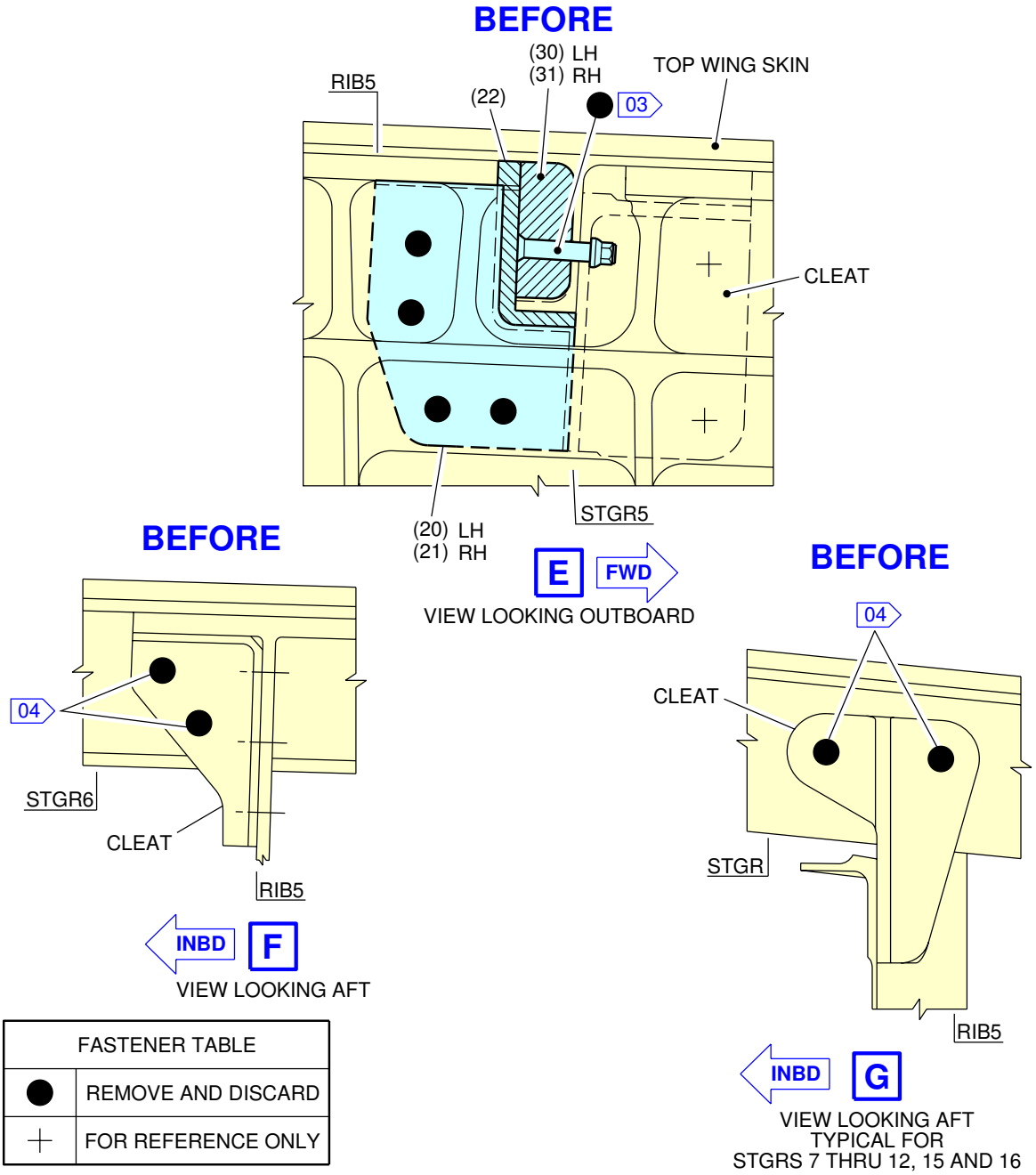
N_SB_571208_7_BDAE_01_11

Figure A-UBDAE - Sheet 01
Modification of the Cleat to Stringer Webs RIB 5



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 005, 011




| FASTENER TABLE | |
|---|---|
| ● | REMOVE AND DISCARD |
| + | FOR REFERENCE ONLY |

**NOTE:**

03 FOAM CARRIER, ITEM (20) LH, ITEM (21) RH, AND FOAM SEALANT, ITEM (22), MUST BE REMOVED TO GET ACCESS TO THE FASTENER INSTALLED THROUGH THE METALLIC PACKER.

04 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

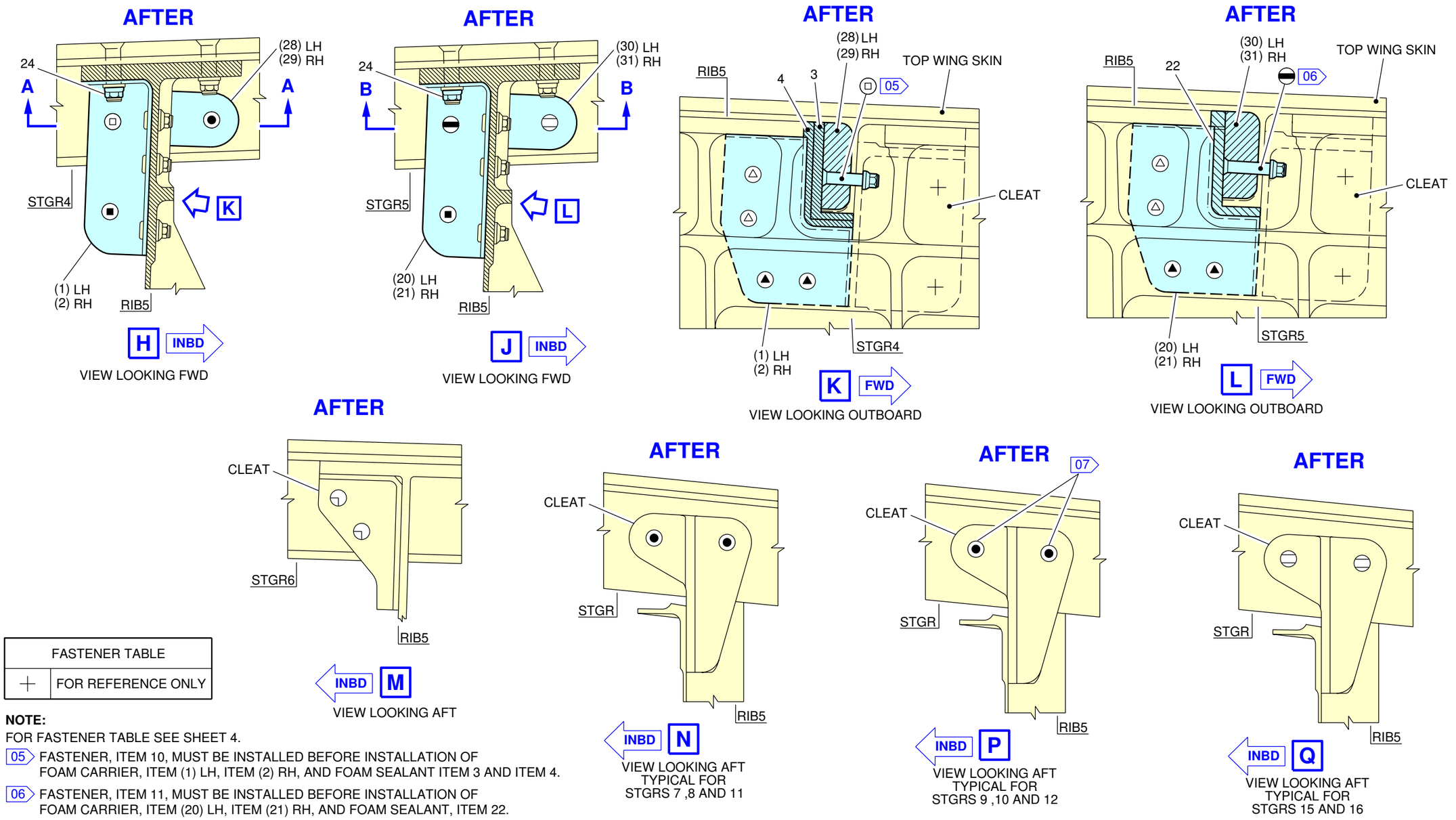
N_SB_571208_7_BDAE_02_09

Figure A-UBDAE - Sheet 02
Modification of the Cleat to Stringer Webs RIB 5



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 005, 011




| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

FOR FASTENER TABLE SEE SHEET 4.

05 FASTENER, ITEM 10, MUST BE INSTALLED BEFORE INSTALLATION OF FOAM CARRIER, ITEM (1) LH, ITEM (2) RH, AND FOAM SEALANT ITEM 3 AND ITEM 4.

06 FASTENER, ITEM 11, MUST BE INSTALLED BEFORE INSTALLATION OF FOAM CARRIER, ITEM (20) LH, ITEM (21) RH, AND FOAM SEALANT, ITEM 22.

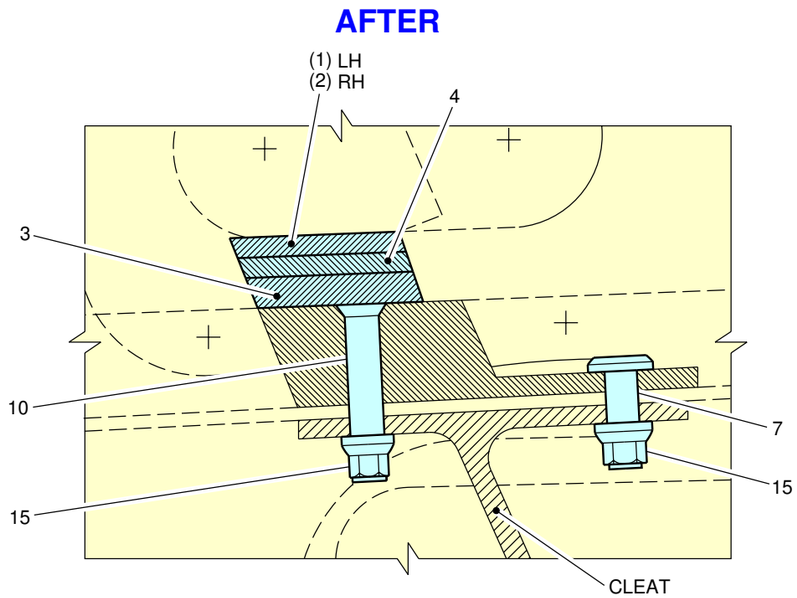
07 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

Figure A-UBDAE - Sheet 03
Modification of the Cleat to Stringer Webs RIB 5

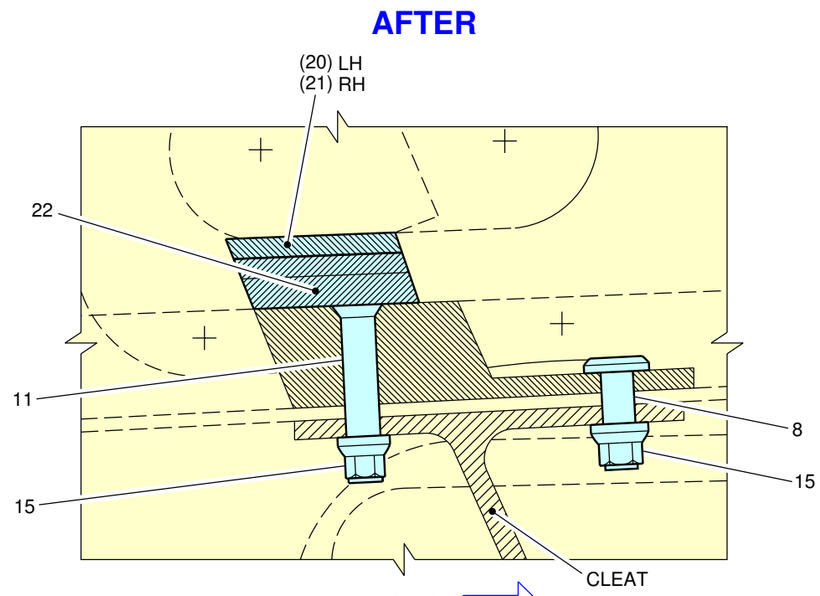


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 005, 011




A - A INBD




B - B INBD

| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER MIN | FINAL HOLE DIAMETER MAX | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | – | 6 | EN6115V4Y5 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 08 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 08 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 8 | EN6115V4Y7 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 08 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 10 | EN6114V4Y17 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 08 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 11 | EN6114V4Y18 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 08 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 17 | EN6115V4–3 | BOLT | – | – | CLEARANCE FIT | 08 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 18 | EN6115V3–4 | BOLT | – | – | CLEARANCE FIT | – |
| | | 27 | ASNA2531–3 | NUT | | | | |
| | – | 19 | EN6115V3–5 | BOLT | – | – | CLEARANCE FIT | – |
| | | 27 | ASNA2531–3 | NUT | | | | |

| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

08 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

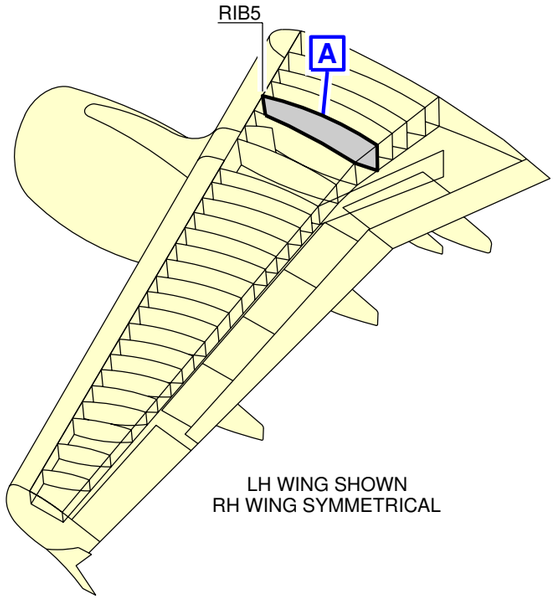
N_SB_571208_7_BDAE_04_07

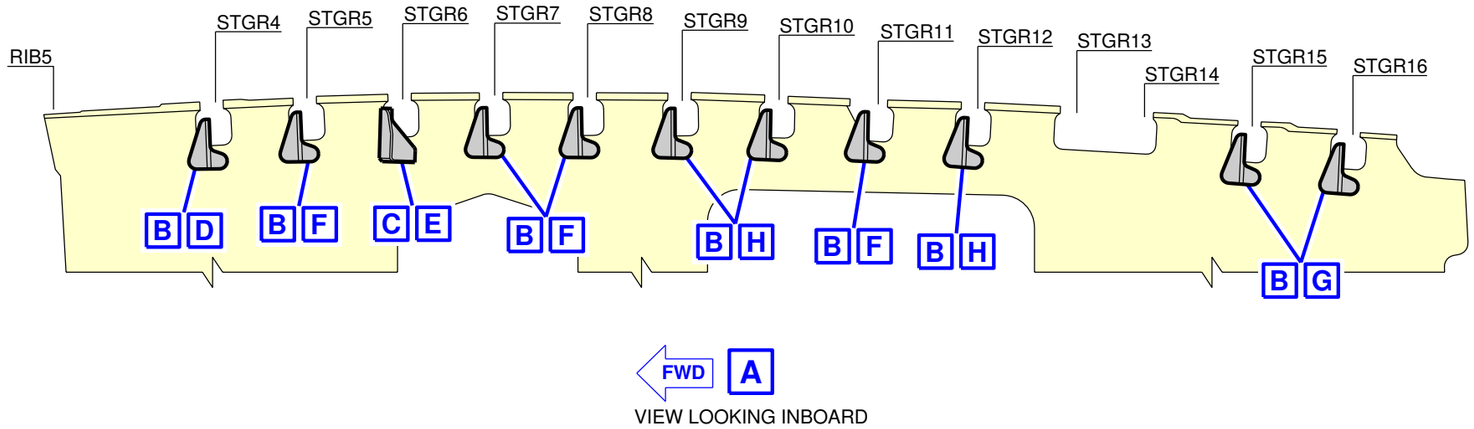
Figure A-UBDAE - Sheet 04
Modification of the Cleat to Stringer Webs RIB 5



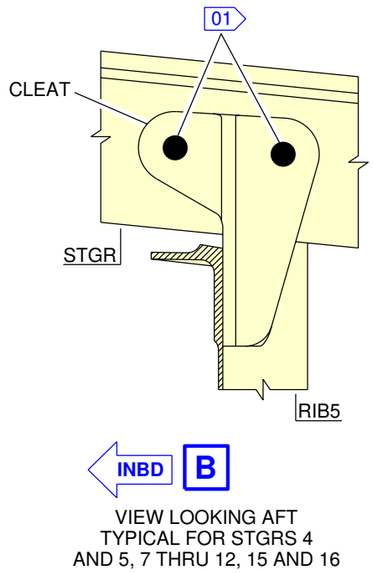
Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 006, 017

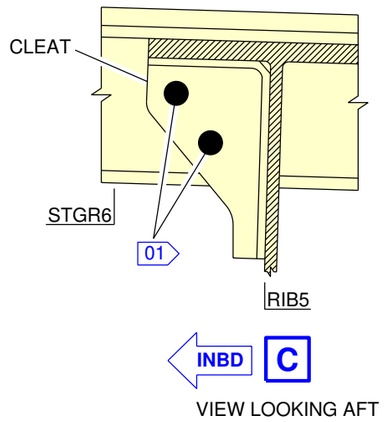



**BEFORE**




**BEFORE**




| FASTENER TABLE | |
|---|---|
| ● | REMOVE AND DISCARD |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

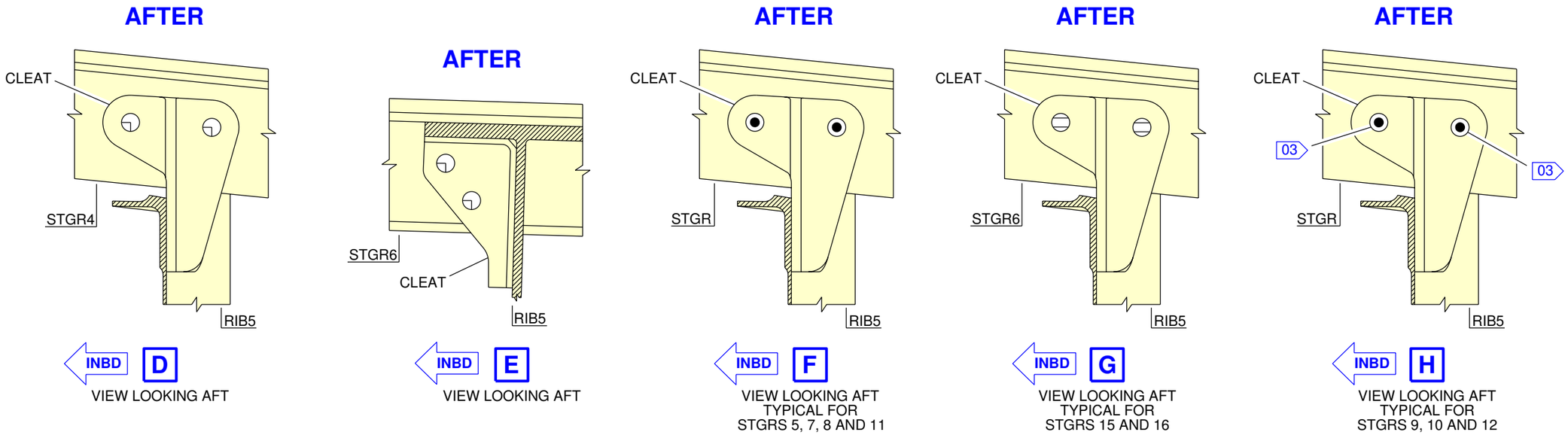
N_SB_571208_7_BDAF_01_04

Figure A-UBDAF - Sheet 01
Modification of the Cleat to Stringer Webs RIB 5



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 006, 017




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER | | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | | | | | MIN | MAX | | |
| ⊖ | – | 6 | EN6115V4Y5 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊖ | – | 8 | EN6115V4Y7 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

03 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

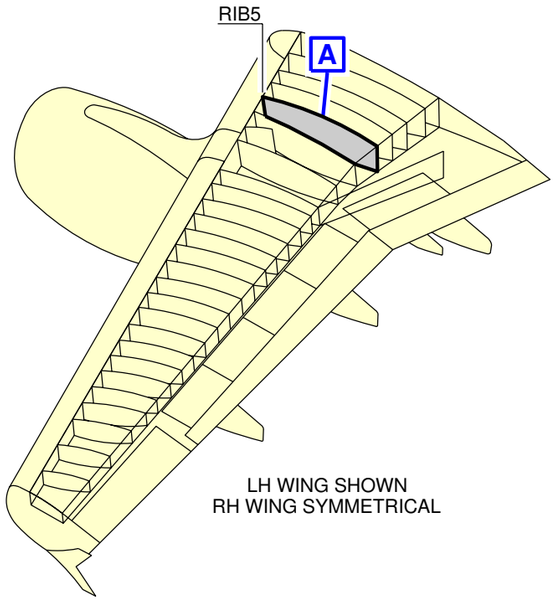
N_SB_571208_7_BDAF_02_05

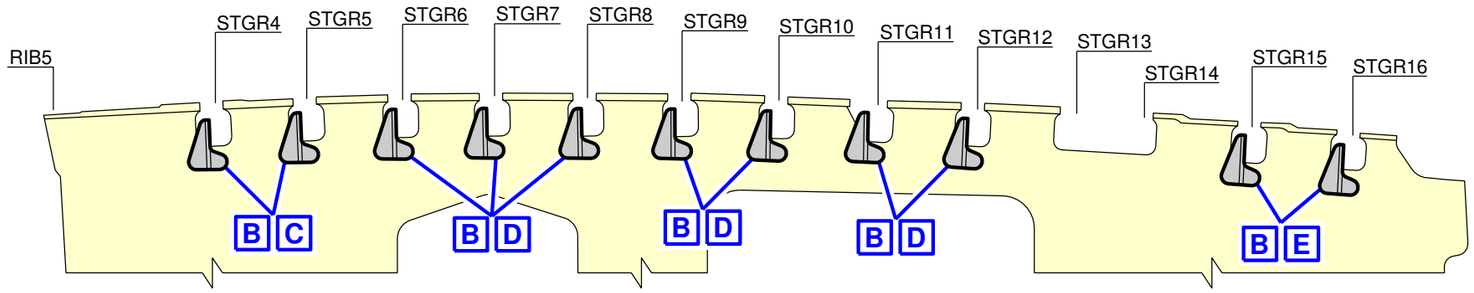
Figure A-UBDAF - Sheet 02
Modification of the Cleat to Stringer Webs RIB 5



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

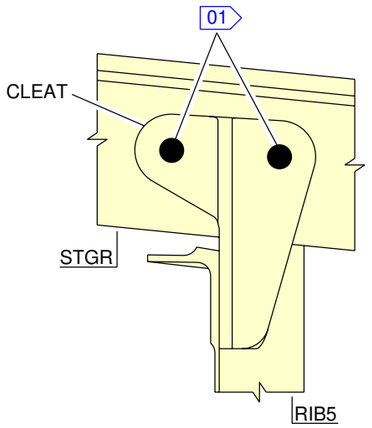
**CONF 007, 012



VIEW LOOKING INBOARD

## BEFORE



TYPICAL FOR
STGRS 4 THRU 12, 15 AND 16

| | FASTENER TABLE | NOTE |
|---|---|---|
| ● | REMOVE AND DISCARD | 01 |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

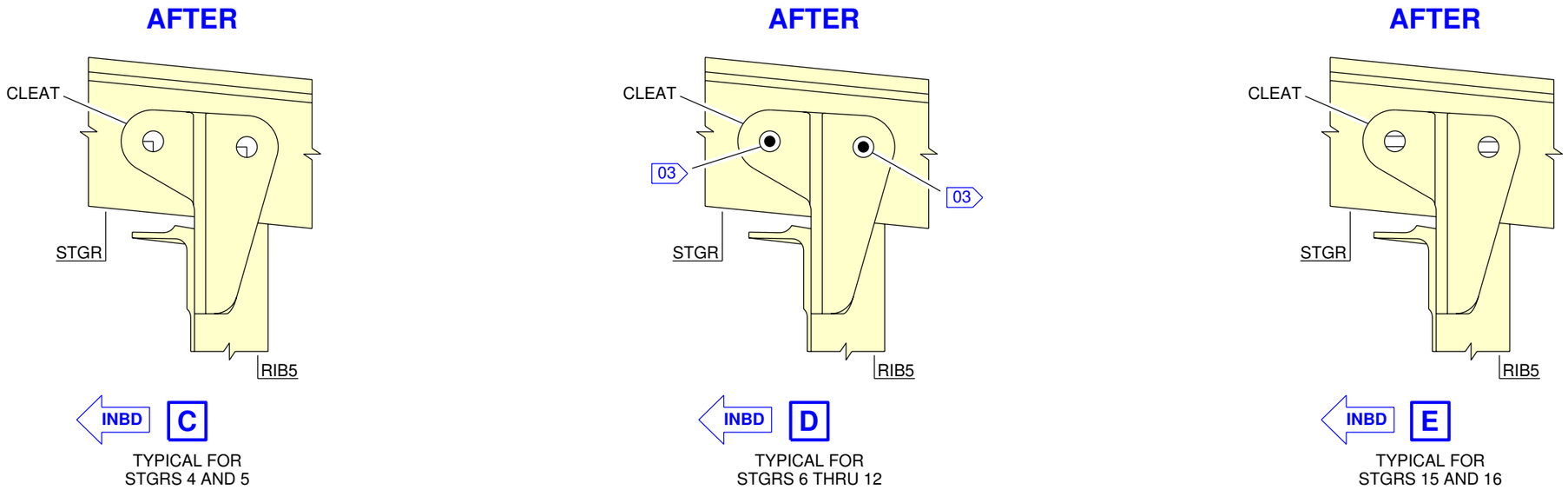
N_SB_571208_7_BDAG_01_03

Figure A-UBDAG - Sheet 01
Modification of the Cleat to Stringer Webs RIB 5



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 007, 012




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER MIN | FINAL HOLE DIAMETER MAX | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | – | 6 | EN6115V4Y5 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 8 | EN6115V4Y7 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

03 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

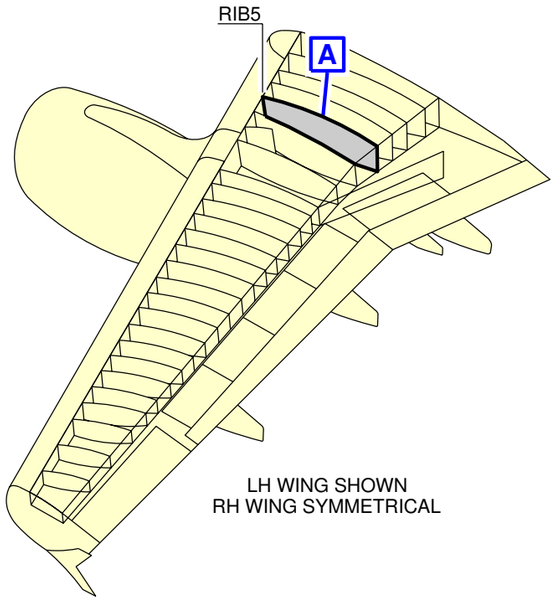
N_SB_571208_7_BDAG_02_03

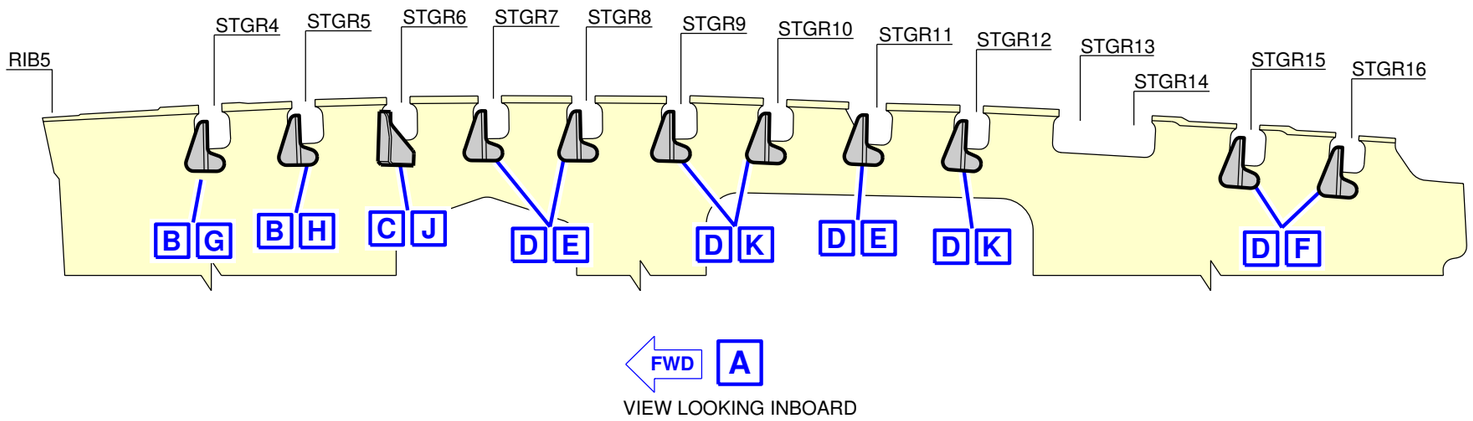
Figure A-UBDAG - Sheet 02
Modification of the Cleat to Stringer Webs RIB 5

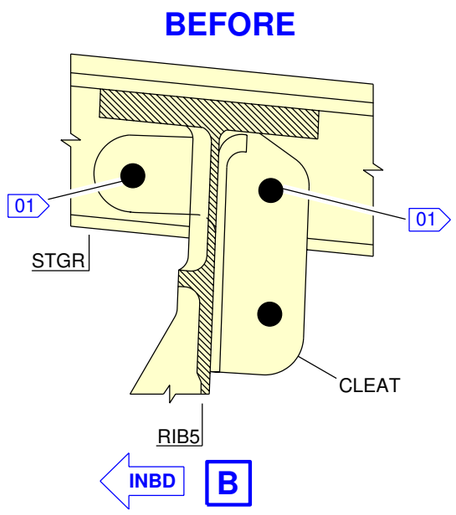


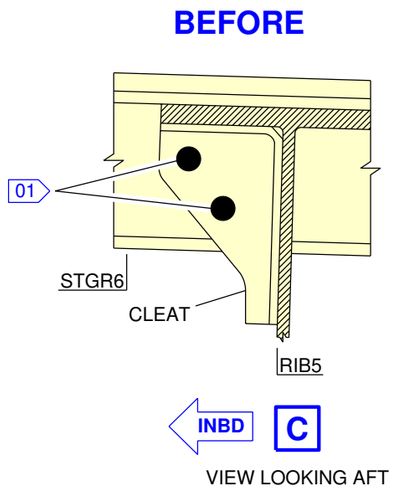
Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

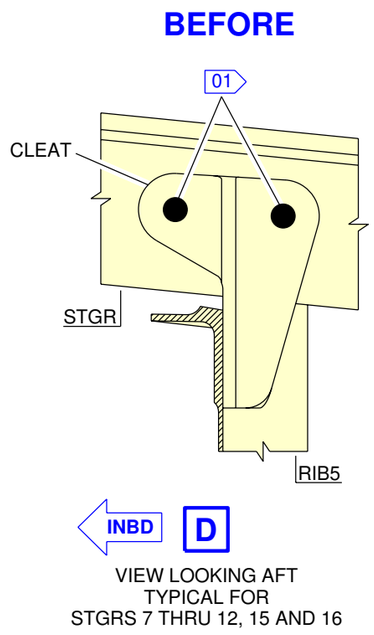
**CONF 008, 014




| FASTENER TABLE | |
|---|---|
| ● | REMOVE AND DISCARD |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

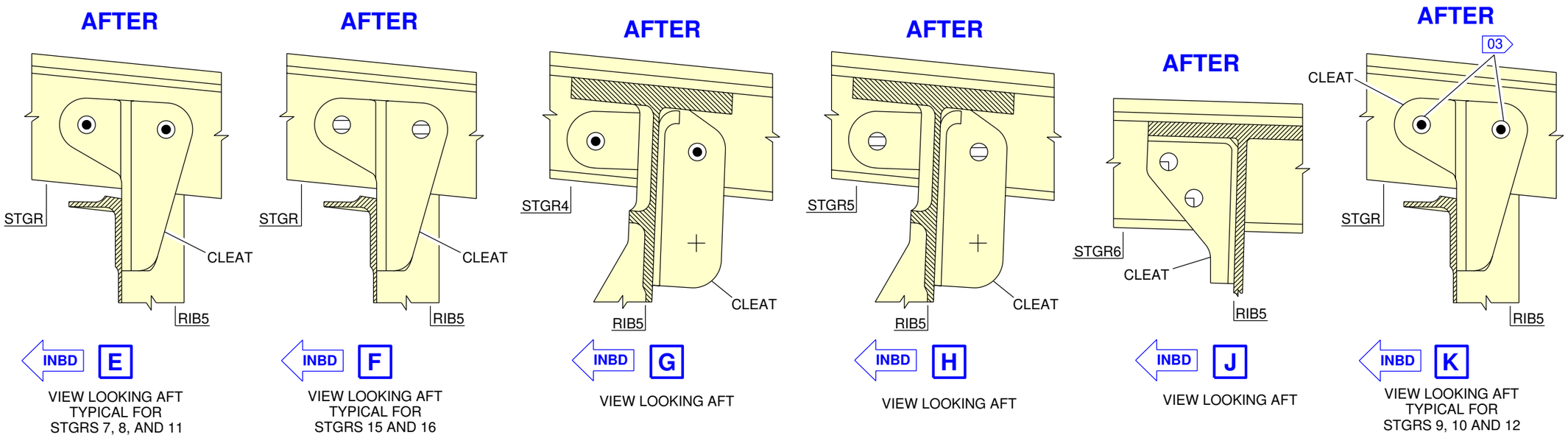
N_SB_571208_7_BDAH_01_04

Figure A-UBDAH - Sheet 01
Modification of the Cleat to Stringer Webs RIB 5



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 008, 014




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER MIN | FINAL HOLE DIAMETER MAX | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| ◶ | – | 6 | EN6115V4Y5 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊖ | – | 8 | EN6115V4Y7 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |

| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

03 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

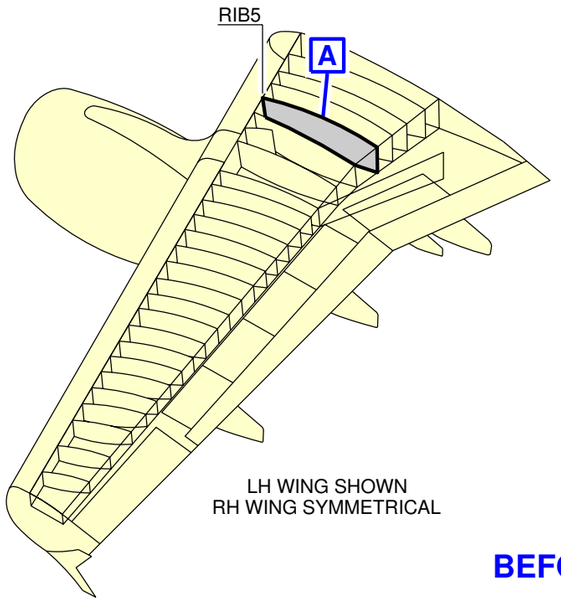
N_SB_571208_7_BDAH_02_05

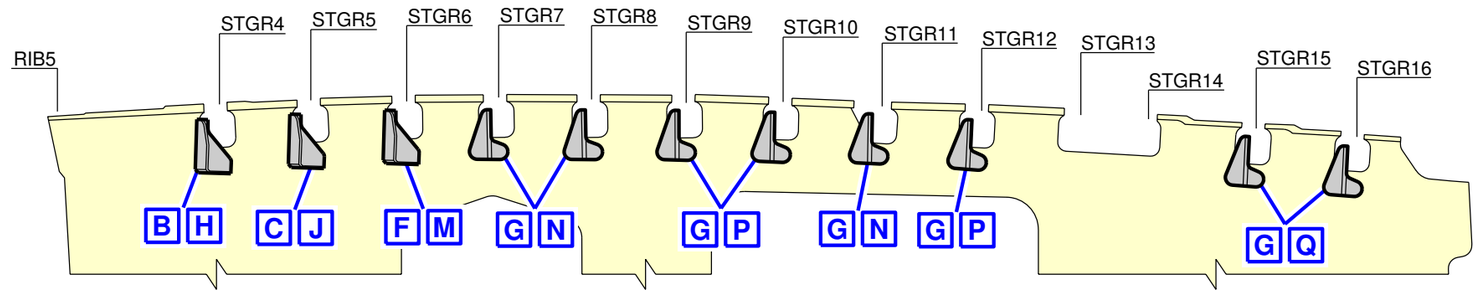
Figure A-UBDAH - Sheet 02
Modification of the Cleat to Stringer Webs RIB 5

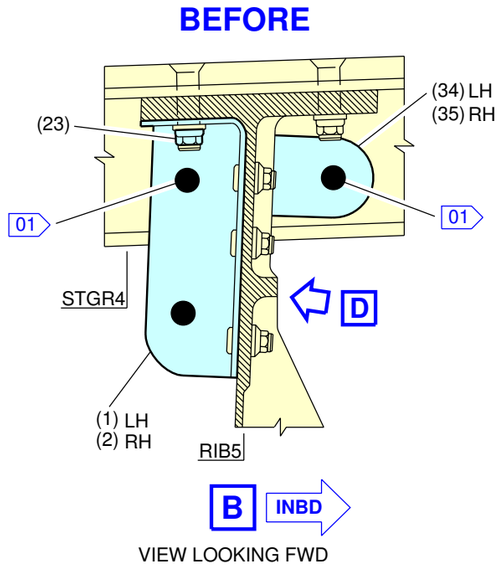


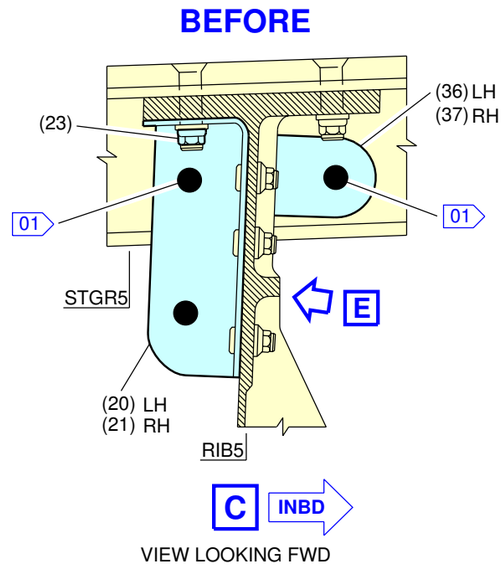
Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

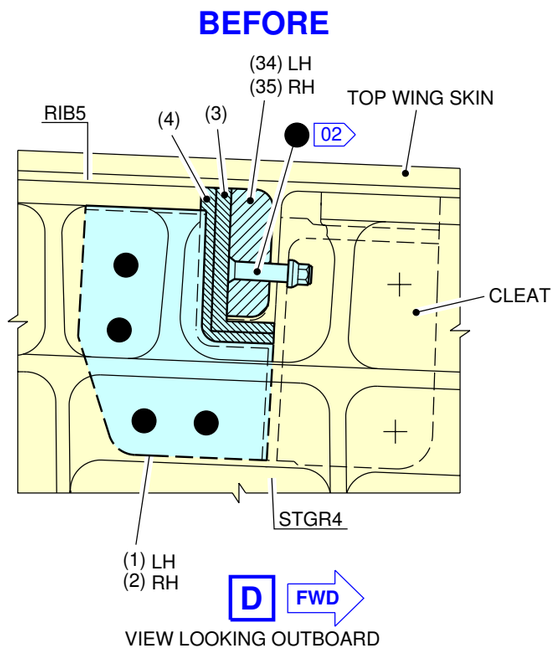
**CONF 009, 015




| FASTENER TABLE | |
|---|---|
| ● | REMOVE AND DISCARD |
| + | FOR REFERENCE ONLY |

**NOTE:**

01 THE TWO SIDES OF THE CLEAT MUST BE SUFFICIENTLY CLAMPED NEAR TO THE HOLES AT ALL TIMES DURING OVERSIZING OPERATION.

02 FOAM CARRIER, ITEM (1) LH, ITEM (2) RH, AND FOAM SEALANT, ITEM (3) AND ITEM (4), MUST BE REMOVED TO GET ACCESS TO THE FASTENER INSTALLED THROUGH THE METALLIC PACKER.

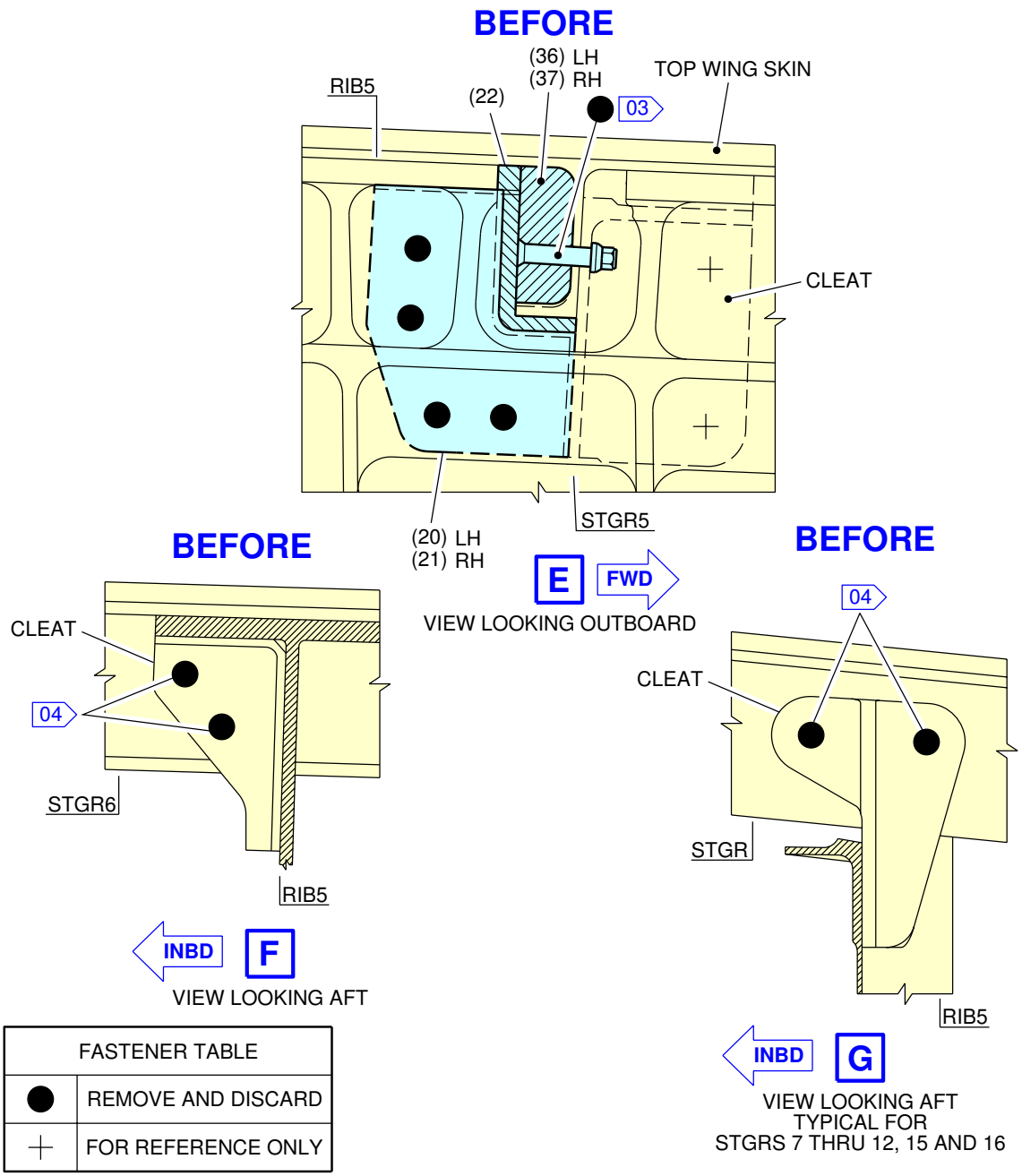
N_SB_571208_7_BDAJ_01_11

Figure A-UBDAJ - Sheet 01
Modification of the Cleat to Stringer Webs RIB 5



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 009, 015




| FASTENER TABLE | |
|---|---|
| ● | REMOVE AND DISCARD |
| + | FOR REFERENCE ONLY |

**NOTE:**

03 FOAM CARRIER, ITEM (20) LH, ITEM (21) RH, AND FOAM SEALANT, ITEM (22), MUST BE REMOVED TO GET ACCESS TO THE FASTENER INSTALLED THROUGH THE METALLIC PACKER.

04 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

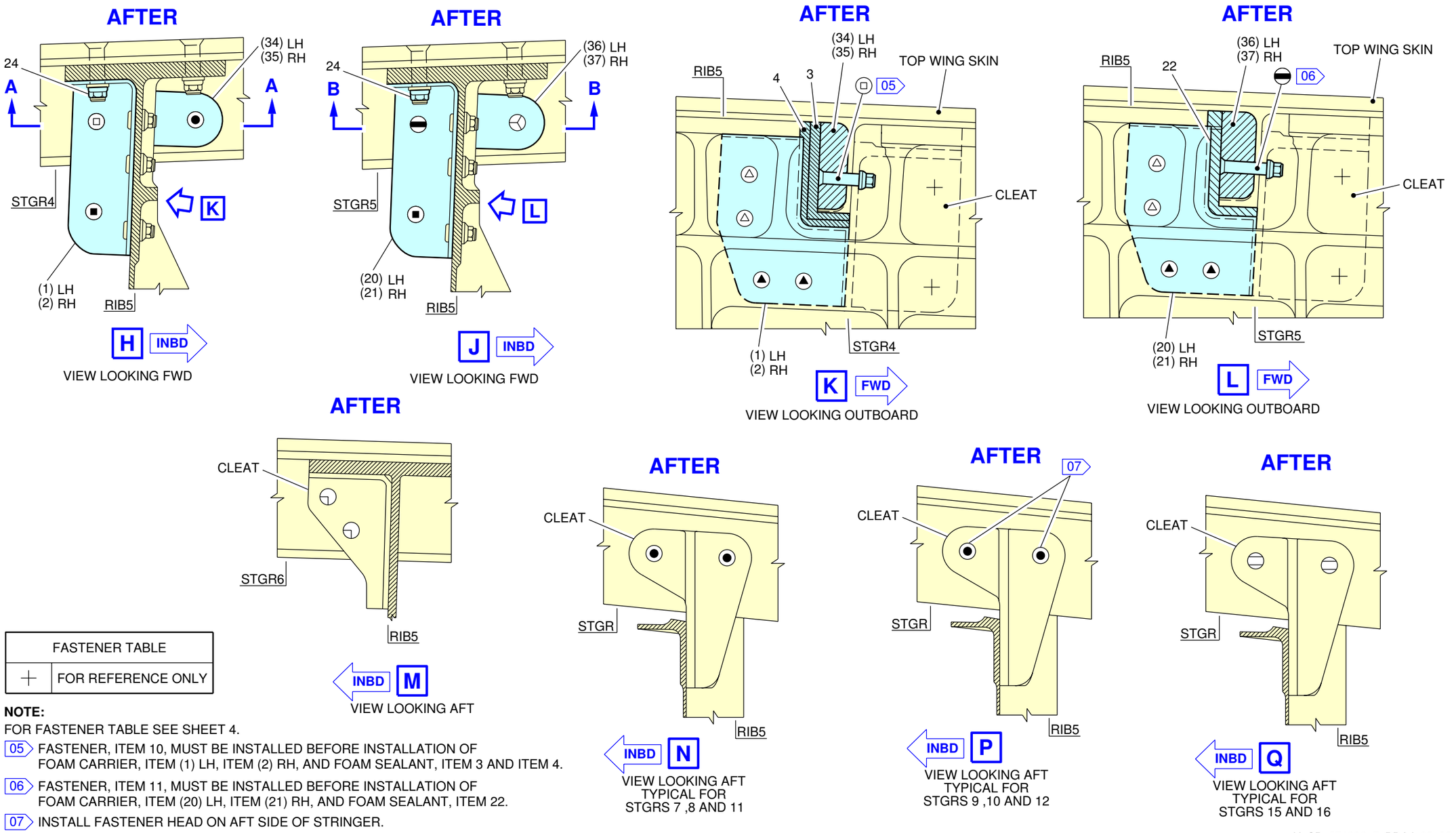
N_SB_571208_7_BDAJ_02_10

Figure A-UBDAJ - Sheet 02
Modification of the Cleat to Stringer Webs RIB 5



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 009, 015




| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

FOR FASTENER TABLE SEE SHEET 4.

05 FASTENER, ITEM 10, MUST BE INSTALLED BEFORE INSTALLATION OF FOAM CARRIER, ITEM (1) LH, ITEM (2) RH, AND FOAM SEALANT, ITEM 3 AND ITEM 4.

06 FASTENER, ITEM 11, MUST BE INSTALLED BEFORE INSTALLATION OF FOAM CARRIER, ITEM (20) LH, ITEM (21) RH, AND FOAM SEALANT, ITEM 22.

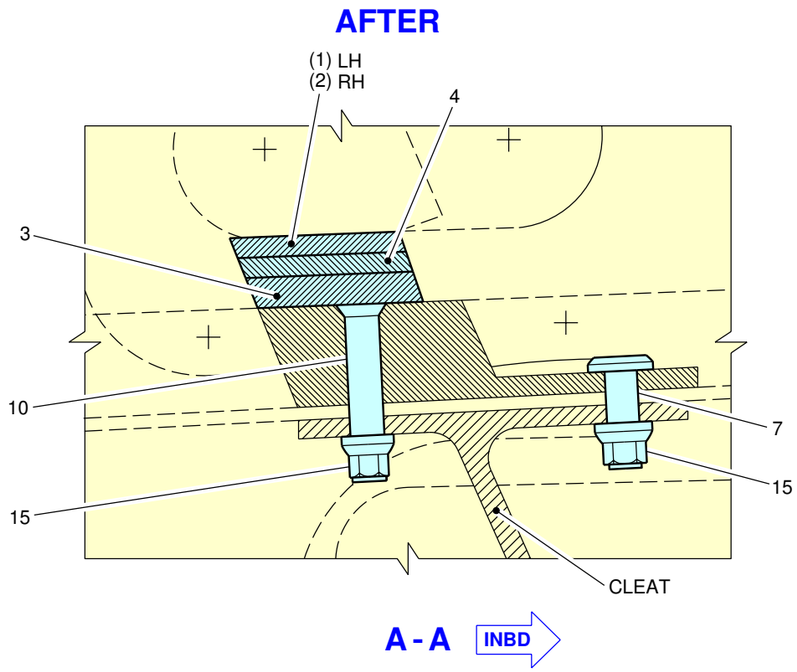
07 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

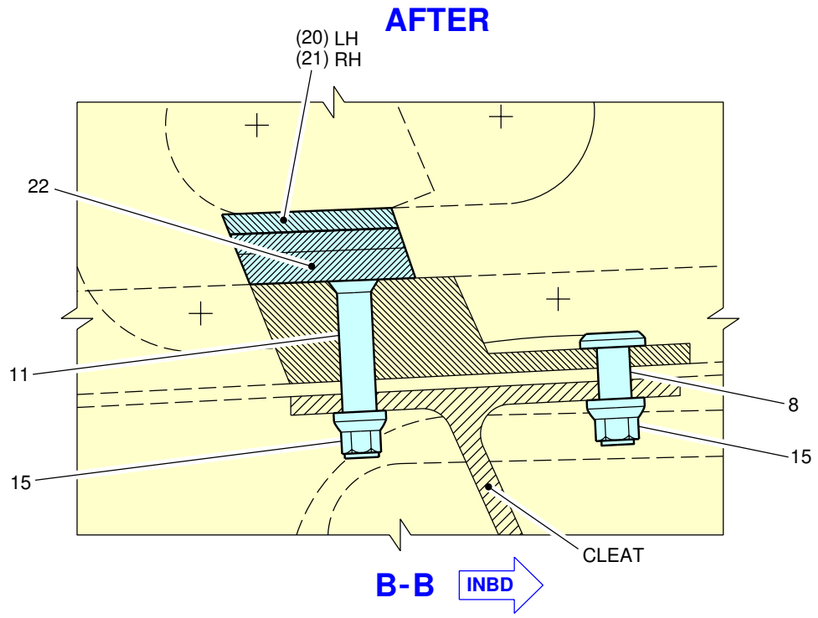
Figure A-UBDAJ - Sheet 03
Modification of the Cleat to Stringer Webs RIB 5



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 009, 015




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER MIN | FINAL HOLE DIAMETER MAX | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | – | 6 | EN6115V4Y5 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 08 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 08 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 8 | EN6115V4Y7 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 08 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 9 | EN6115V4Y8 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 08 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 10 | EN6114V4Y17 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 08 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 11 | EN6114V4Y18 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 08 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 17 | EN6115V4–3 | BOLT | – | – | CLEARANCE FIT | 08 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 18 | EN6115V3–4 | BOLT | – | – | CLEARANCE FIT | – |
| | | 27 | ASNA2531–3 | NUT | | | | |
| | – | 19 | EN6115V3–5 | BOLT | – | – | CLEARANCE FIT | – |
| | | 27 | ASNA2531–3 | NUT | | | | |

N_SB_571208_7_BDAJ_04_07

| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

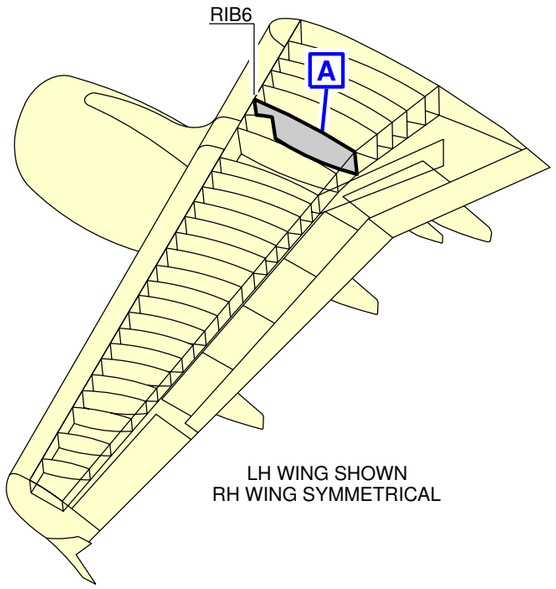
08 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

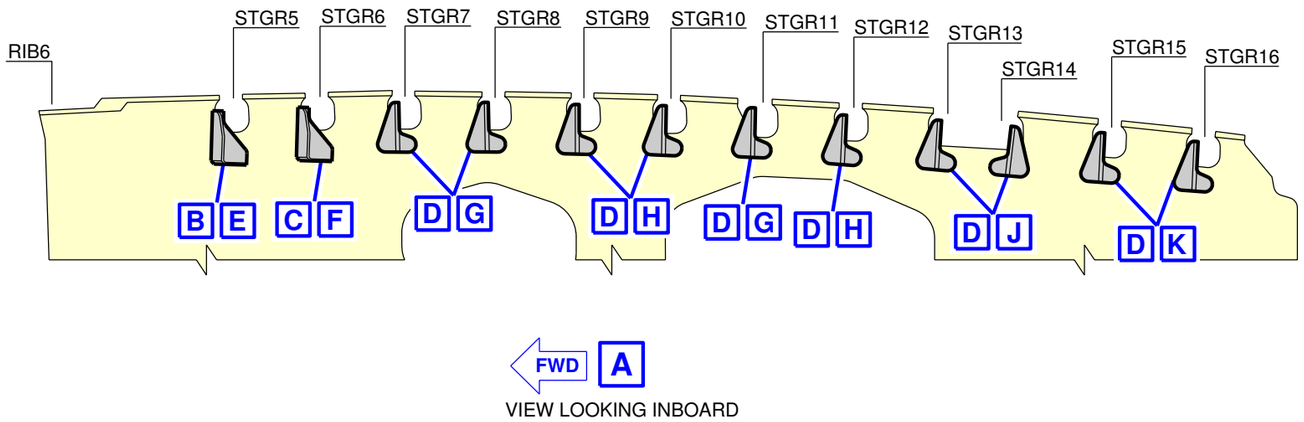
Figure A-UBDAJ - Sheet 04
Modification of the Cleat to Stringer Webs RIB 5

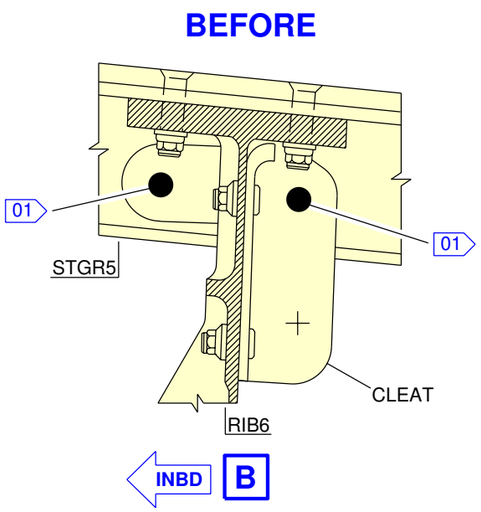


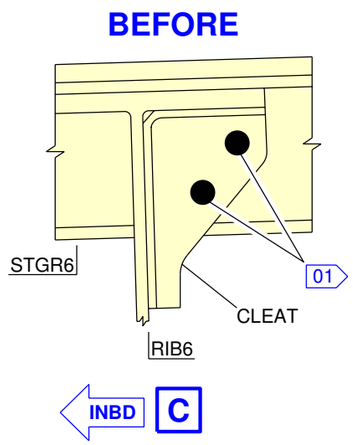
Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

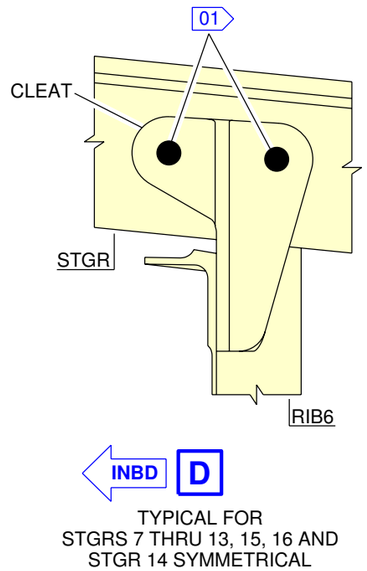
**CONF 001




| FASTENER TABLE | |
|---|---|
| ● | REMOVE AND DISCARD |
| + | FOR REFERENCE ONLY |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

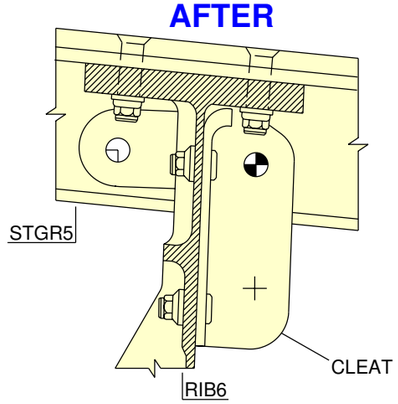
N_SB_571208_7_BEAA_01_04

Figure A-UBEAA - Sheet 01
Modification of the Cleat to Stringer Webs RIB 6

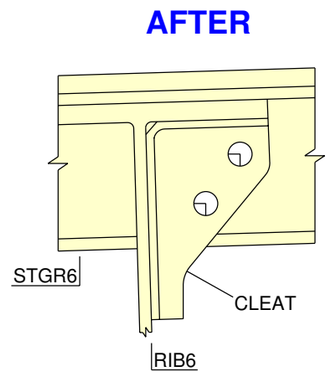


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

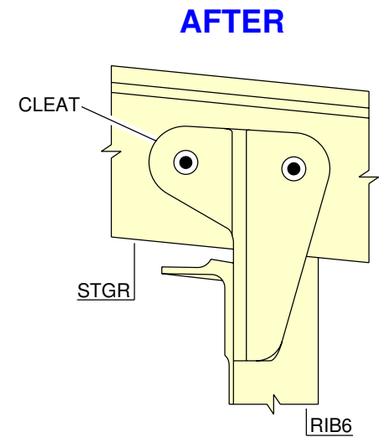
**CONF 001




INBD E

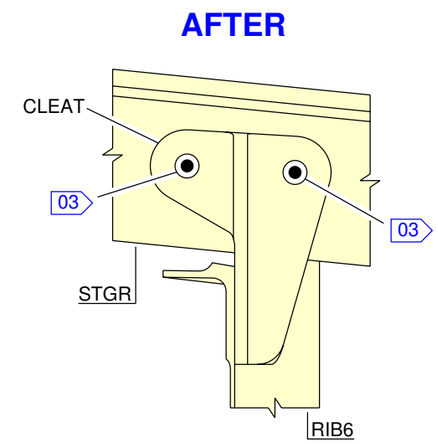



INBD F



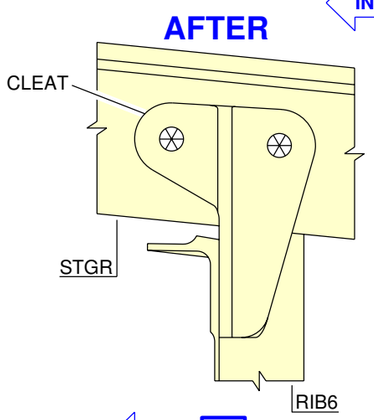

INBD G

TYPICAL FOR
STGRS 7, 8 AND 11



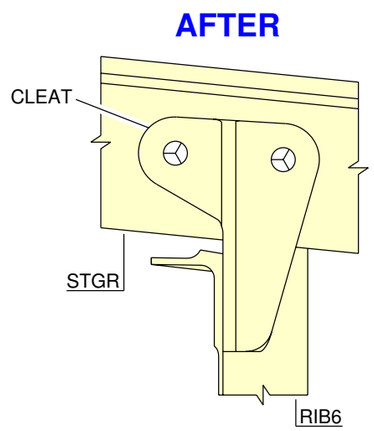

INBD H

TYPICAL FOR
STGRS 9, 10 AND 12




INBD J

STGR 13 SHOWN
STGR 14 SYMMETRICAL




INBD K

TYPICAL FOR
STGRS 15 AND 16

| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER | | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | | | | | MIN | MAX | | |
| ◐ | – | 4 | EN6115V3A7 | BOLT | 5.555 mm (0.2187 in) | 5.606 mm (0.2207 in) | 2ND OVERSIZE CLEARANCE FIT | – |
| | | 14 | ASNA2531–3A | NUT | | | | |
| ◶ | – | 6 | EN6115V4Y5 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ◷ | – | 9 | EN6115V4Y8 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊛ | – | 13 | NAS1751–4L6 | BOLT | 7.01 mm (0.276 in) | 7.06 mm (0.277 in) | 1ST OVERSIZE CLEARANCE FIT | – |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

03 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

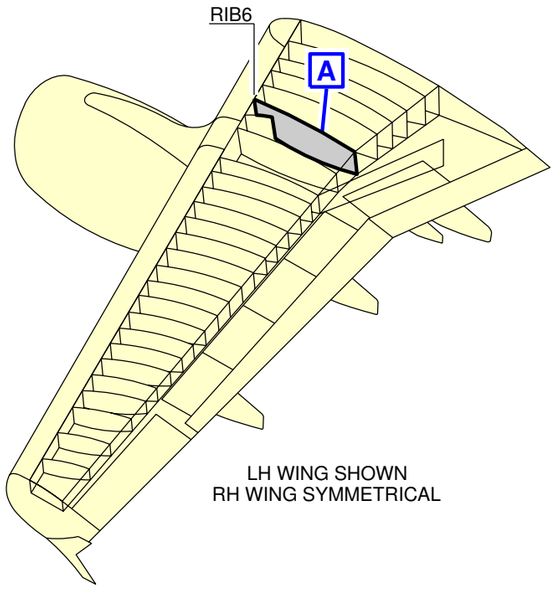
N_SB_571208_7_BEAA_02_06

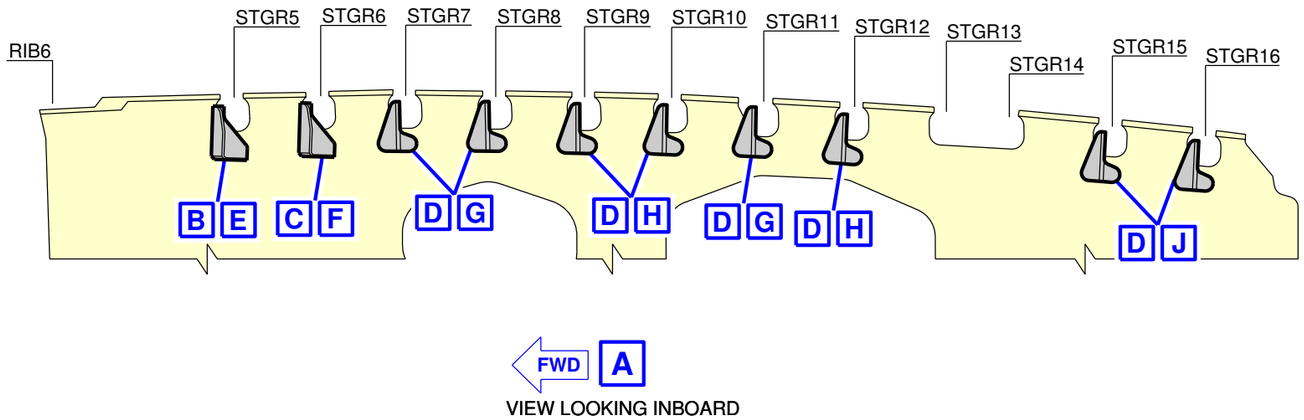
Figure A-UBEAA - Sheet 02
Modification of the Cleat to Stringer Webs RIB 6

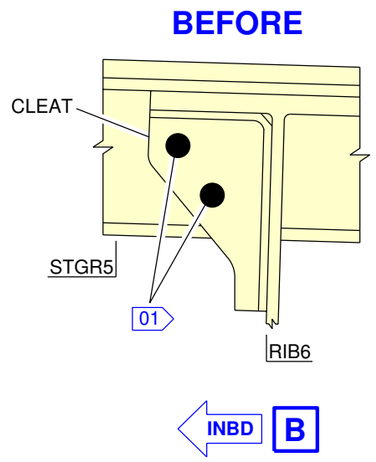


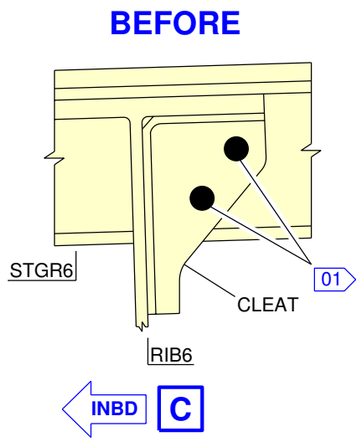
Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

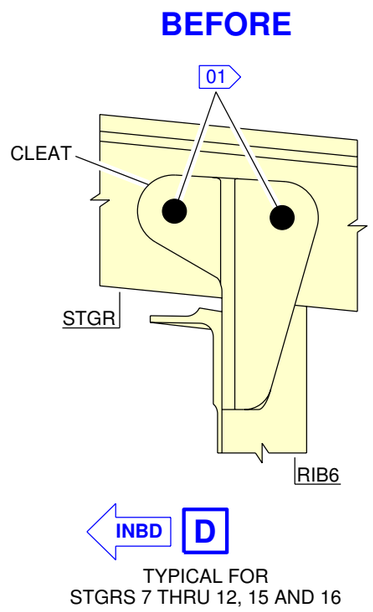
**CONF 002, 016




| FASTENER TABLE | |
|---|---|
| ● | REMOVE AND DISCARD |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

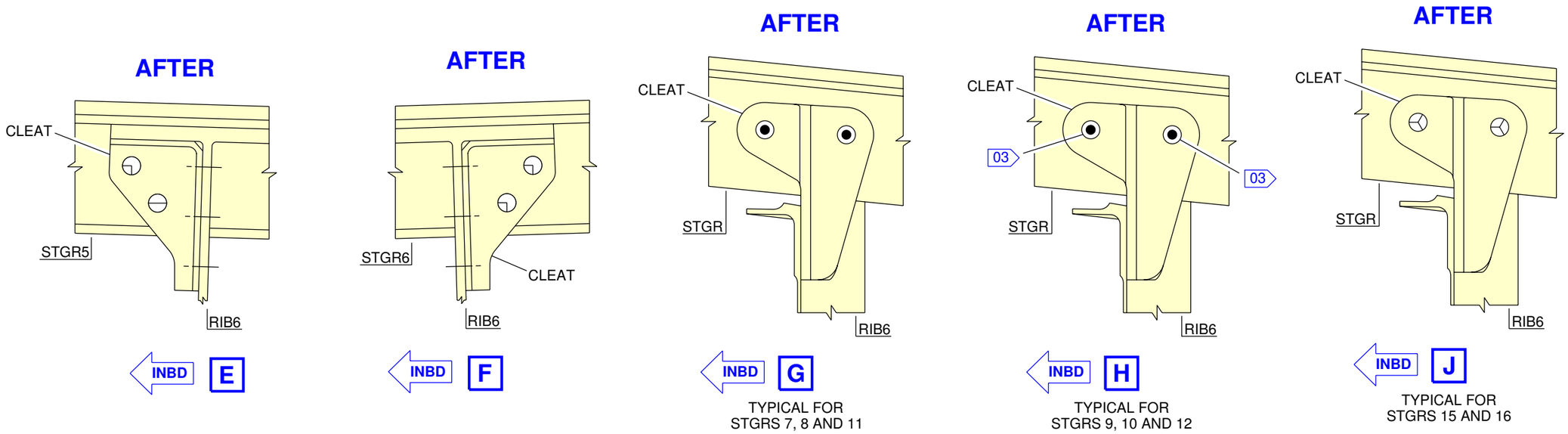
N_SB_571208_7_BEAB_01_04

Figure A-UBEAB - Sheet 01
Modification of the Cleat to Stringer Webs RIB 6



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 002, 016




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER MIN | FINAL HOLE DIAMETER MAX | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| ⊖ | – | 2 | EN6115V3A5 | BOLT | 5.555 mm (0.2187 in) | 5.606 mm (0.2207 in) | 2ND OVERSIZE CLEARANCE FIT | – |
| | | 14 | ASNA2531–3A | NUT | | | | |
| ◶ | – | 6 | EN6115V4Y5 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊘ | – | 9 | EN6115V4Y8 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

03 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

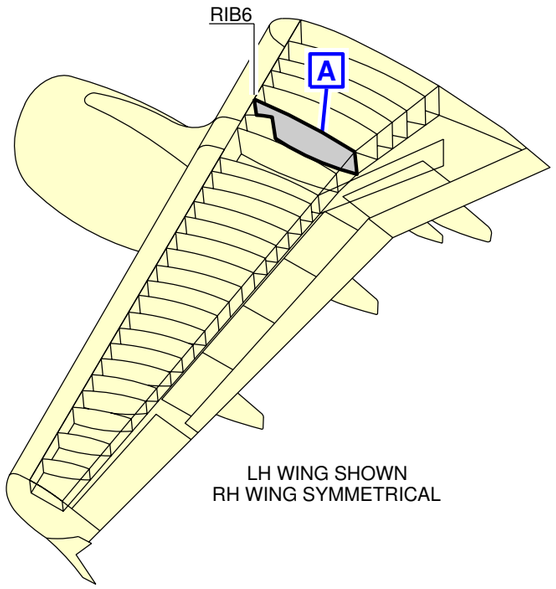
N_SB_571208_7_BEAB_02_04

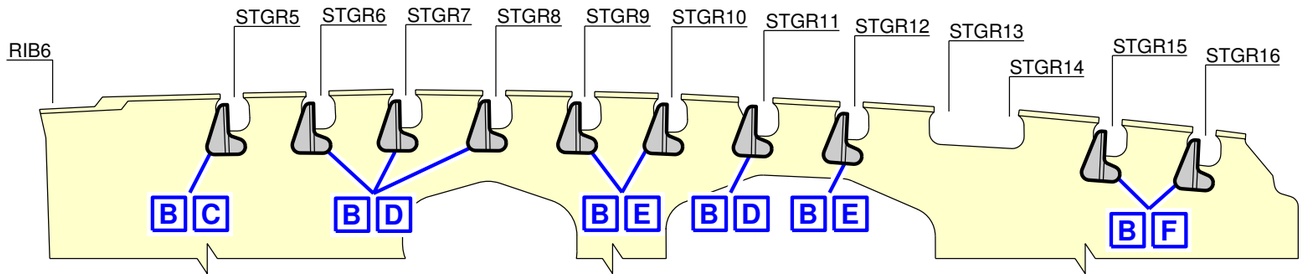
Figure A-UBEAB - Sheet 02
Modification of the Cleat to Stringer Webs RIB 6



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

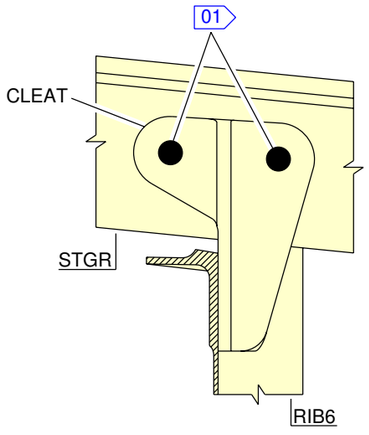
**CONF 003, 010



VIEW LOOKING INBOARD

**BEFORE**



VIEW LOOKING AFT
TYPICAL FOR
STGRS 5 THRU 12, 15 AND 16

| | FASTENER TABLE | NOTE |
|---|---|---|
| ● | REMOVE AND DISCARD | 01 |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

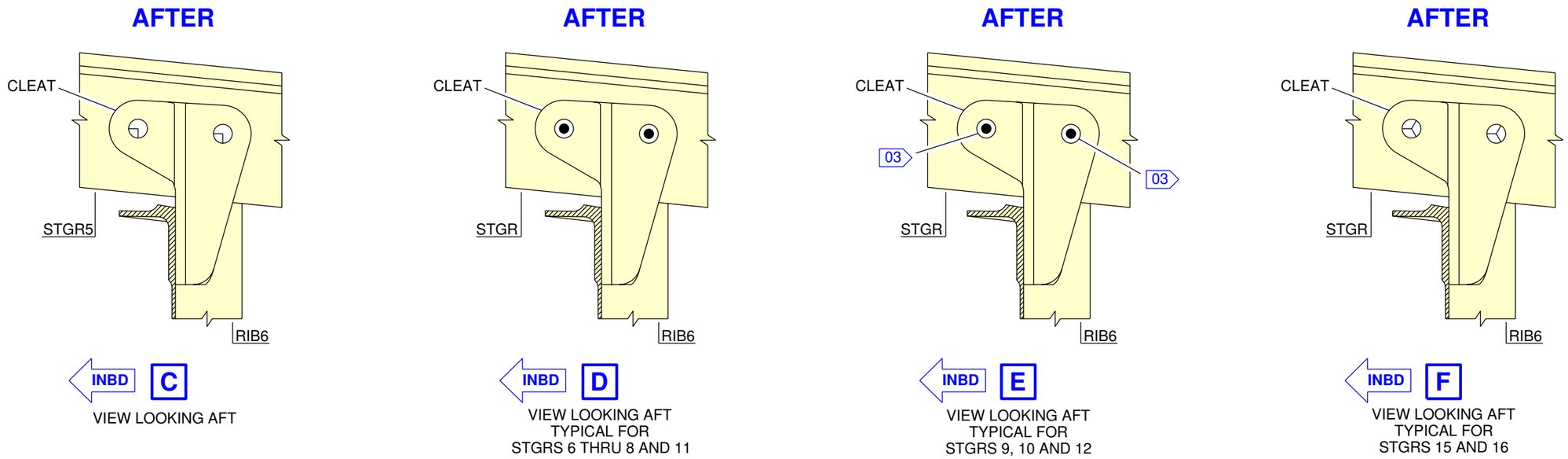
N_SB_571208_7_BEAC_01_03

Figure A-UBEAC - Sheet 01
Modification of the Cleat to Stringer Webs RIB 6



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 003, 010




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER | | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | | | | | MIN | MAX | | |
| ⊖ | – | 6 | EN6115V4Y5 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊘ | – | 9 | EN6115V4Y8 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

03 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

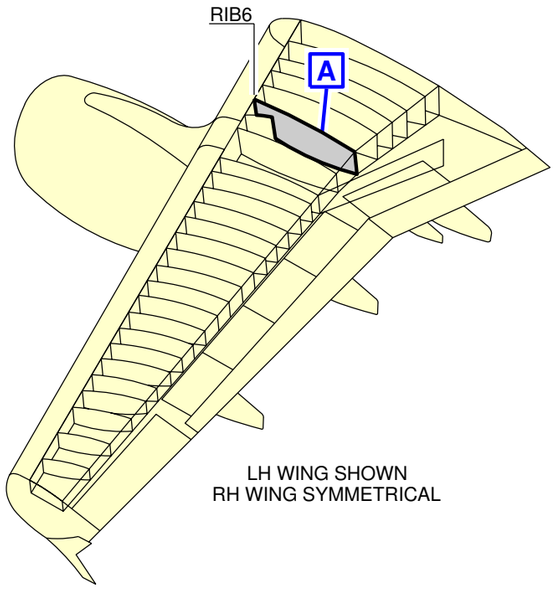
N_SB_571208_7_BEAC_02_04

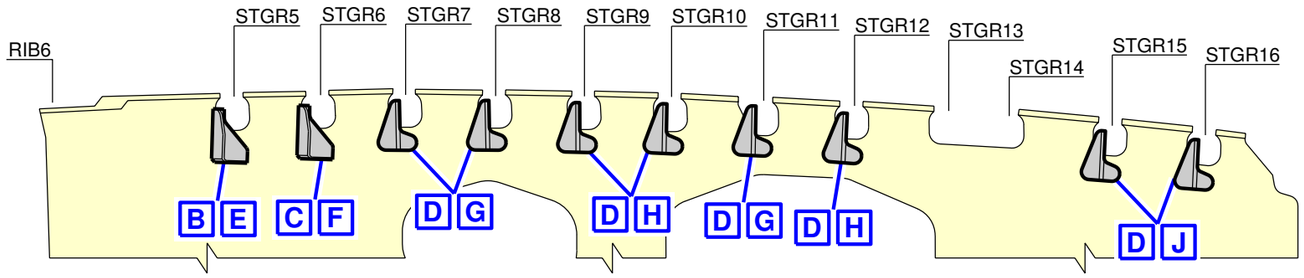
Figure A-UBEAC - Sheet 02
Modification of the Cleat to Stringer Webs RIB 6



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

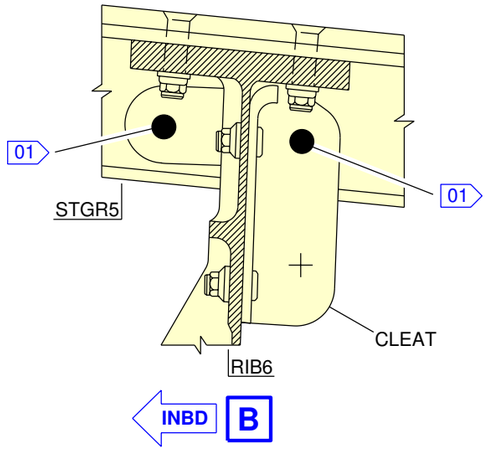
**CONF 004, 013



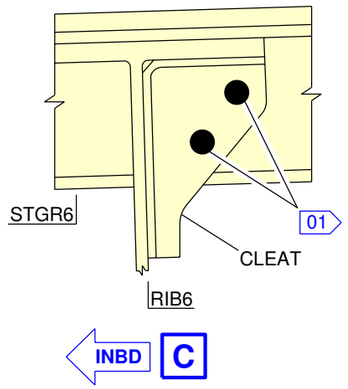



VIEW LOOKING INBOARD

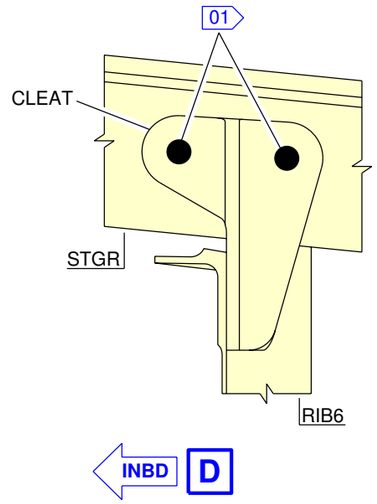
**BEFORE**




**BEFORE**




**BEFORE**




TYPICAL FOR
STGRS 7 THRU 12, 15 AND 16

| FASTENER TABLE | |
|---|---|
| ● | REMOVE AND DISCARD |
| + | FOR REFERENCE ONLY |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

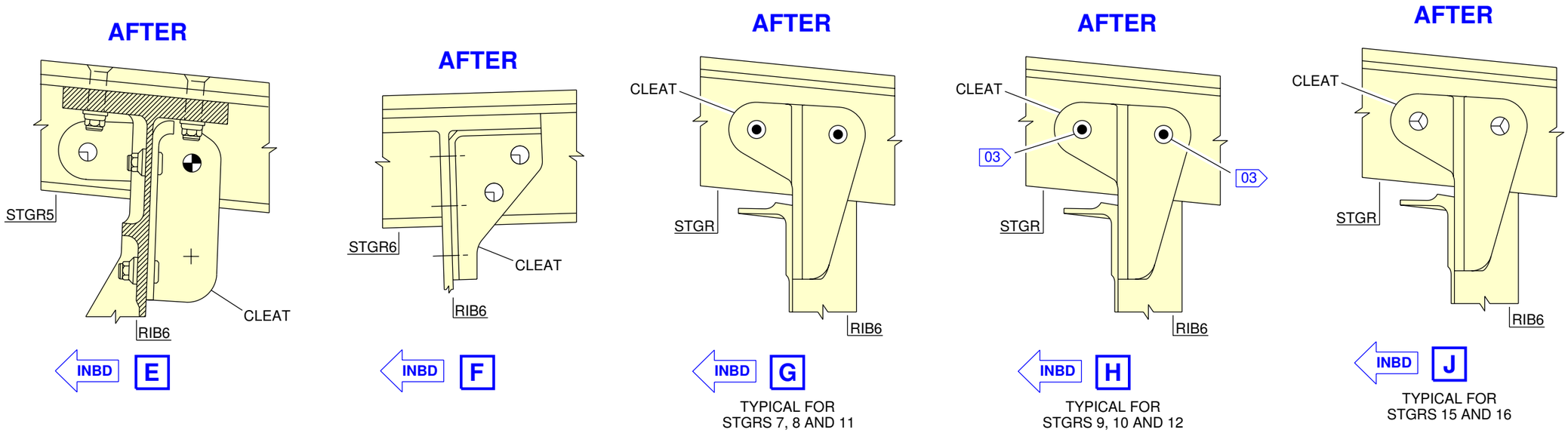
N_SB_571208_7_BEAD_01_04

Figure A-UBEAD - Sheet 01
Modification of the Cleat to Stringer Webs RIB 6



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 004, 013




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER MIN | FINAL HOLE DIAMETER MAX | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| ◕ | – | 4 | EN6115V3A7 | BOLT | 5.555 mm (0.2187 in) | 5.606 mm (0.2207 in) | 2ND OVERSIZE CLEARANCE FIT | – |
| | | 14 | ASNA2531–3A | NUT | | | | |
| ◶ | – | 6 | EN6115V4Y5 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ◷ | – | 9 | EN6115V4Y8 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |

| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

03 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

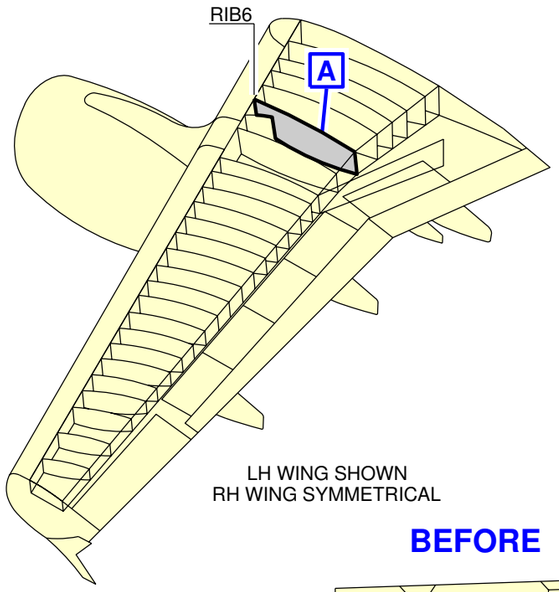
N_SB_571208_7_BEAD_02_04

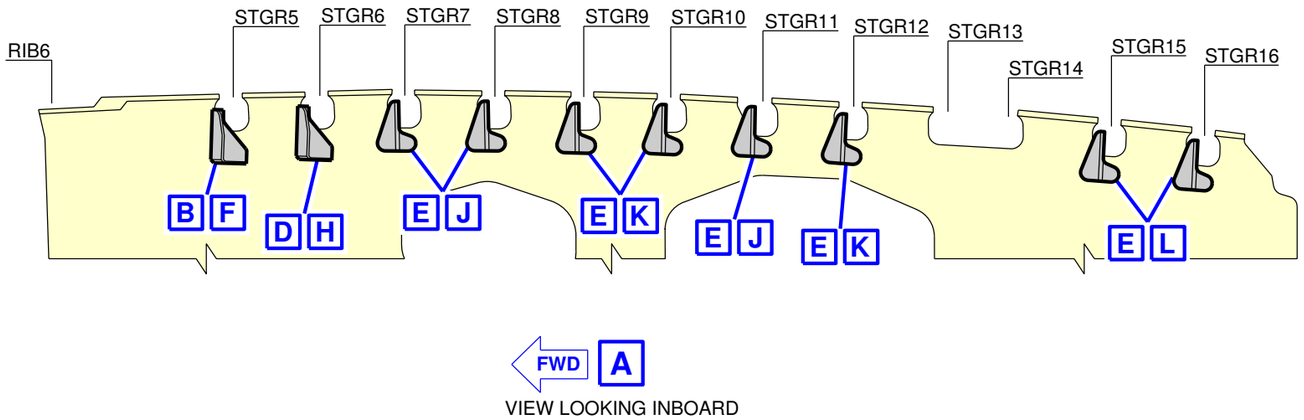
Figure A-UBEAD - Sheet 02
Modification of the Cleat to Stringer Webs RIB 6

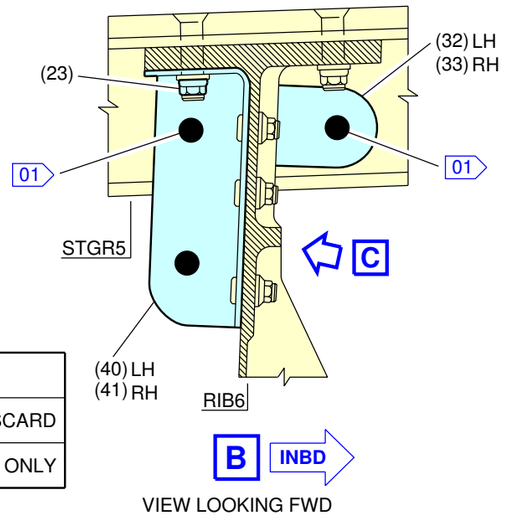


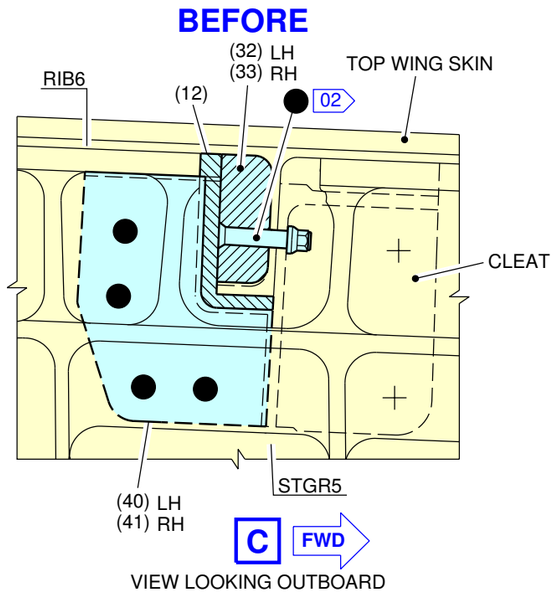
Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

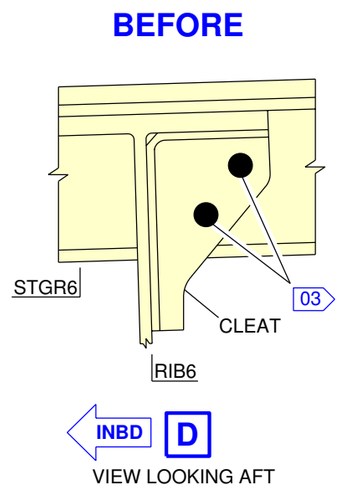
**CONF 005, 011

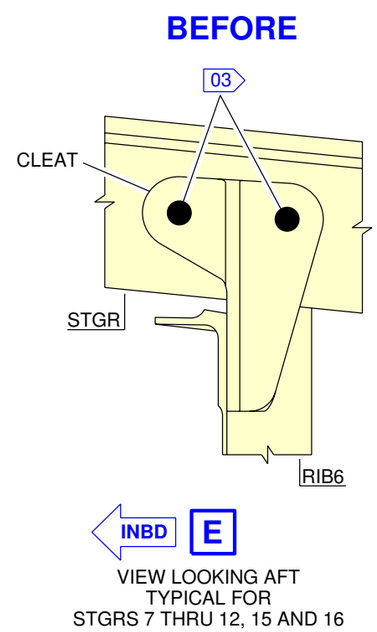



| FASTENER TABLE | |
|---|---|
| ● | REMOVE AND DISCARD |
| + | FOR REFERENCE ONLY |

**NOTE:**

01 THE TWO SIDES OF THE CLEAT MUST BE SUFFICIENTLY CLAMPED NEAR TO THE HOLES AT ALL TIMES DURING OVERSIZING OPERATION.

02 FOAM CARRIER, ITEM (40) LH, ITEM (41) RH, AND FOAM SEALANT, ITEM (12), MUST BE REMOVED TO GET ACCESS TO THE FASTENER INSTALLED THROUGH THE METALLIC PACKER.

03 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

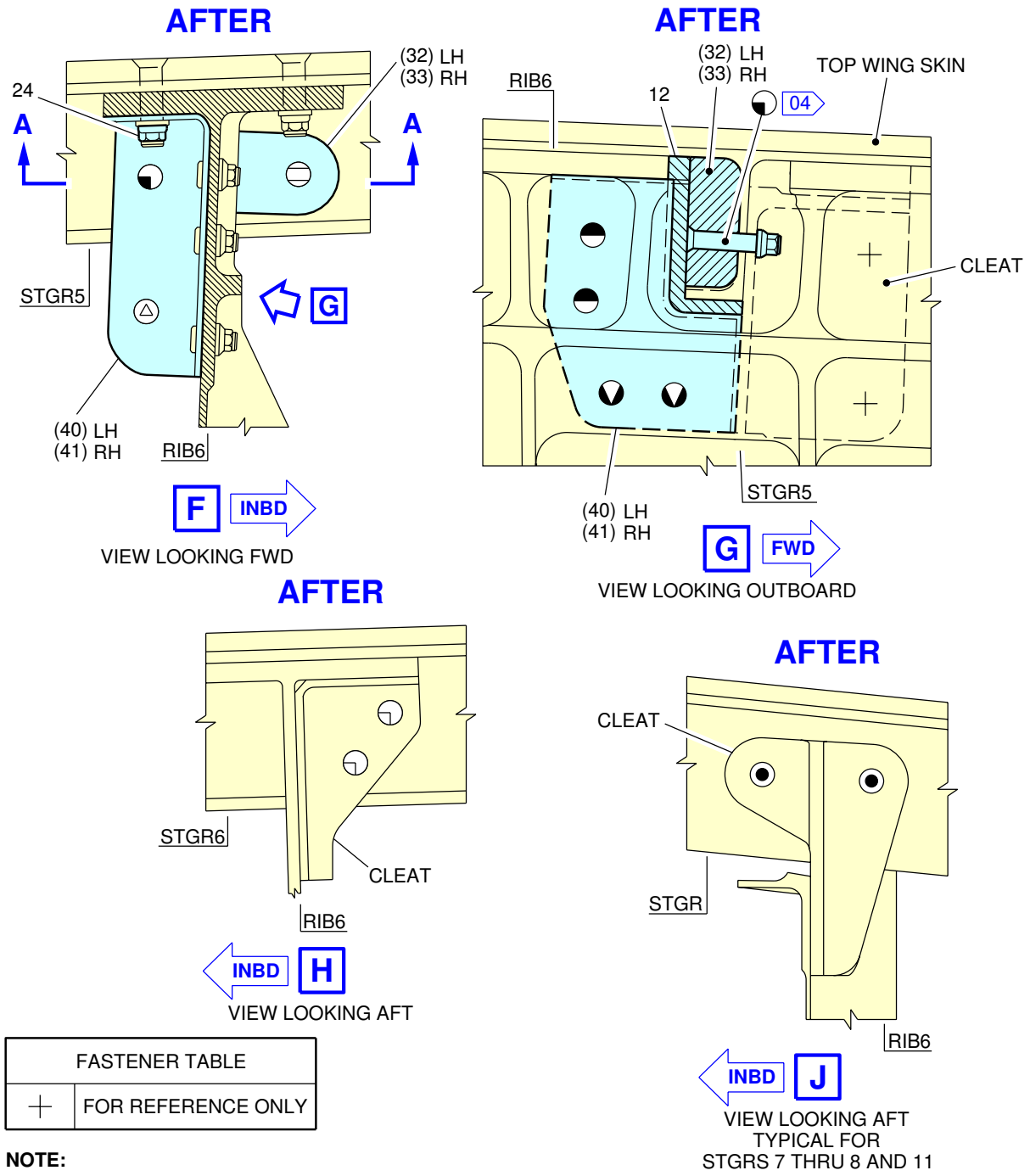
N_SB_571208_7_BEAE_01_10

Figure A-UBEAE - Sheet 01
Modification of the Cleat to Stringer Webs RIB 6



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 005, 011




| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

FOR FASTENER TABLE SEE SHEET 3.

04 FASTENER, ITEM 5, MUST BE INSTALLED BEFORE INSTALLATION OF FOAM CARRIER, ITEM (40) LH, ITEM (41) RH, AND FOAM SEALANT, ITEM 12.

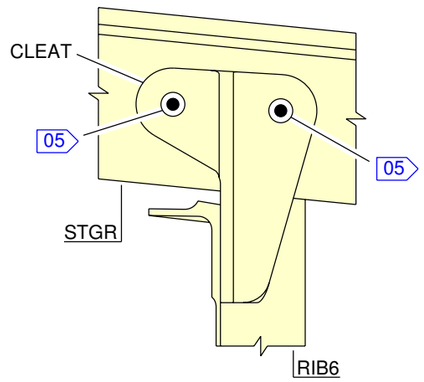
N_SB_571208_7_BEAE_02_11

Figure A-UBEAE - Sheet 02
Modification of the Cleat to Stringer Webs RIB 6

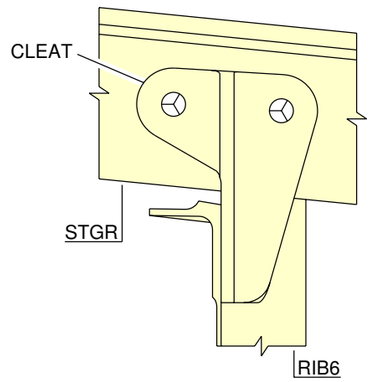


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

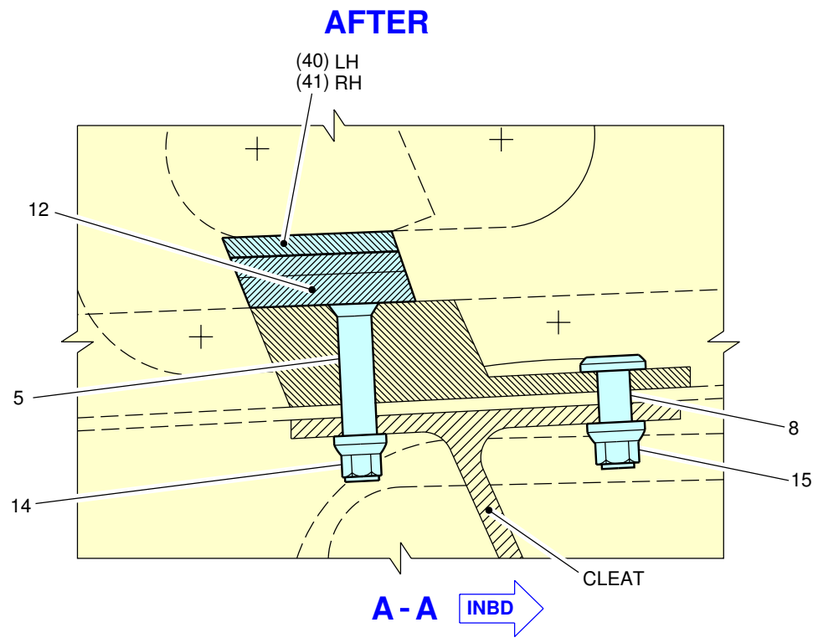
**CONF 005, 011




VIEW LOOKING AFT
TYPICAL FOR
STGRS 9, 10 AND 12




VIEW LOOKING AFT
TYPICAL FOR
STGRS 15 AND 16




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER MIN | FINAL HOLE DIAMETER MAX | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | – | 5 | EN6114V3A16 | BOLT | 5.555 mm (0.2187 in) | 5.606 mm (0.2207 in) | 2ND OVERSIZE CLEARANCE FIT | – |
| | | 14 | ASNA2531–3A | NUT | | | | |
| | – | 6 | EN6115V4Y5 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 06 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 06 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 8 | EN6115V4Y7 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 06 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 9 | EN6115V4Y8 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 06 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 18 | EN6115V3–4 | BOLT | – | – | CLEARANCE FIT | – |
| | | 27 | ASNA2531–3 | NUT | | | | |
| | – | 25 | EN6115V3–6 | BOLT | – | – | CLEARANCE FIT | – |
| | | 27 | ASNA2531–3 | NUT | | | | |
| | – | 26 | EN6115V3–8 | BOLT | – | – | CLEARANCE FIT | – |
| | | 27 | ASNA2531–3 | NUT | | | | |

| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

05 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

06 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

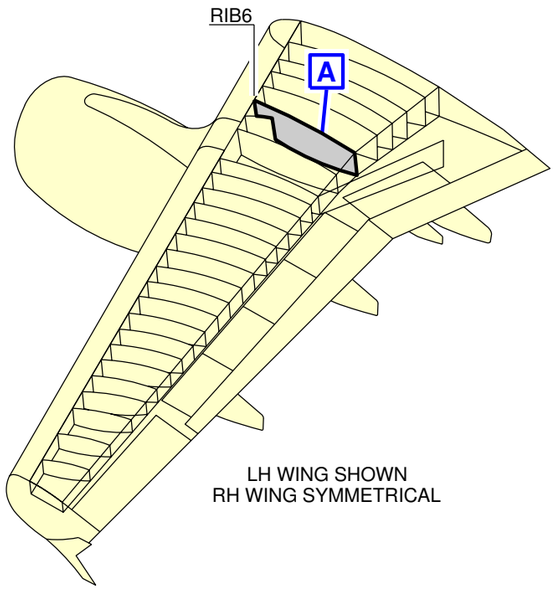
N_SB_571208_7_BEAE_03_07

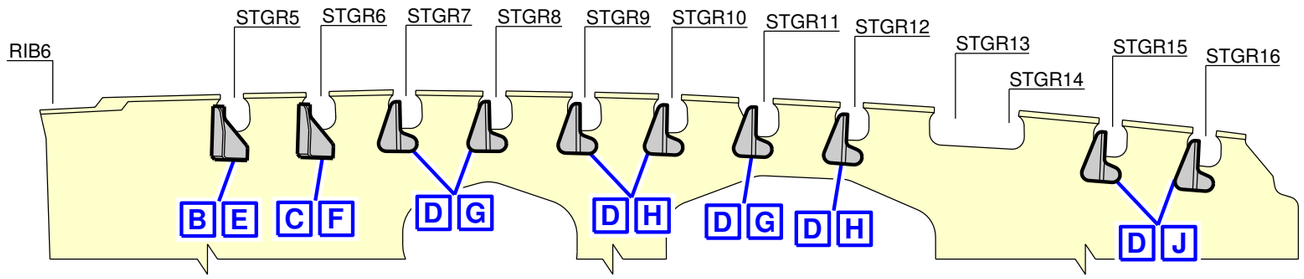
Figure A-UBEAE - Sheet 03
Modification of the Cleat to Stringer Webs RIB 6



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

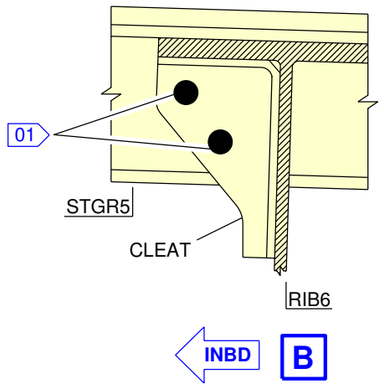
**CONF 006, 017



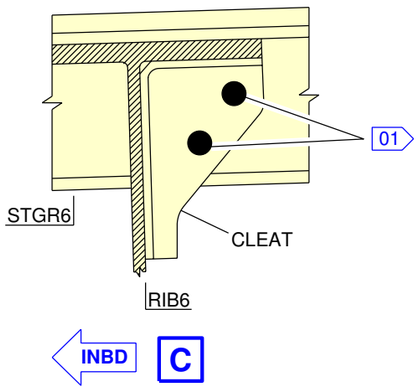
VIEW LOOKING INBOARD

BEFORE



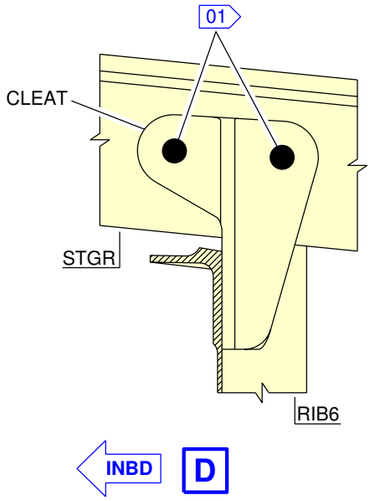

VIEW LOOKING AFT

BEFORE




VIEW LOOKING AFT

BEFORE




VIEW LOOKING AFT
TYPICAL FOR
STGRS 7 THRU 12, 15 AND 16

| FASTENER TABLE | |
|---|---|
| ● | REMOVE AND DISCARD |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

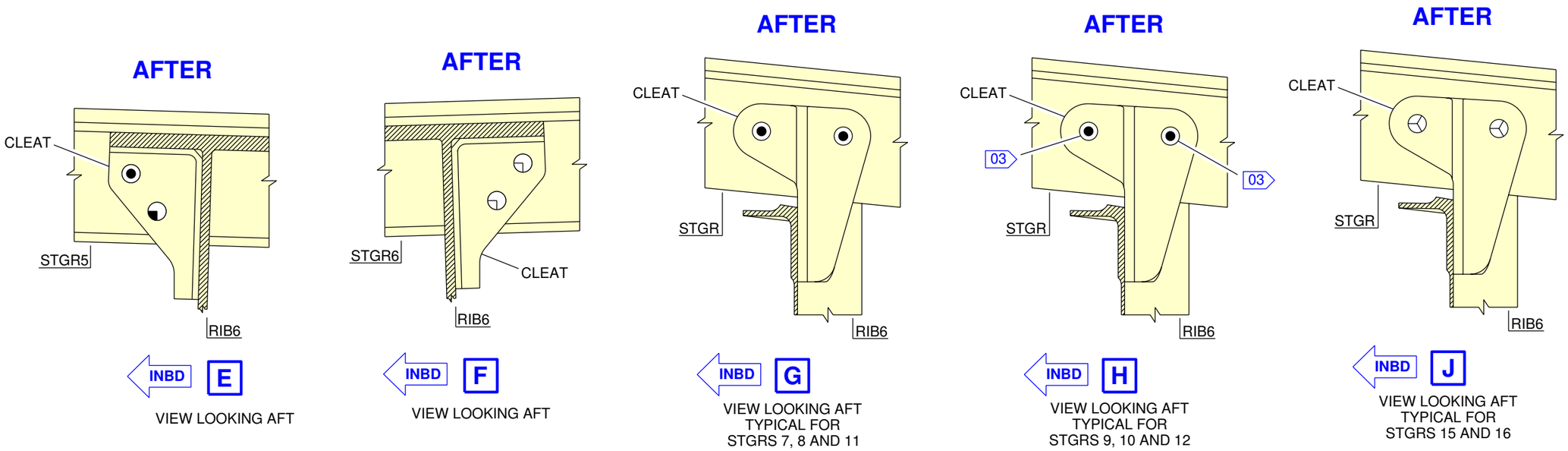
N_SB_571208_7_BEAF_01_03

Figure A-UBEAF - Sheet 01
Modification of the Cleat to Stringer Webs RIB 6



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 006, 017




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER MIN | FINAL HOLE DIAMETER MAX | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| ◕ | – | 5 | EN6115V3A6 | BOLT | 5.555 mm (0.2187 in) | 5.606 mm (0.2207 in) | 2ND OVERSIZE CLEARANCE FIT | – |
| | | 14 | ASNA2531–3A | NUT | | | | |
| ◷ | – | 6 | EN6115V4Y5 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊘ | – | 9 | EN6115V4Y8 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

03 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

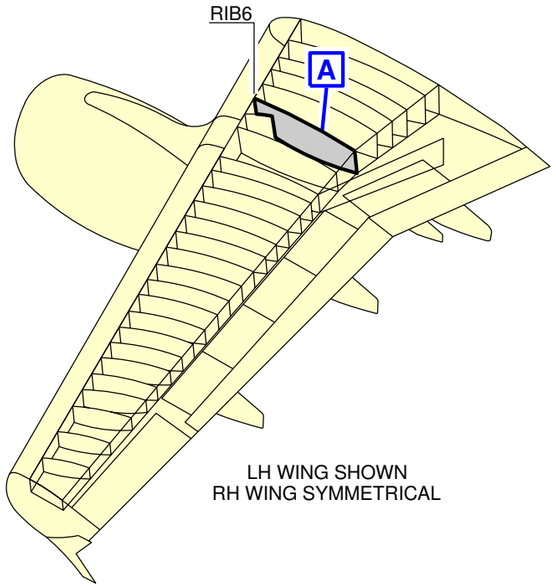
N_SB_571208_7_BEAF_02_04

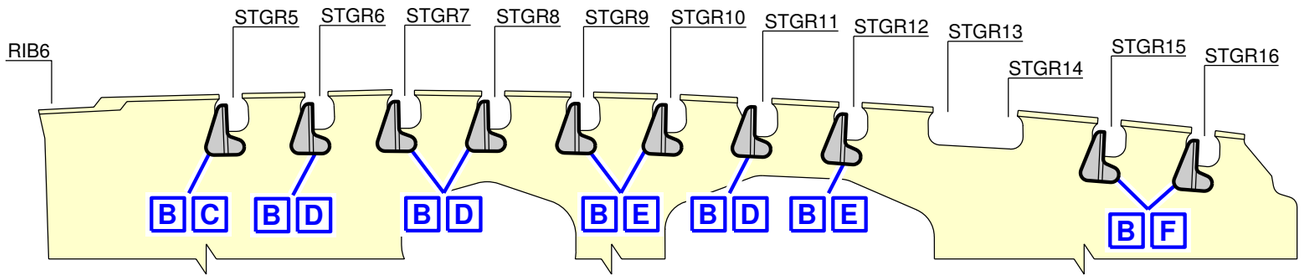
Figure A-UBEAF - Sheet 02
Modification of the Cleat to Stringer Webs RIB 6



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

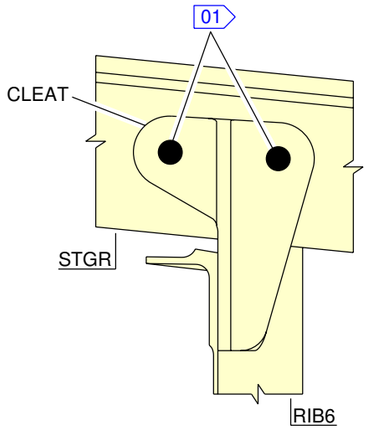
**CONF 007, 012



VIEW LOOKING INBOARD

**BEFORE**



TYPICAL FOR
STGRS 5 THRU 12, 15 AND 16

| | FASTENER TABLE | NOTE |
|---|---|---|
| ● | REMOVE AND DISCARD | 01 |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

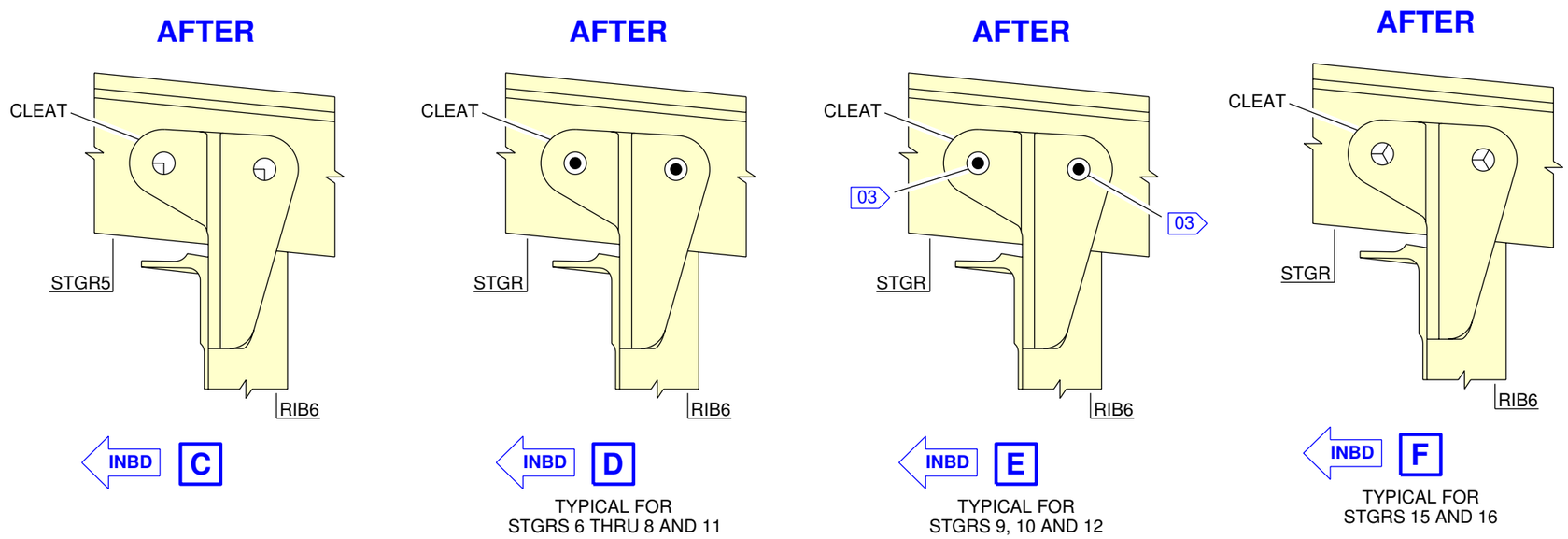
N_SB_571208_7_BEAG_01_03

Figure A-UBEAG - Sheet 01
Modification of the Cleat to Stringer Webs RIB 6



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 007, 012




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER MIN | FINAL HOLE DIAMETER MAX | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | – | 6 | EN6115V4Y5 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 9 | EN6115V4Y8 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

03 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

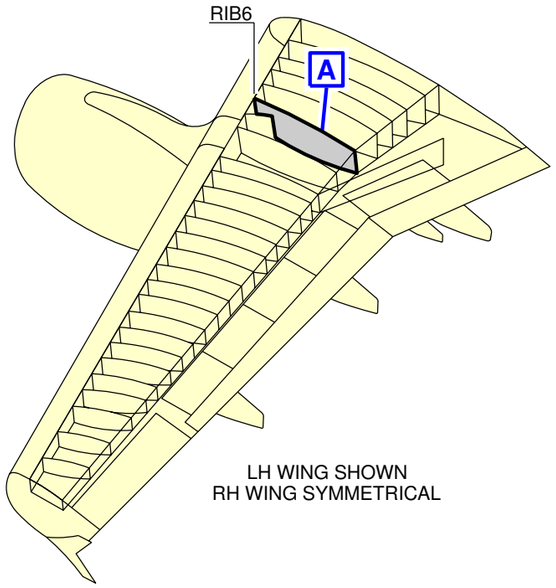
N_SB_571208_7_BEAG_02_03

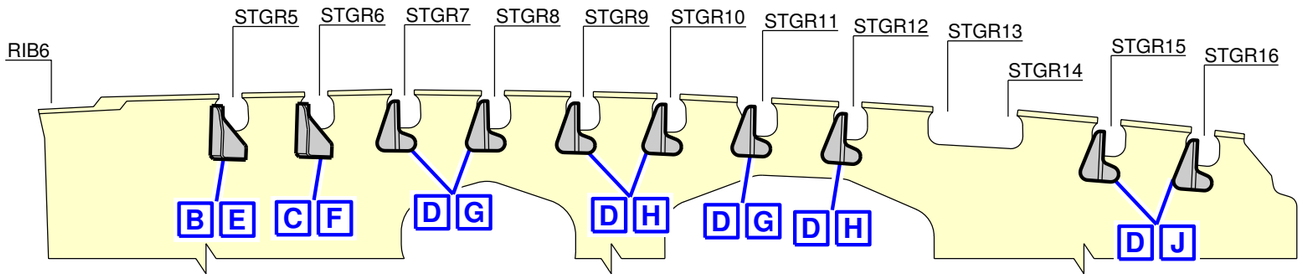
Figure A-UBEAG - Sheet 02
Modification of the Cleat to Stringer Webs RIB 6



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 008, 014

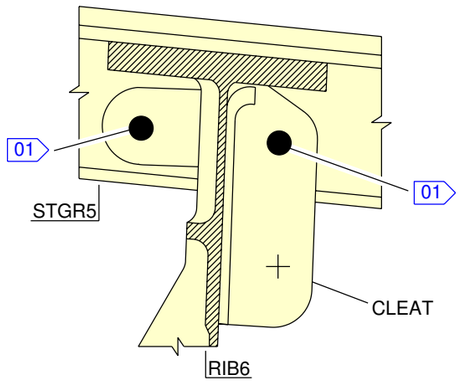



FWD A

VIEW LOOKING INBOARD

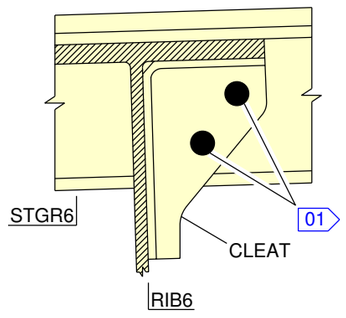
**BEFORE**




INBD B

VIEW LOOKING AFT

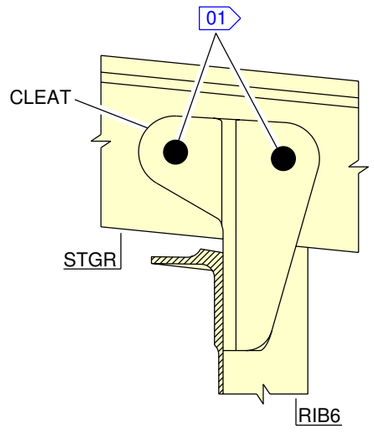
**BEFORE**




INBD C

VIEW LOOKING AFT

**BEFORE**




INBD D

VIEW LOOKING AFT
TYPICAL FOR
STGRS 7 THRU 12, 15 AND 16

| FASTENER TABLE | |
|---|---|
| ● | REMOVE AND DISCARD |
| + | FOR REFERENCE ONLY |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

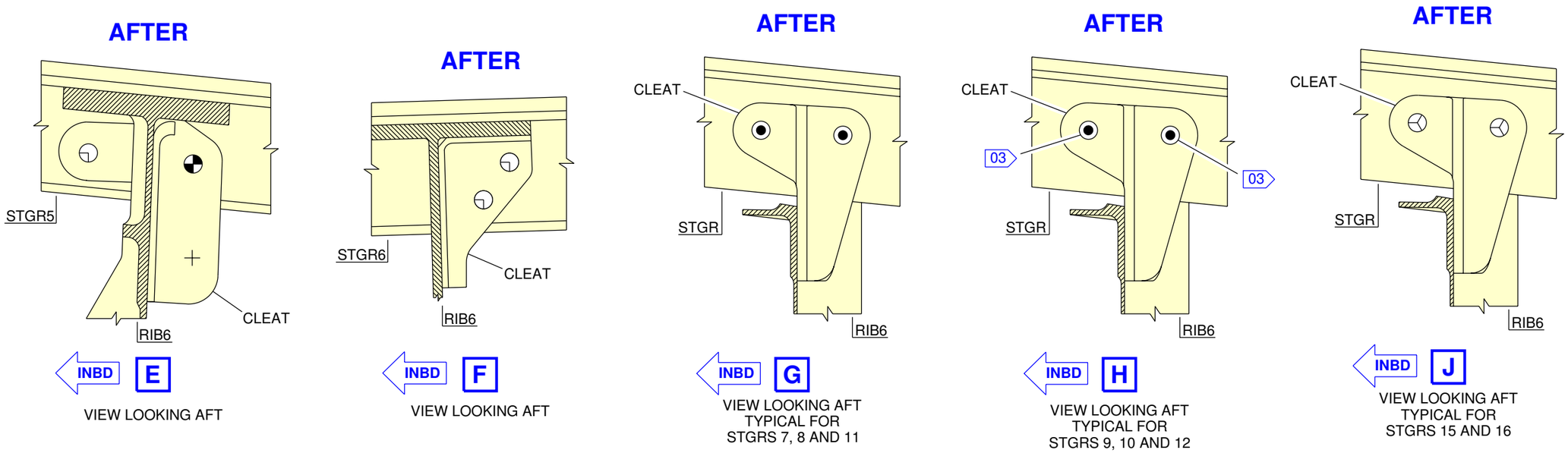
N_SB_571208_7_BEAH_01_04

Figure A-UBEAH - Sheet 01
Modification of the Cleat to Stringer Webs RIB 6



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 008, 014




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER MIN | FINAL HOLE DIAMETER MAX | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| ◕ | – | 4 | EN6115V3A7 | BOLT | 5.555 mm (0.2187 in) | 5.606 mm (0.2207 in) | 2ND OVERSIZE CLEARANCE FIT | – |
| | | 14 | ASNA2531–3A | NUT | | | | |
| ◶ | – | 6 | EN6115V4Y5 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ◷ | – | 9 | EN6115V4Y8 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |

| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

03 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

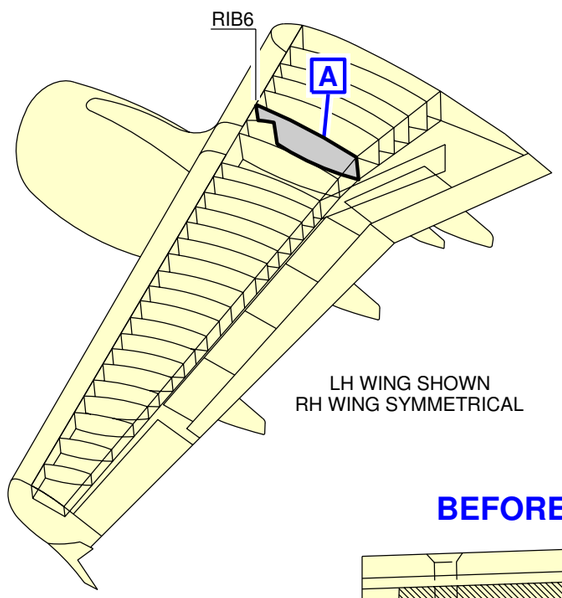
N_SB_571208_7_BEAH_02_05

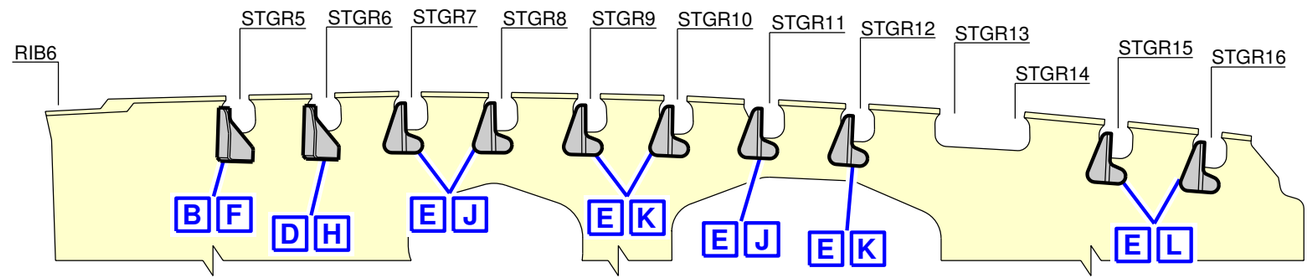
Figure A-UBEAH - Sheet 02
Modification of the Cleat to Stringer Webs RIB 6

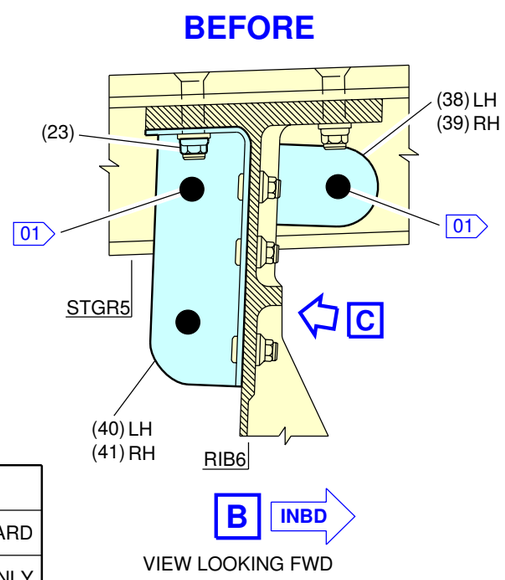


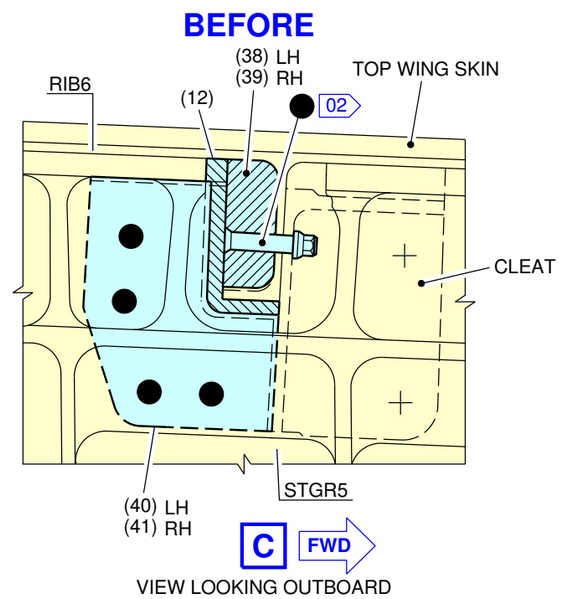
Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

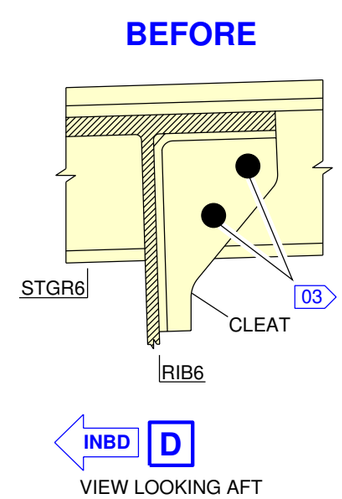
**CONF 009, 015

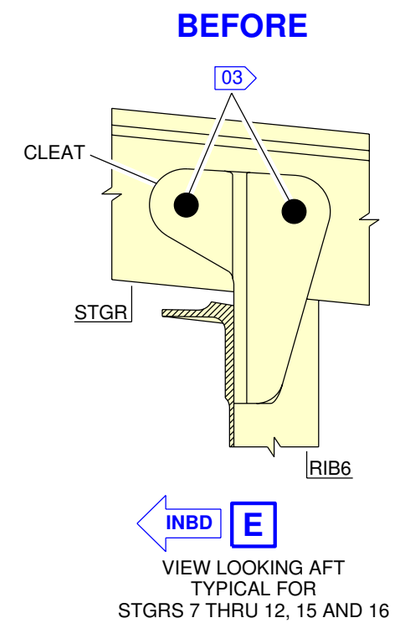



| FASTENER TABLE | |
|---|---|
| ● | REMOVE AND DISCARD |
| + | FOR REFERENCE ONLY |

**NOTE:**

01 THE TWO SIDES OF THE CLEAT MUST BE SUFFICIENTLY CLAMPED NEAR TO THE HOLES AT ALL TIMES DURING OVERSIZING OPERATION.

02 FOAM CARRIER, ITEM (40) LH, ITEM (41) RH, AND FOAM SEALANT, ITEM (12), MUST BE REMOVED TO GET ACCESS TO THE FASTENER INSTALLED THROUGH THE METALLIC PACKER.

03 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

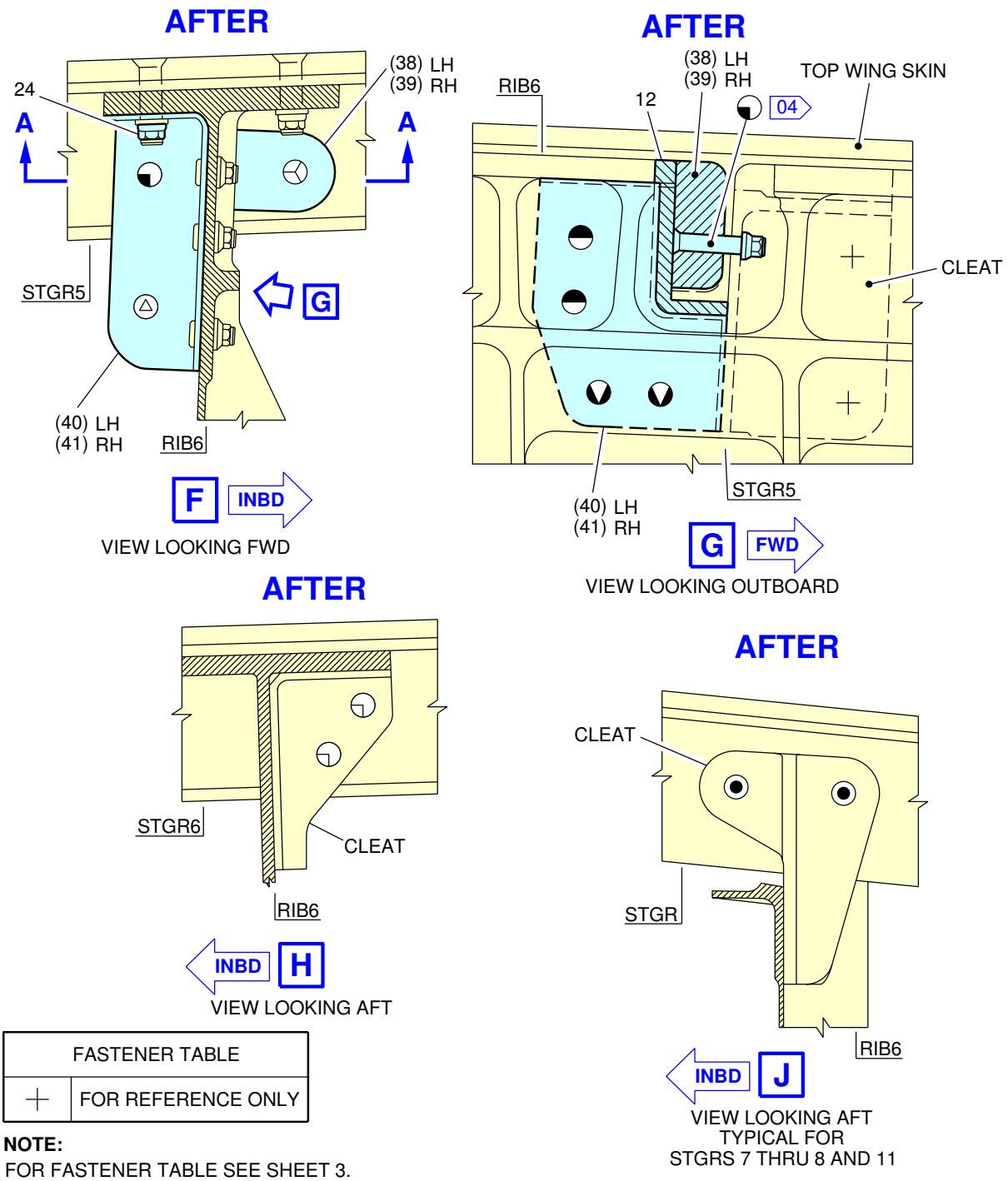
N_SB_571208_7_BEAJ_01_10

Figure A-UBEAJ - Sheet 01
Modification of the Cleat to Stringer Webs RIB 6



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 009, 015




| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

FOR FASTENER TABLE SEE SHEET 3.

04 FASTENER, ITEM 5, MUST BE INSTALLED BEFORE INSTALLATION OF FOAM CARRIER, ITEM (40) LH, ITEM (41) RH, AND FOAM SEALANT, ITEM 12.

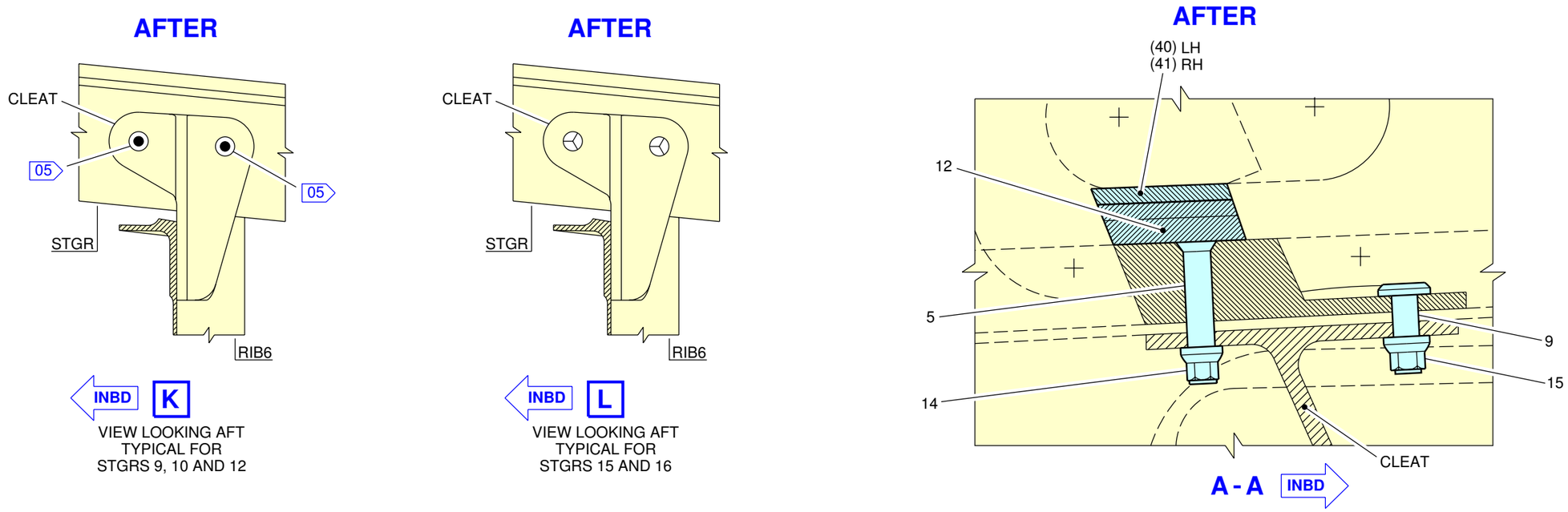
N_SB_571208_7_BEAJ_02_11

Figure A-UBEAJ - Sheet 02
Modification of the Cleat to Stringer Webs RIB 6



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 009, 015




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER MIN | FINAL HOLE DIAMETER MAX | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | – | 5 | EN6114V3A16 | BOLT | 5.555 mm (0.2187 in) | 5.606 mm (0.2207 in) | 2ND OVERSIZE CLEARANCE FIT | – |
| | | 14 | ASNA2531–3A | NUT | | | | |
| | – | 6 | EN6115V4Y5 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 06 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 06 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 9 | EN6115V4Y8 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 06 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| | – | 18 | EN6115V3–4 | BOLT | – | – | CLEARANCE FIT | – |
| | | 27 | ASNA2531–3 | NUT | | | | |
| | – | 25 | EN6115V3–6 | BOLT | – | – | CLEARANCE FIT | – |
| | | 27 | ASNA2531–3 | NUT | | | | |
| | – | 26 | EN6115V3–8 | BOLT | – | – | CLEARANCE FIT | – |
| | | 27 | ASNA2531–3 | NUT | | | | |

| FASTENER TABLE | |
|---|---|
| + | FOR REFERENCE ONLY |

**NOTE:**

05 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

06 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

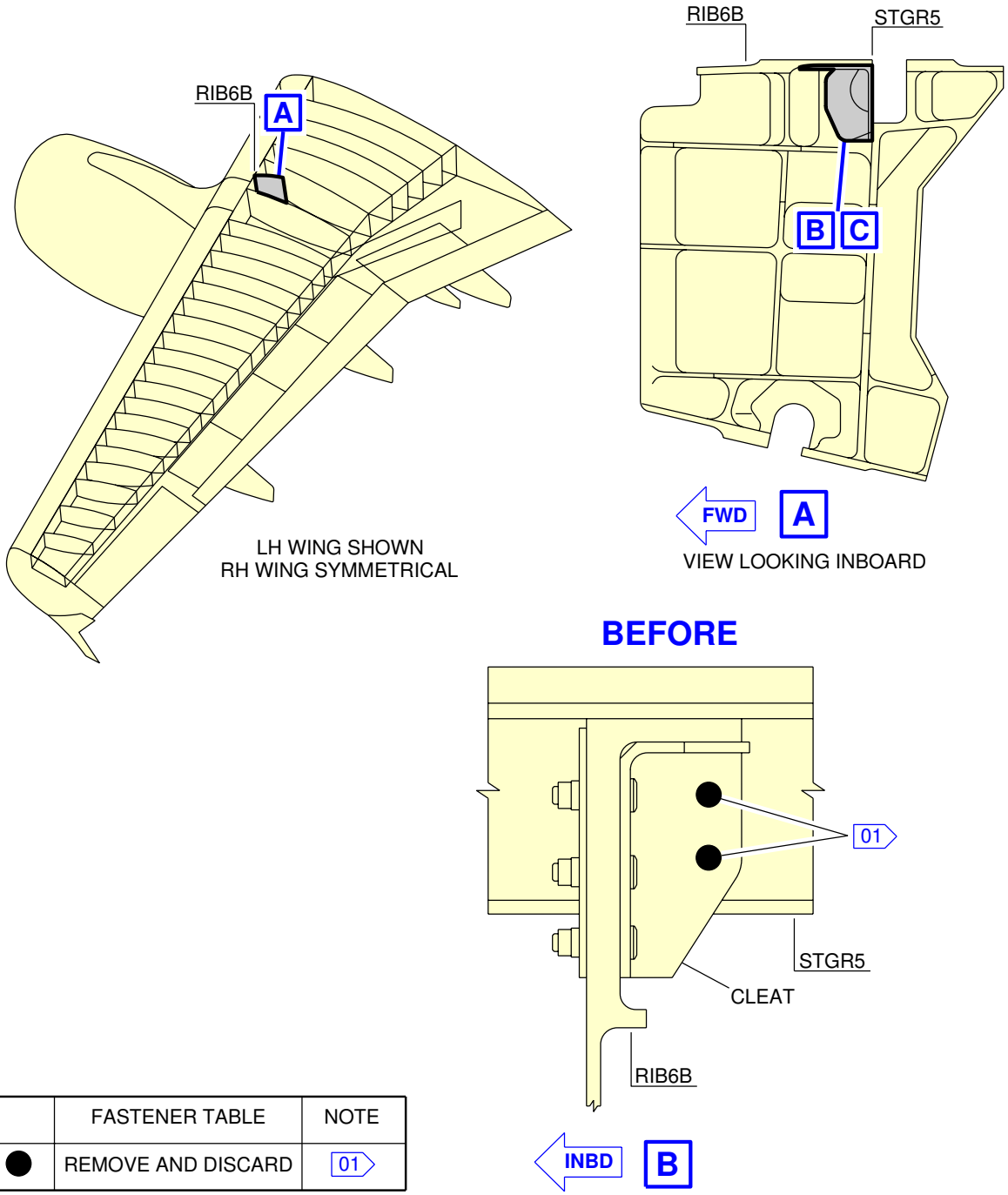
N_SB_571208_7_BEAJ_03_07

Figure A-UBEAJ - Sheet 03
Modification of the Cleat to Stringer Webs RIB 6



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 001, 004, 013




| | FASTENER TABLE | NOTE |
|---|---|---|
| ● | REMOVE AND DISCARD | 01 |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION

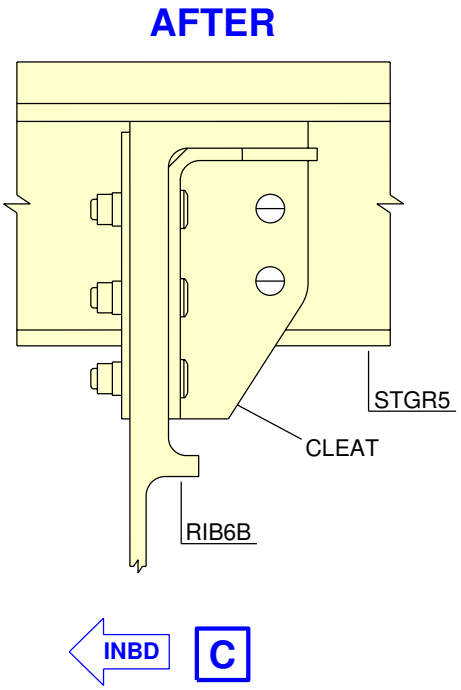
N_SB_571208_7_BFAA_01_02

Figure A-UBFAA - Sheet 01
Modification of the Cleat to Stringer Webs RIB 6B



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 001, 004, 013




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER | | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | | | | | MIN | MAX | | |
| ⊖ | – | 2 | EN6115V3A5 | BOLT | 5.555 mm (0.2187 in) | 5.606 mm (0.2207 in) | 2ND OVERSIZE CLEARANCE FIT | |
| | | 14 | ASNA2531–3A | NUT | | | | |

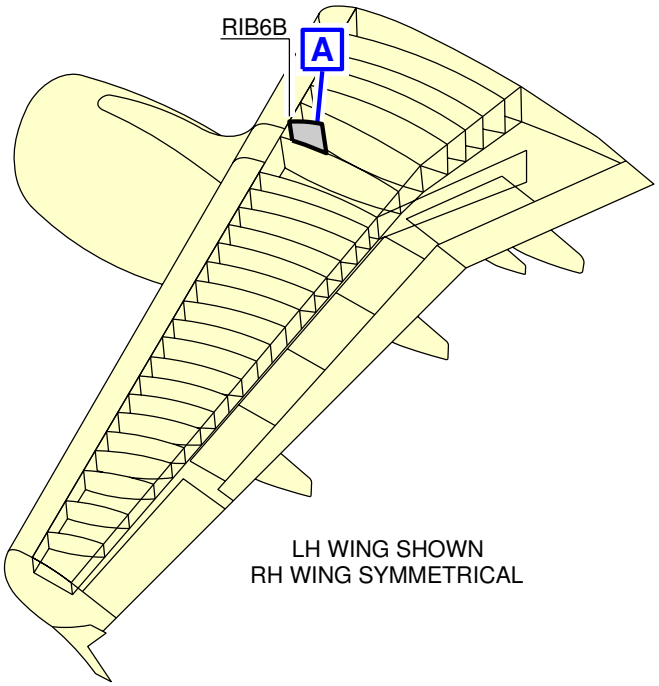
N_SB_571208_7_BFAA_02_02

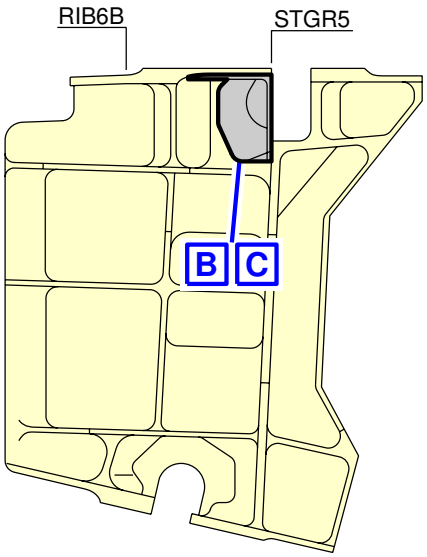
Figure A-UBFAA - Sheet 02
Modification of the Cleat to Stringer Webs RIB 6B



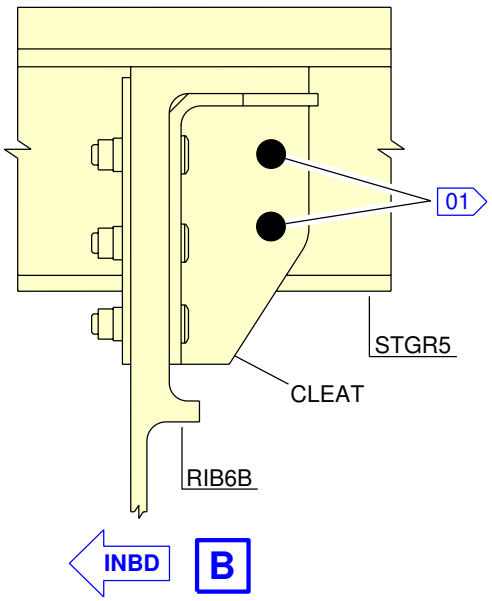
Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 005, 011




**BEFORE**




| | FASTENER TABLE | NOTE |
|---|---|---|
| ● | REMOVE AND DISCARD | 01 |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION

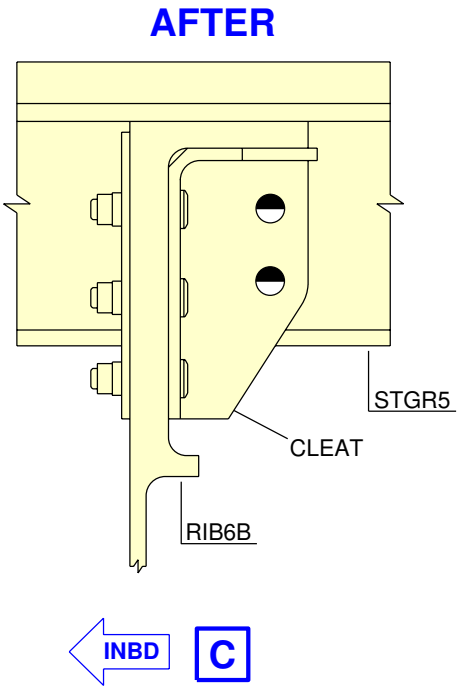
N_SB_571208_7_BFAB_01_02

Figure A-UBFAB - Sheet 01
Modification of the Cleat to Stringer Webs RIB 6B



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 005, 011




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER | | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | | | | | MIN | MAX | | |
| ◓ | – | 1 | EN6115V3A4 | BOLT | 5.555 mm (0.2187 in) | 5.606 mm (0.2207 in) | 2ND OVERSIZE CLEARANCE FIT | |
| | | 14 | ASNA2531–3A | NUT | | | | |

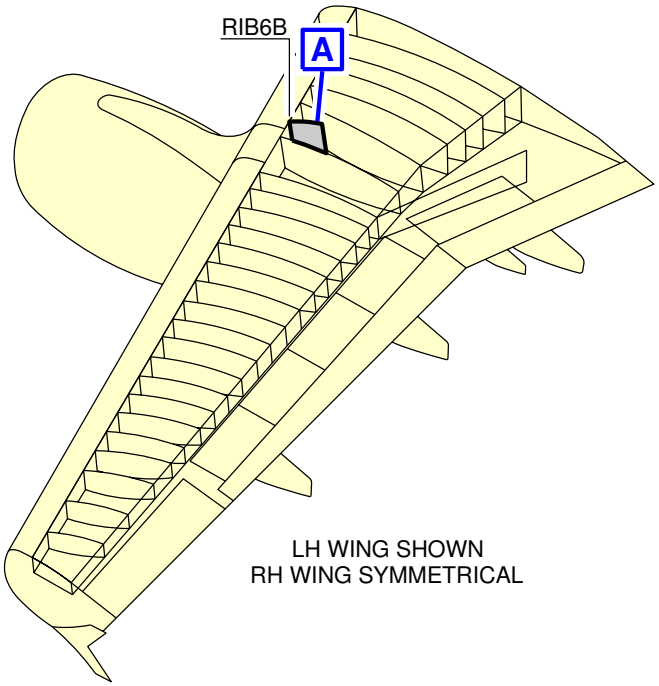
N_SB_571208_7_BFAB_02_02

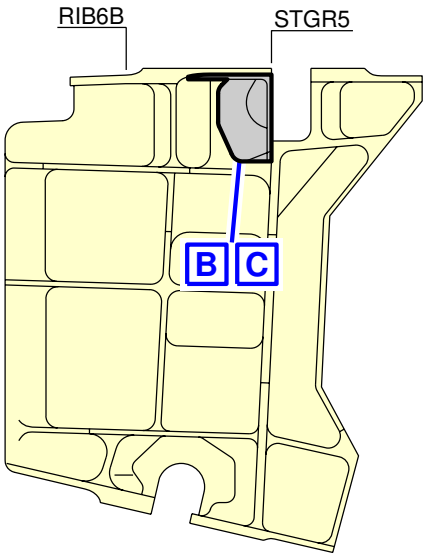
Figure A-UBFAB - Sheet 02
Modification of the Cleat to Stringer Webs RIB 6B



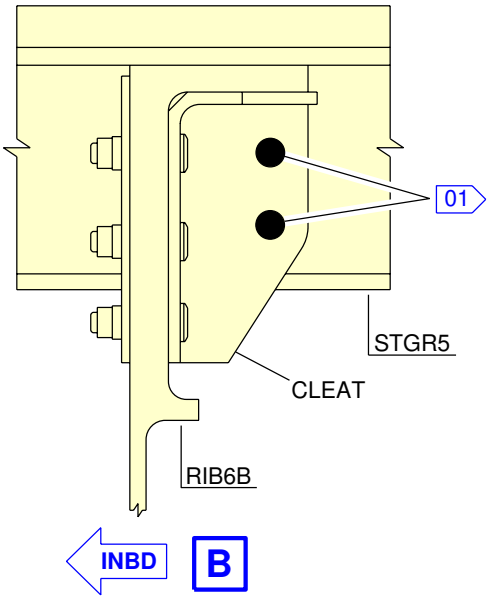
Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 008 thru 009, 014 thru 015




**BEFORE**




| | FASTENER TABLE | NOTE |
|---|---|---|
| ● | REMOVE AND DISCARD | 01 |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION

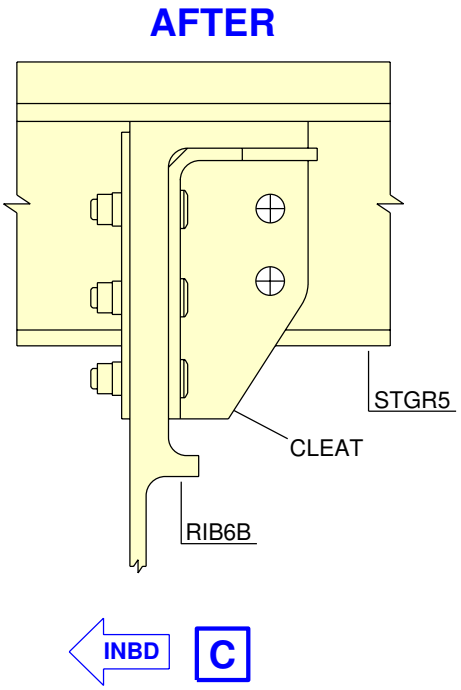
N_SB_571208_7_BFAC_01_02

Figure A-UBFAC - Sheet 01
Modification of the Cleat to Stringer Webs RIB 6B



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 008 thru 009, 014 thru 015




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER | | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | | | | | MIN | MAX | | |
| ⊕ | – | 3 | EN6115V3A6 | BOLT | 5.555 mm (0.2187 in) | 5.606 mm (0.2207 in) | 2ND OVERSIZE CLEARANCE FIT | |
| | | 14 | ASNA2531–3A | NUT | | | | |

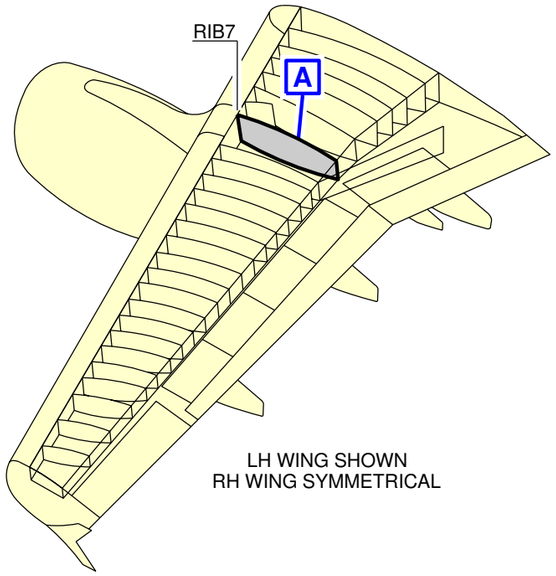
N_SB_571208_7_BFAC_02_02

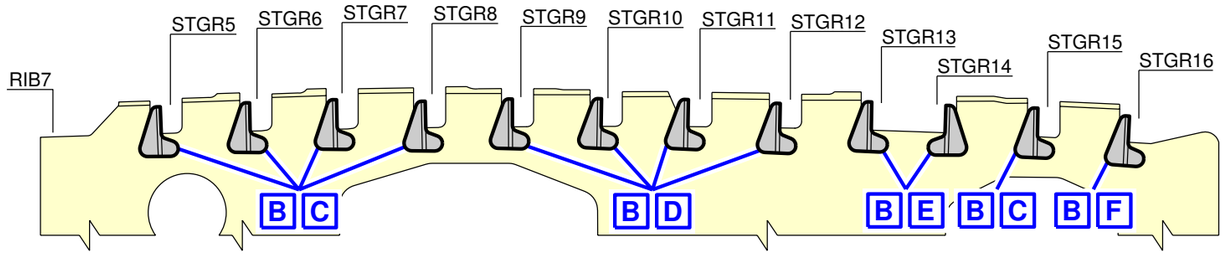
Figure A-UBFAC - Sheet 02
Modification of the Cleat to Stringer Webs RIB 6B



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

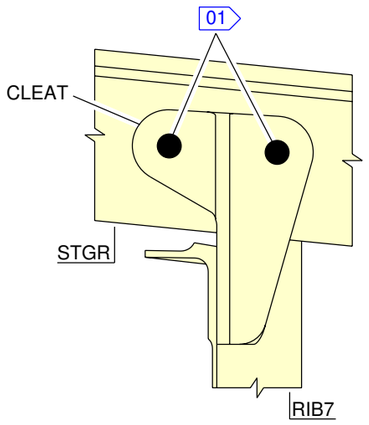
**CONF 001



VIEW LOOKING INBOARD

## BEFORE



TYPICAL FOR
STGRS 5 THRU 16

| | FASTENER TABLE | NOTE |
|---|---|---|
| ● | REMOVE AND DISCARD | 01 |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

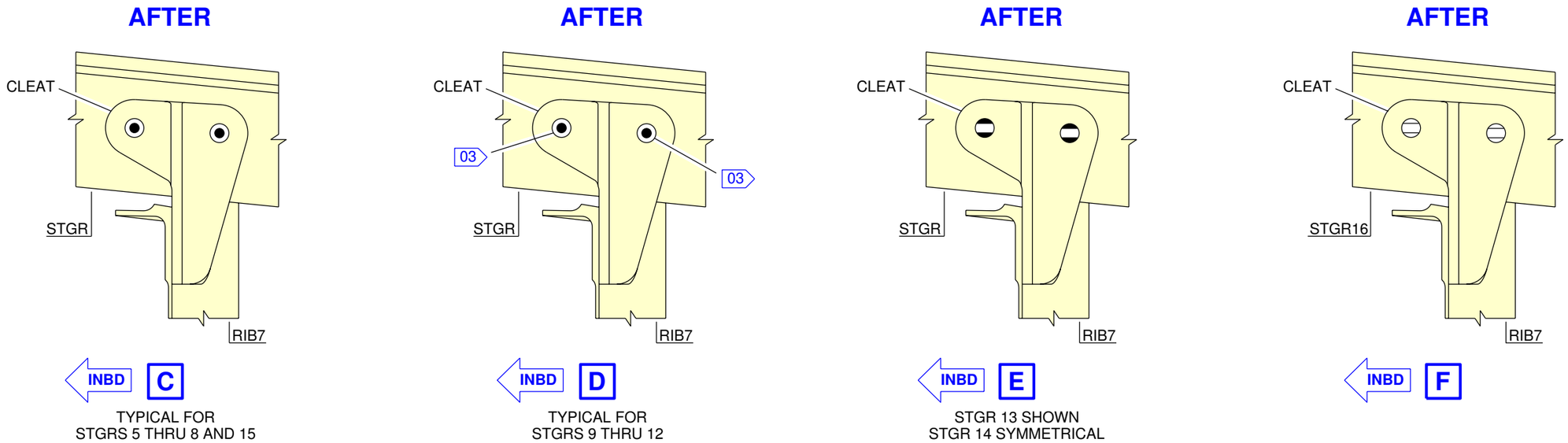
N_SB_571208_7_BGAA_01_02

Figure A-UBGAA - Sheet 01
Modification of the Cleat to Stringer Webs RIB 7



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 001




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER MIN | FINAL HOLE DIAMETER MAX | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊖ | – | 8 | EN6115V4Y7 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⬬ | – | 12 | NAS1751–4L5 | BOLT | 7.010 mm (0.2760 in) | 7.060 mm (0.2779 in) | 1ST OVERSIZE CLEARANCE FIT | – |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

03 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

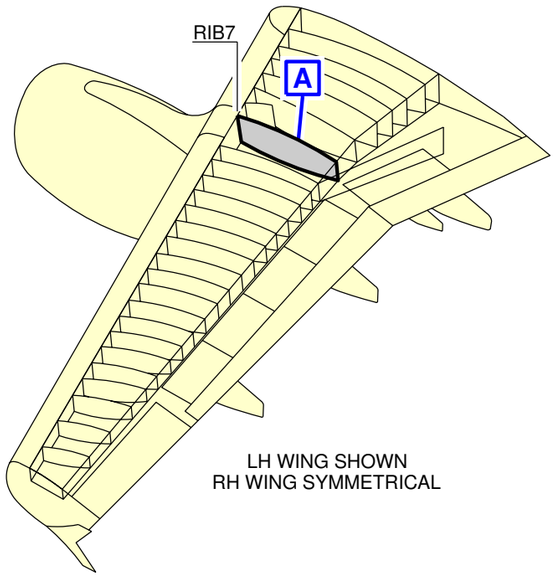
N_SB_571208_7_BGAA_02_04

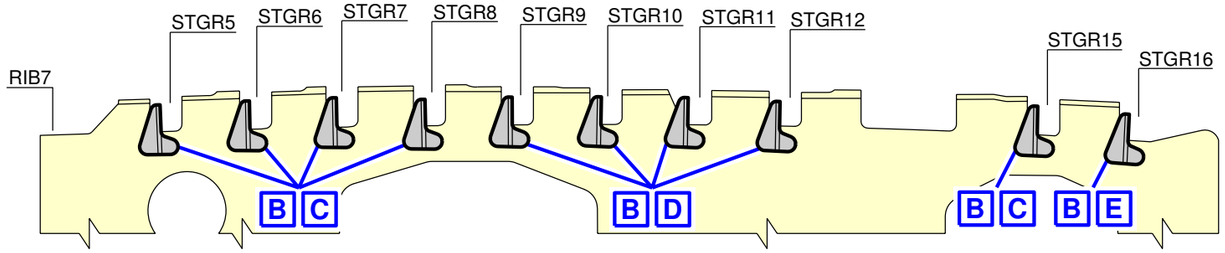
Figure A-UBGAA - Sheet 02
Modification of the Cleat to Stringer Webs RIB 7



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

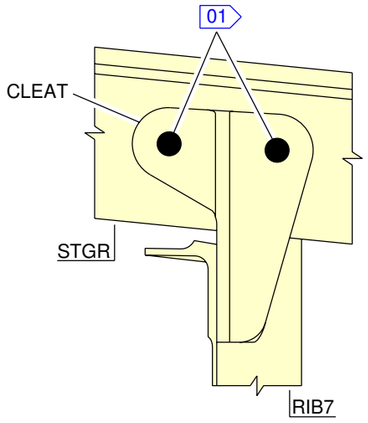
**CONF 002 thru 005, 010 thru 011, 013, 016



VIEW LOOKING INBOARD

**BEFORE**



TYPICAL FOR
STGRS 5 THRU 12, 15 AND 16

| | FASTENER TABLE | NOTE |
|---|---|---|
| ● | REMOVE AND DISCARD | 01 |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

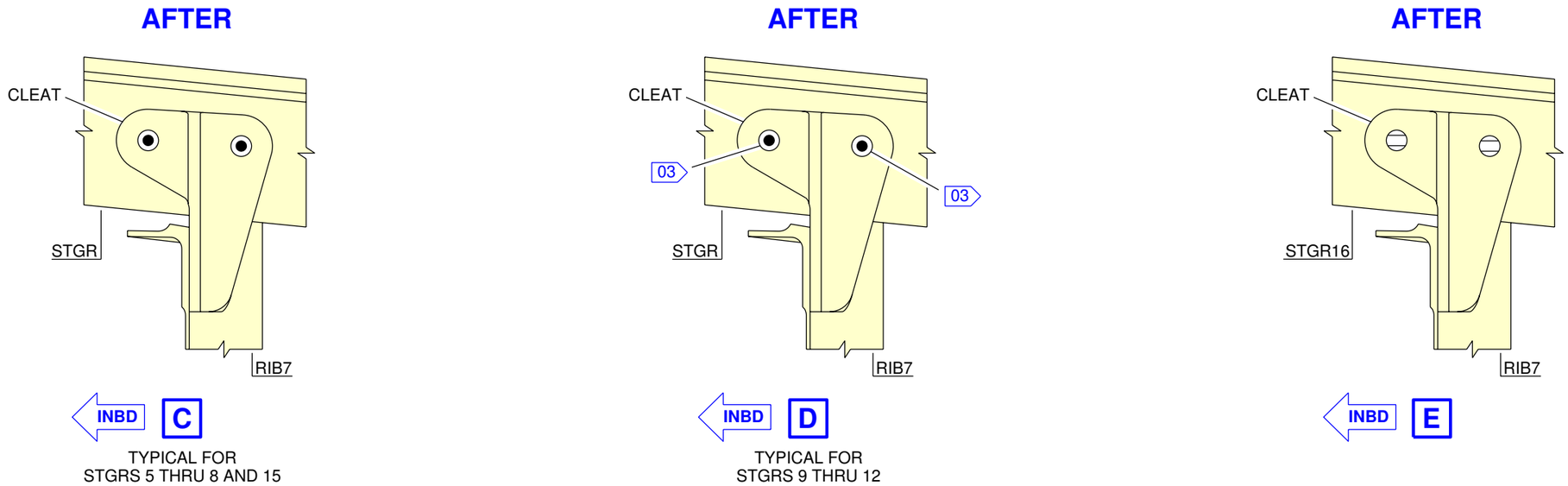
N_SB_571208_7_BGAB_01_02

Figure A-UBGAB - Sheet 01
Modification of the Cleat to Stringer Webs RIB 7



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 002 thru 005, 010 thru 011, 013, 016




| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER MIN | FINAL HOLE DIAMETER MAX | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊖ | – | 8 | EN6115V4Y7 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

03 INSTALL FASTENER HEAD ON AFT SIDE OF STRINGER.

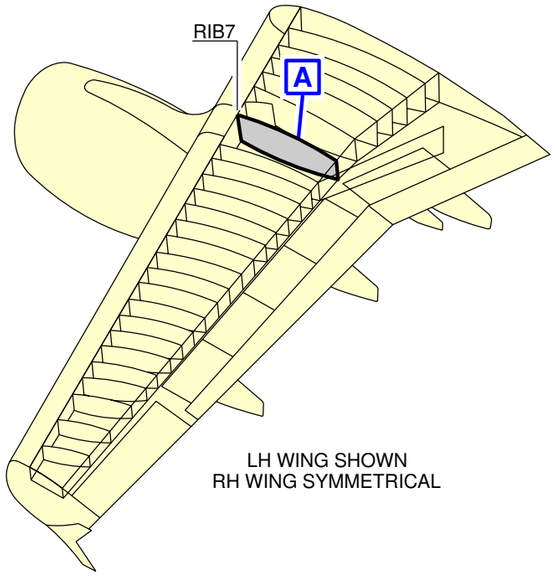
N_SB_571208_7_BGAB_02_03

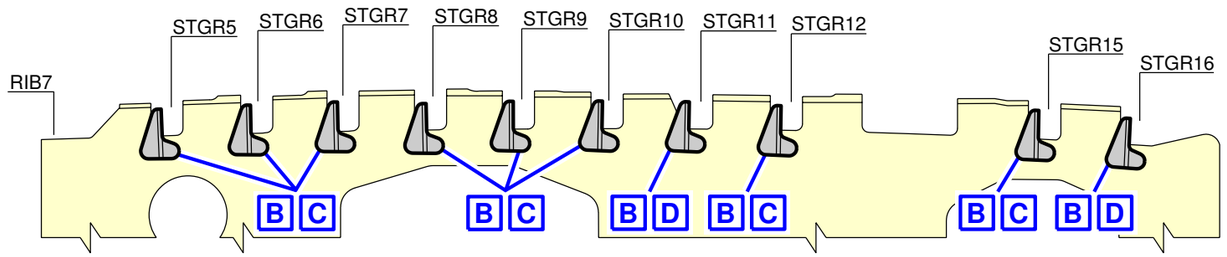
Figure A-UBGAB - Sheet 02
Modification of the Cleat to Stringer Webs RIB 7



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

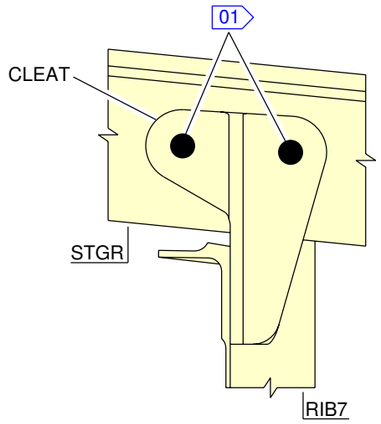
**CONF 006 thru 009, 012, 014 thru 015, 017



VIEW LOOKING INBOARD

## BEFORE



TYPICAL FOR
STGRS 5 THRU 12, 15 AND 16

| | FASTENER TABLE | NOTE |
|---|---|---|
| ● | REMOVE AND DISCARD | 01 |

**NOTE:**

01 ONE FASTENER TO REMAIN INSTALLED WITH THE OTHER SIDE SUFFICIENTLY CLAMPED AT ALL TIMES DURING OVERSIZING OPERATION.

N_SB_571208_7_BGAC_01_02

Figure A-UBGAC - Sheet 01
Modification of the Cleat to Stringer Webs RIB 7



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 006 thru 009, 012, 014 thru 015, 017

| HOLE SYMBOL | OLD ITEM | NEW ITEM | PN | DESCRIPTION | FINAL HOLE DIAMETER | | SIZE / FIT TYPE | NOTE |
|---|---|---|---|---|---|---|---|---|
| | | | | | MIN | MAX | | |
| ◉ | – | 7 | EN6115V4Y6 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |
| ⊖ | – | 8 | EN6115V4Y7 | BOLT | 7.142 mm (0.2812 in) | 7.193 mm (0.2831 in) | 2ND OVERSIZE CLEARANCE FIT | 02 |
| | | 15 | ASNA2531–4 | NUT | | | | |

**NOTE:**

02 A MAXIMUM OF TWO WASHERS, ITEM 16, PN NSA5372–416B TO BE INSTALLED UNDER EACH NUT IF NECESSARY. WASHERS MAY BE INSTALLED FOR CORRECT FASTENER GRIP LENGTH IN ACCORDANCE WITH SRM CHAPTER 51.

N_SB_571208_7_BGAC_02_03

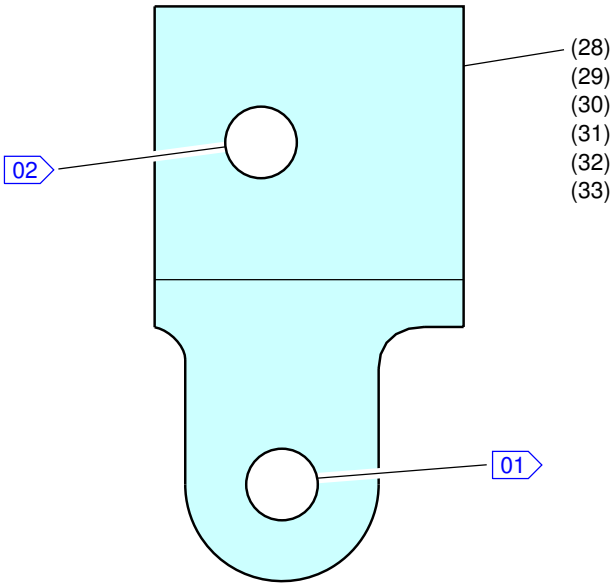
Figure A-UBGAC - Sheet 02
Modification of the Cleat to Stringer Webs RIB 7



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 005, 011

## ON BENCH




TYPICAL

**NOTE:**

01 DRILL AND REAM HOLE TO A DIAMETER BETWEEN 7.938 mm (0.3126 in) AND 7.988 mm (0.3144 in).

02 DRILL AND REAM HOLE TO A DIAMETER BETWEEN 7.142 mm (0.2812 in) AND 7.193 mm (0.2831 in).

N_SB_571208_7_BHAA_01_02

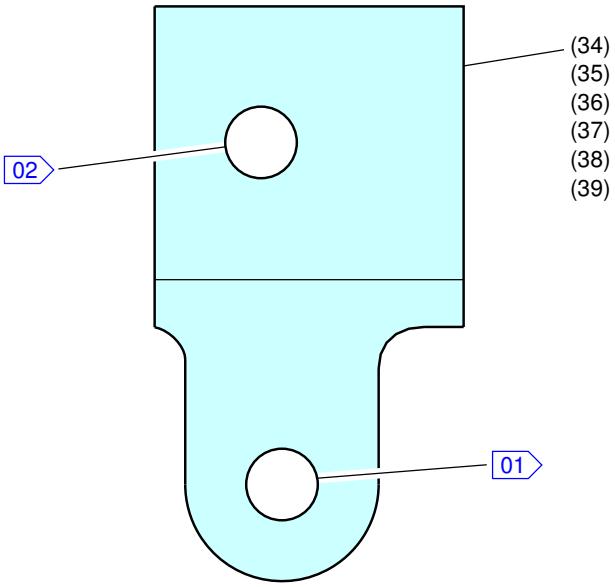
Figure A-UBHAA - Sheet 01
Enlargement of the Metallic Packer holes



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 009, 015

## ON BENCH




TYPICAL

**NOTE:**

01 DRILL AND REAM HOLE TO A DIAMETER BETWEEN 7.938 mm (0.3126 in) AND 7.988 mm (0.3144 in).

02 DRILL AND REAM HOLE TO A DIAMETER BETWEEN 7.142 mm (0.2812 in) AND 7.193 mm (0.2831 in).

N_SB_571208_7_BHAB_01_00

Figure A-UBHAB - Sheet 01
Enlargement of the Metallic Packer holes



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF ALL

(1) For an explanation of the man-hours and elapsed time, refer to the next page(s).

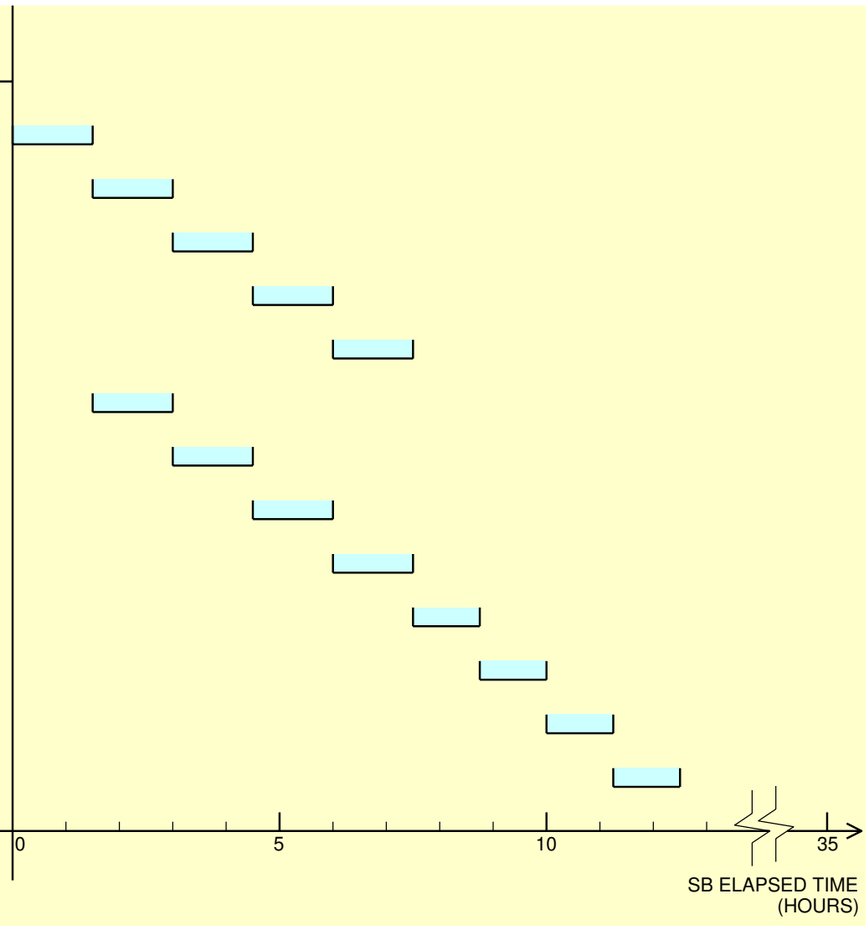


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 001, 004, 008, 013 thru 014

**ELAPSED TIME ASSUMPTIONS SERVICE BULLETIN No A320–57–1208** 01 02

| STEPS | MH | PER | ET/S |
|---|---|---|---|
| GET ACCESS | 1.50 | 1 | 1.50 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 2 LH | 3.00 | 2 | 1.50 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 2 LH | 3.00 | 2 | 1.50 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 2 LH | 3.00 | 2 | 1.50 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 2 LH | 3.00 | 2 | 1.50 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 2 RH | 3.00 | 2 | 1.50 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 2 RH | 3.00 | 2 | 1.50 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 2 RH | 3.00 | 2 | 1.50 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 2 RH | 3.00 | 2 | 1.50 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 3 LH | 2.50 | 2 | 1.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 3 LH | 2.50 | 2 | 1.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 3 LH | 2.50 | 2 | 1.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 3 LH | 2.50 | 2 | 1.25 |




TOTAL MANHOURS 125.00
SB ELAPSED TIME 34.50

**NOTES:**

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

N_SB_571208_7_AAAA_01_02

Figure A-UAAAA - Sheet 01
Manpower Gantt Chart

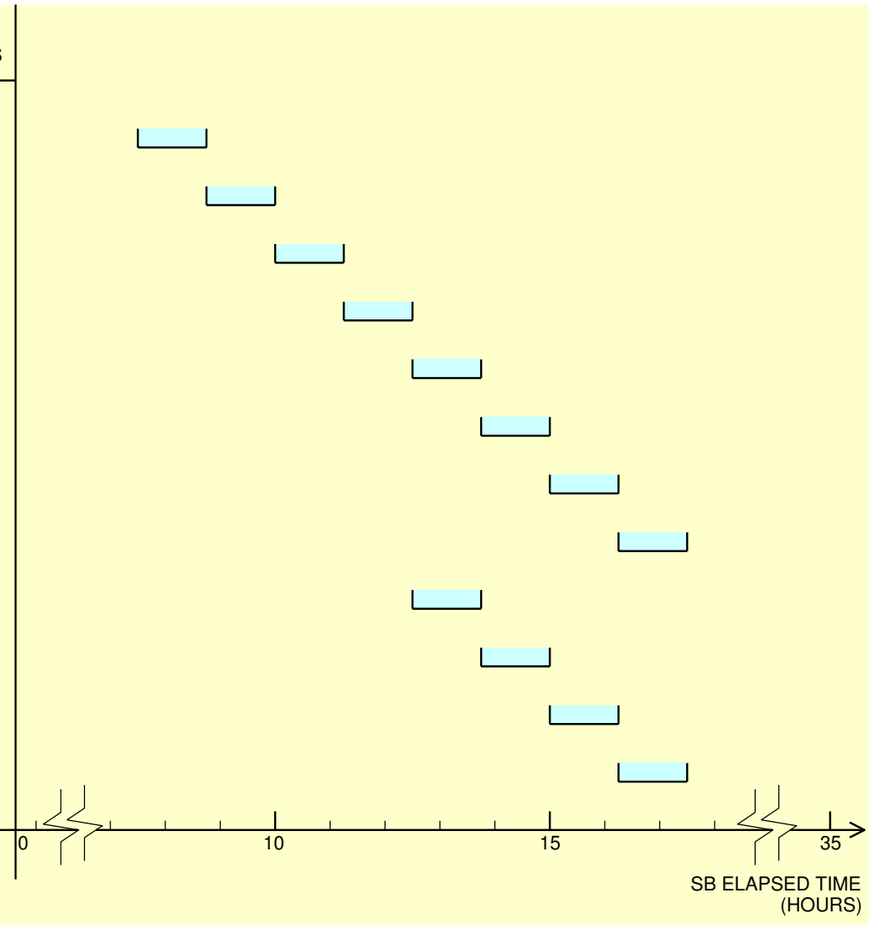


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 001, 004, 008, 013 thru 014

**ELAPSED TIME ASSUMPTIONS SERVICE BULLETIN No A320–57–1208** 01 02

| STEPS | MH | PER | ET/S |
|---|---|---|---|
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 3 RH | 2.50 | 2 | 1.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 3 RH | 2.50 | 2 | 1.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 3 RH | 2.50 | 2 | 1.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 3 RH | 2.50 | 2 | 1.25 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 4 LH | 2.50 | 2 | 1.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 4 LH | 2.50 | 2 | 1.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 4 LH | 2.50 | 2 | 1.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 4 LH | 2.50 | 2 | 1.25 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 4 RH | 2.50 | 2 | 1.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 4 RH | 2.50 | 2 | 1.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 4 RH | 2.50 | 2 | 1.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 4 RH | 2.50 | 2 | 1.25 |




TOTAL MANHOURS 125.00
SB ELAPSED TIME 34.50

**NOTES:**

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

N_SB_571208_7_AAAA_02_02

Figure A-UAAAA - Sheet 02
Manpower Gantt Chart

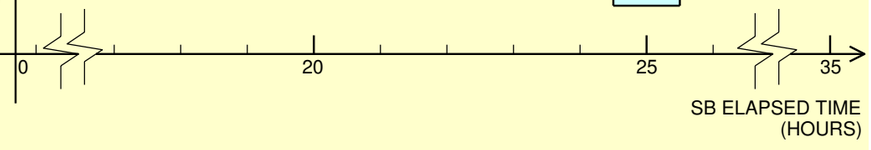


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 001, 004, 008, 013 thru 014

**ELAPSED TIME ASSUMPTIONS SERVICE BULLETIN No A320–57–1208** 01 02

| STEPS | MH | PER | ET/S |
|---|---|---|---|
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 5 LH | 2.00 | 2 | 1.00 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 5 LH | 2.00 | 2 | 1.00 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 5 LH | 2.00 | 2 | 1.00 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 5 LH | 2.00 | 2 | 1.00 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 5 RH | 2.00 | 2 | 1.00 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 5 RH | 2.00 | 2 | 1.00 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 5 RH | 2.00 | 2 | 1.00 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 5 RH | 2.00 | 2 | 1.00 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 6 LH | 2.00 | 2 | 1.00 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 6 LH | 2.00 | 2 | 1.00 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 6 LH | 2.00 | 2 | 1.00 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 6 LH | 2.00 | 2 | 1.00 |




TOTAL MANHOURS 125.00
SB ELAPSED TIME 34.50

**NOTES:**

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

N_SB_571208_7_AAAA_03_02

Figure A-UAAAA - Sheet 03
Manpower Gantt Chart

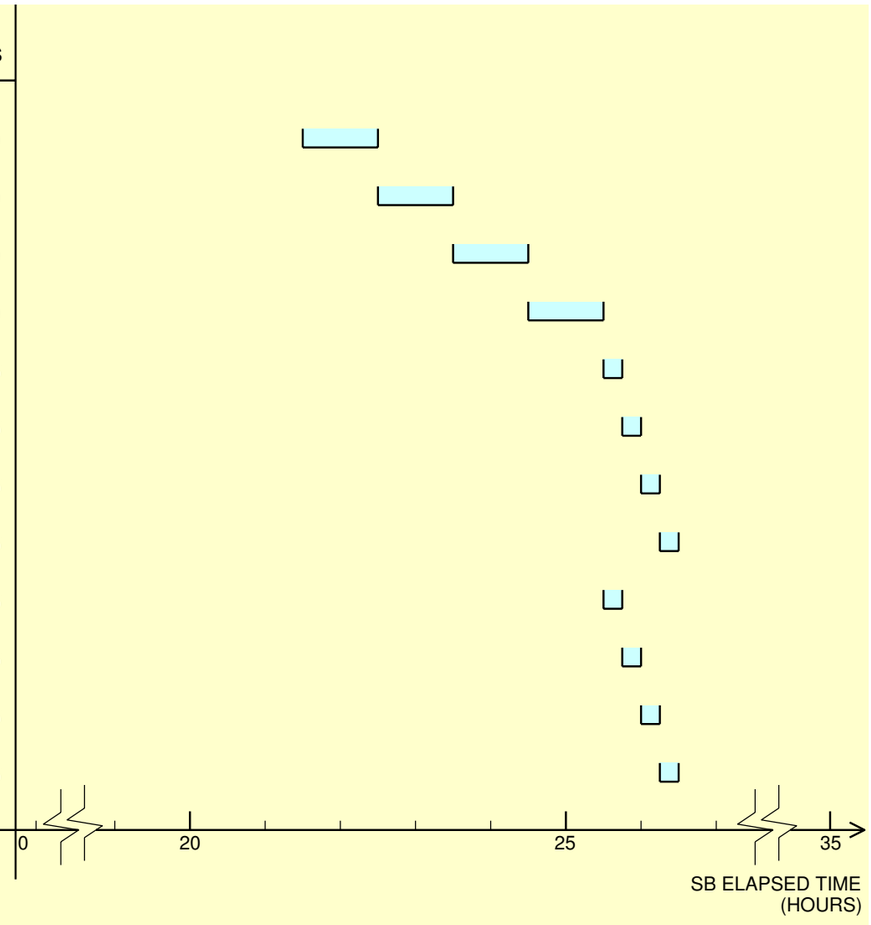


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 001, 004, 008, 013 thru 014

**ELAPSED TIME ASSUMPTIONS SERVICE BULLETIN No A320–57–1208** 01 02

| STEPS | MH | PER | ET/S |
|---|---|---|---|
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 6 RH | 2.00 | 2 | 1.00 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 6 RH | 2.00 | 2 | 1.00 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 6 RH | 2.00 | 2 | 1.00 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 6 RH | 2.00 | 2 | 1.00 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 6B LH | 0.50 | 2 | 0.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 6B LH | 0.50 | 2 | 0.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 6B LH | 0.50 | 2 | 0.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 6B LH | 0.50 | 2 | 0.25 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 6B RH | 0.50 | 2 | 0.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 6B RH | 0.50 | 2 | 0.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 6B RH | 0.50 | 2 | 0.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 6B RH | 0.50 | 2 | 0.25 |




TOTAL MANHOURS 125.00
SB ELAPSED TIME 34.50

MH : MANHOURS
PER : NUMBER OF PERSONS
ET/S: ELAPSED TIME PER STEP

**NOTES:**

01 THIS CHART IS ONLY A PROPOSAL.
OPERATORS MAY DETERMINE THAT ANOTHER WAY TO DO THE WORK IS MORE SUITABLE FOR THEM.

02 IF A VSB IS INVOLVED, THE ASSOCIATED MANHOURS ARE NOT REFLECTED IN THIS GANTT CHART.

N_SB_571208_7_AAAA_04_02

Figure A-UAAAA - Sheet 04
Manpower Gantt Chart

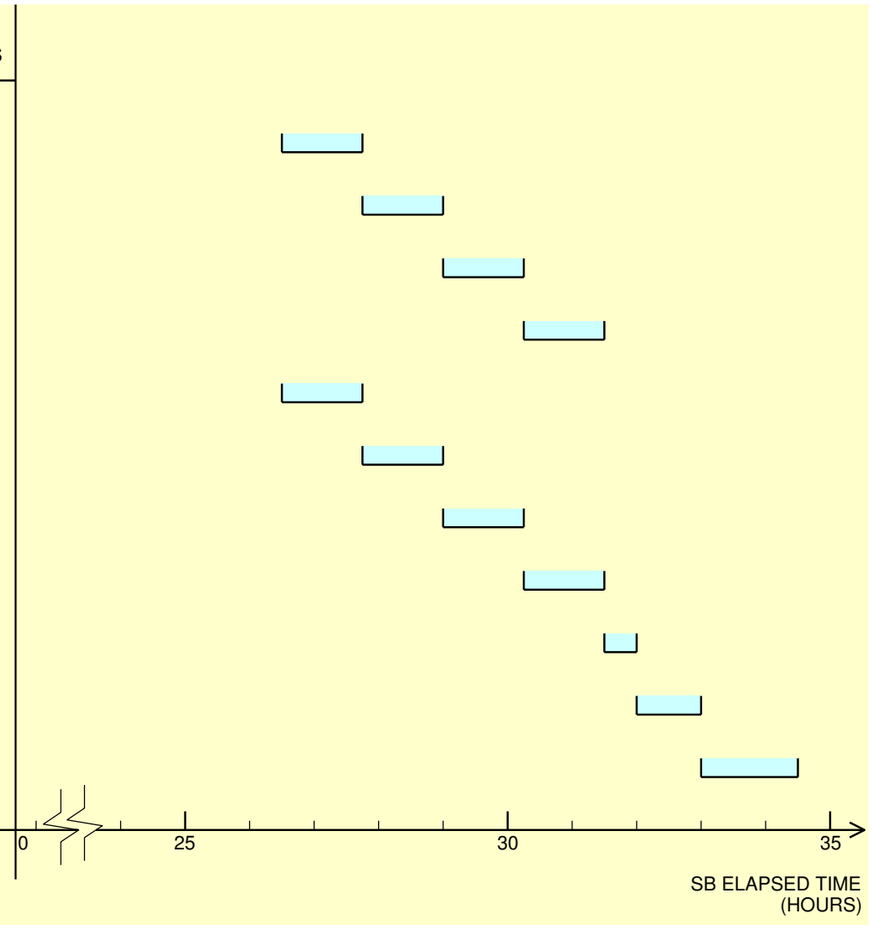


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 001, 004, 008, 013 thru 014

**ELAPSED TIME ASSUMPTIONS SERVICE BULLETIN No A320–57–1208** 01 02

| STEPS | MH | PER | ET/S |
|---|---|---|---|
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 7 LH | 2.50 | 2 | 1.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB RIB 7 LH | 2.50 | 2 | 1.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 7 LH | 2.50 | 2 | 1.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 7 LH | 2.50 | 2 | 1.25 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 7 RH | 2.50 | 2 | 1.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 7 RH | 2.50 | 2 | 1.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 7 RH | 2.50 | 2 | 1.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 7 RH | 2.50 | 2 | 1.25 |
| REPLACE THE LP FUEL FILTERS | 1.00 | 2 | 0.50 |
| TESTS | 1.00 | 1 | 1.00 |
| CLOSE–UP | 1.50 | 1 | 1.50 |




TOTAL MANHOURS 125.00
SB ELAPSED TIME 34.50

**NOTES:**

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

N_SB_571208_7_AAAA_05_02

Figure A-UAAAA - Sheet 05
Manpower Gantt Chart

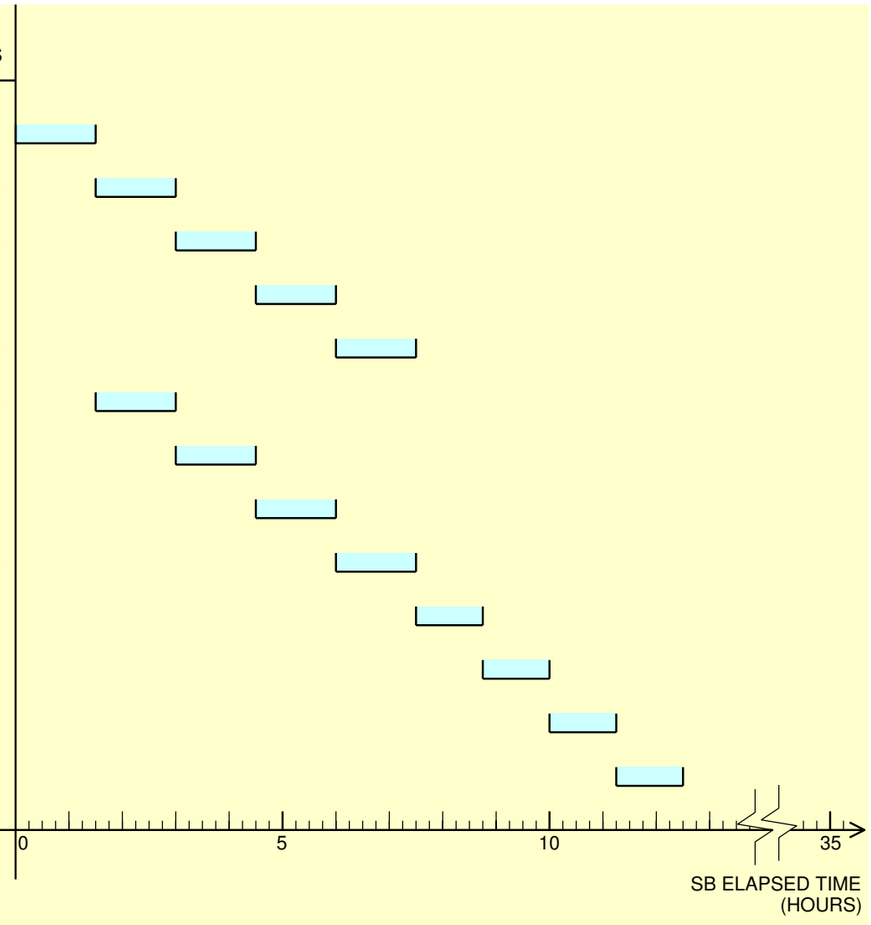


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 002 thru 003, 006 thru 007, 010, 012, 016 thru 017

**ELAPSED TIME ASSUMPTIONS SERVICE BULLETIN No A320–57–1208** 01 02

| STEPS | MH | PER | ET/S |
|---|---|---|---|
| GET ACCESS | 1.50 | 1 | 1.50 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 2 LH | 3.00 | 2 | 1.50 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 2 LH | 3.00 | 2 | 1.50 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 2 LH | 3.00 | 2 | 1.50 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 2 LH | 3.00 | 2 | 1.50 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 2 RH | 3.00 | 2 | 1.50 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 2 RH | 3.00 | 2 | 1.50 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 2 RH | 3.00 | 2 | 1.50 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 2 RH | 3.00 | 2 | 1.50 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 3 LH | 2.50 | 2 | 1.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 3 LH | 2.50 | 2 | 1.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 3 LH | 2.50 | 2 | 1.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 3 LH | 2.50 | 2 | 1.25 |




TOTAL MANHOURS 121.00
SB ELAPSED TIME 33.50

MH : MANHOURS
PER : NUMBER OF PERSONS
ET/S: ELAPSED TIME PER STEP

**NOTES:**

01 THIS CHART IS ONLY A PROPOSAL.
OPERATORS MAY DETERMINE THAT ANOTHER WAY TO DO THE WORK IS MORE SUITABLE FOR THEM.

02 IF A VSB IS INVOLVED, THE ASSOCIATED MANHOURS ARE NOT REFLECTED IN THIS GANTT CHART.

N_SB_571208_7_AAAB_01_02

Figure A-UAAAB - Sheet 01
Manpower Gantt Chart

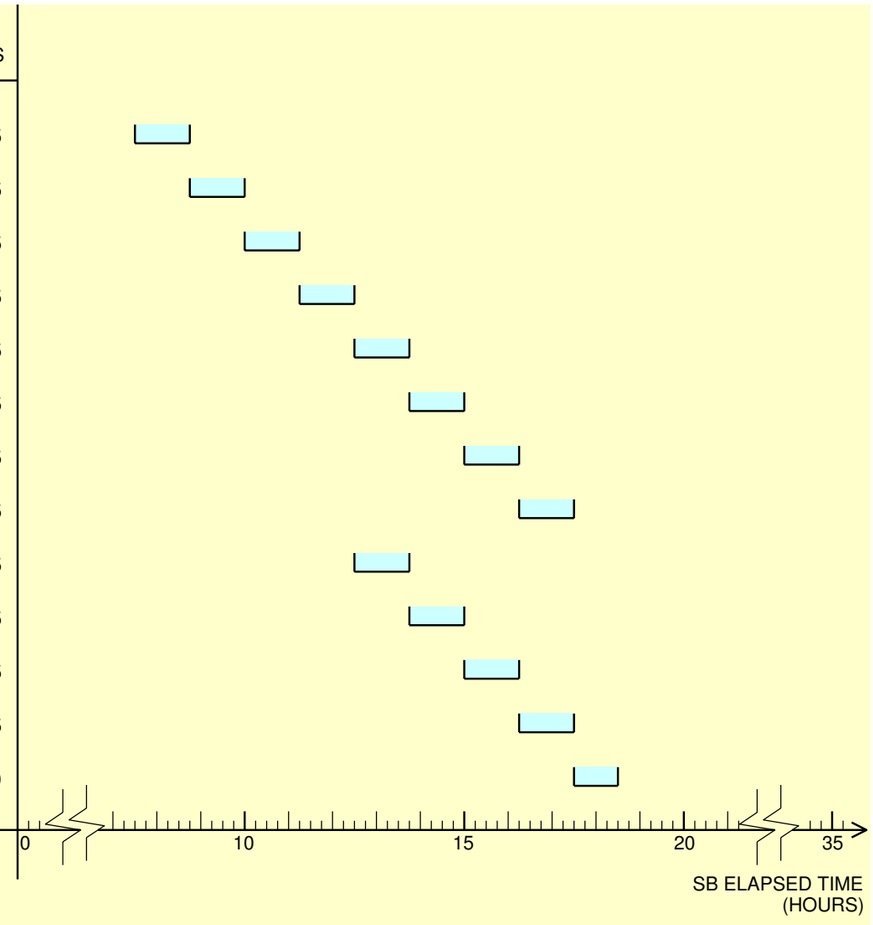


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 002 thru 003, 006 thru 007, 010, 012, 016 thru 017

**ELAPSED TIME ASSUMPTIONS SERVICE BULLETIN No A320–57–1208** 01 02

| STEPS | MH | PER | ET/S |
|---|---|---|---|
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 3 RH | 2.50 | 2 | 1.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 3 RH | 2.50 | 2 | 1.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 3 RH | 2.50 | 2 | 1.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 3 RH | 2.50 | 2 | 1.25 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 4 LH | 2.50 | 2 | 1.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 4 LH | 2.50 | 2 | 1.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 4 LH | 2.50 | 2 | 1.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 4 LH | 2.50 | 2 | 1.25 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 4 RH | 2.50 | 2 | 1.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 4 RH | 2.50 | 2 | 1.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 4 RH | 2.50 | 2 | 1.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 4 RH | 2.50 | 2 | 1.25 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 5 LH | 2.00 | 2 | 1.00 |




TOTAL MANHOURS 121.00
SB ELAPSED TIME 33.50

**NOTES:**

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

N_SB_571208_7_AAAB_02_02

Figure A-UAAAB - Sheet 02
Manpower Gantt Chart

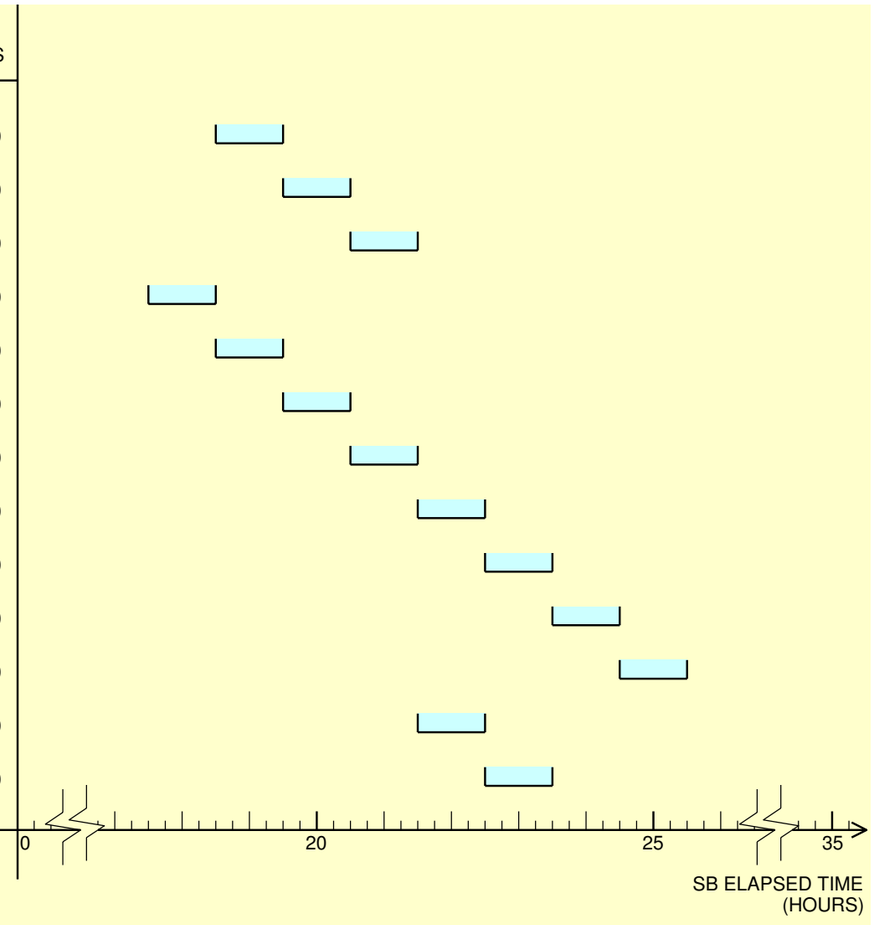


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 002 thru 003, 006 thru 007, 010, 012, 016 thru 017

**ELAPSED TIME ASSUMPTIONS SERVICE BULLETIN No A320–57–1208** 01 02

| STEPS | MH | PER | ET/S |
|---|---|---|---|
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 5 LH | 2.00 | 2 | 1.00 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 5 LH | 2.00 | 2 | 1.00 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 5 LH | 2.00 | 2 | 1.00 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 5 RH | 2.00 | 2 | 1.00 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 5 RH | 2.00 | 2 | 1.00 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 5 RH | 2.00 | 2 | 1.00 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 5 RH | 2.00 | 2 | 1.00 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 6 LH | 2.00 | 2 | 1.00 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 6 LH | 2.00 | 2 | 1.00 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 6 LH | 2.00 | 2 | 1.00 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 6 LH | 2.00 | 2 | 1.00 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 6 RH | 2.00 | 2 | 1.00 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 6 RH | 2.00 | 2 | 1.00 |




TOTAL MANHOURS 121.00
SB ELAPSED TIME 33.50

**NOTES:**

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

N_SB_571208_7_AAAB_03_02

Figure A-UAAAB - Sheet 03
Manpower Gantt Chart

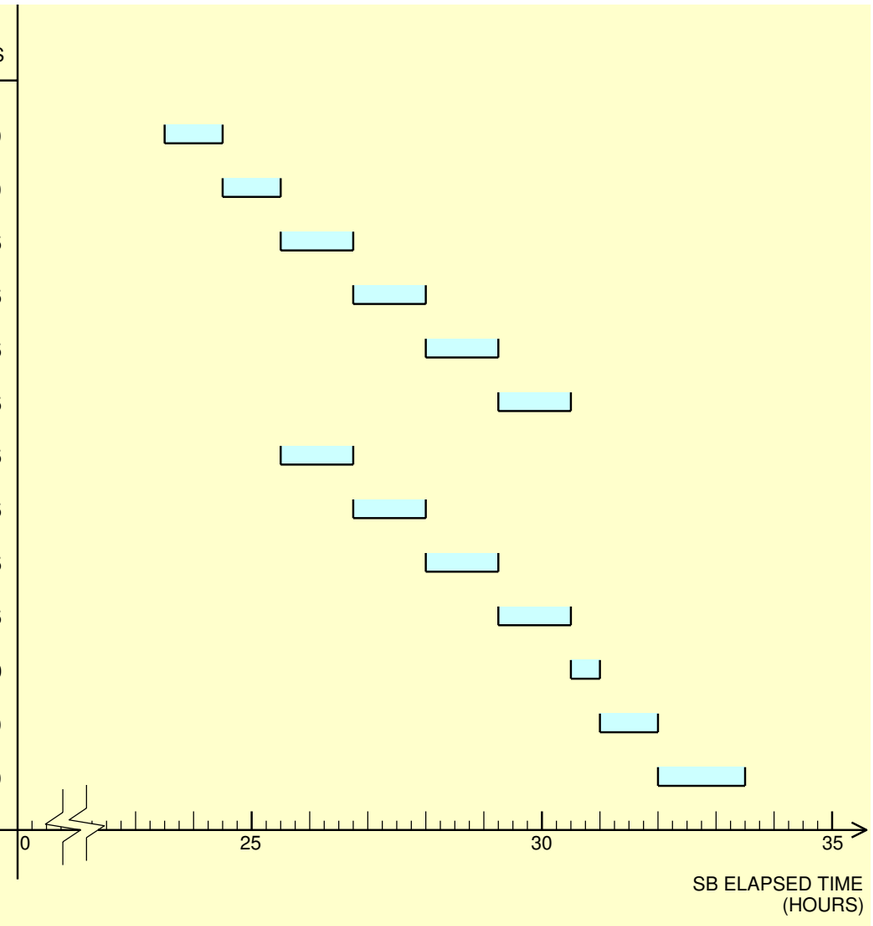


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 002 thru 003, 006 thru 007, 010, 012, 016 thru 017

**ELAPSED TIME ASSUMPTIONS SERVICE BULLETIN No A320–57–1208** 01 02

| STEPS | MH | PER | ET/S |
|---|---|---|---|
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 6 RH | 2.00 | 2 | 1.00 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 6 RH | 2.00 | 2 | 1.00 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 7 LH | 2.50 | 2 | 1.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB RIB 7 LH | 2.50 | 2 | 1.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 7 LH | 2.50 | 2 | 1.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 7 LH | 2.50 | 2 | 1.25 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 7 RH | 2.50 | 2 | 1.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 7 RH | 2.50 | 2 | 1.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 7 RH | 2.50 | 2 | 1.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 7 RH | 2.50 | 2 | 1.25 |
| REPLACE THE LP FUEL FILTERS | 1.00 | 2 | 0.50 |
| TESTS | 1.00 | 1 | 1.00 |
| CLOSE–UP | 1.50 | 1 | 1.50 |




TOTAL MANHOURS 121.00
SB ELAPSED TIME 33.50

**NOTES:**

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

N_SB_571208_7_AAAB_04_02

Figure A-UAAAB - Sheet 04
Manpower Gantt Chart

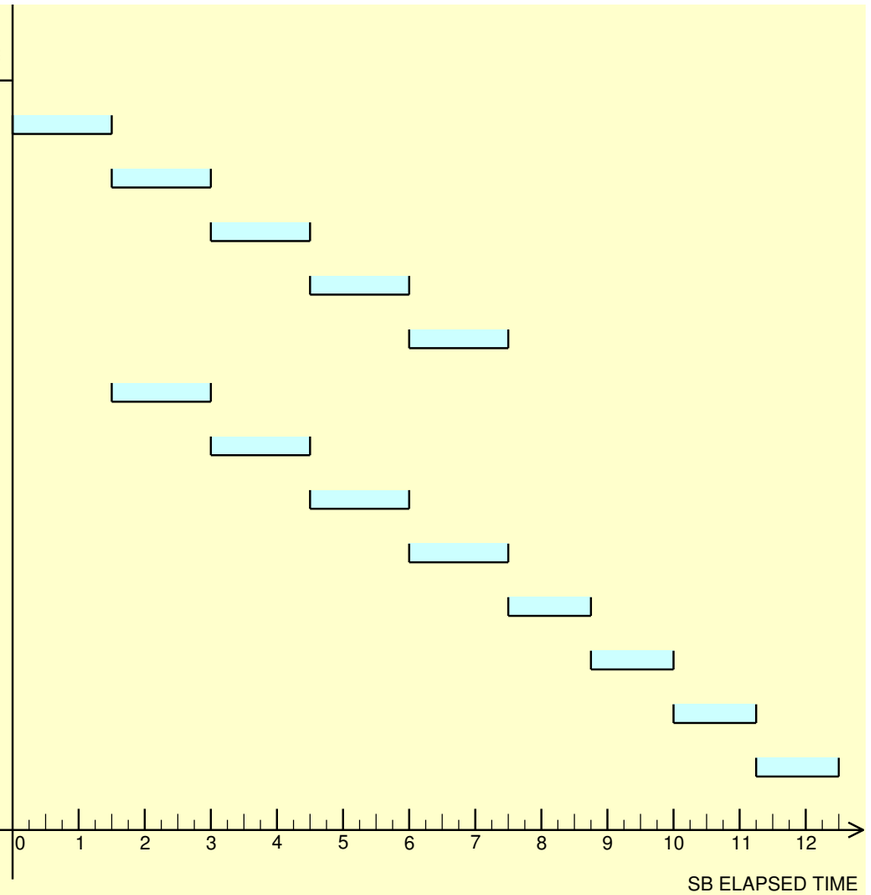


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 005, 009, 011, 015

**ELAPSED TIME ASSUMPTIONS SERVICE BULLETIN No A320–57–1208** 01 02

| STEPS | MH | PER | ET/S |
|---|---|---|---|
| GET ACCESS | 1.50 | 1 | 1.50 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 2 LH | 3.00 | 2 | 1.50 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 2 LH | 3.00 | 2 | 1.50 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 2 LH | 3.00 | 2 | 1.50 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 2 LH | 3.00 | 2 | 1.50 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 2 RH | 3.00 | 2 | 1.50 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 2 RH | 3.00 | 2 | 1.50 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 2 RH | 3.00 | 2 | 1.50 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 2 RH | 3.00 | 2 | 1.50 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 3 LH | 2.50 | 2 | 1.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 3 LH | 2.50 | 2 | 1.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 3 LH | 2.50 | 2 | 1.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 3 LH | 2.50 | 2 | 1.25 |




TOTAL MANHOURS 127.00
SB ELAPSED TIME 35.50

**NOTES:**

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

N_SB_571208_7_AAAC_01_00

Figure A-UAAAC - Sheet 01
Manpower Gantt Chart

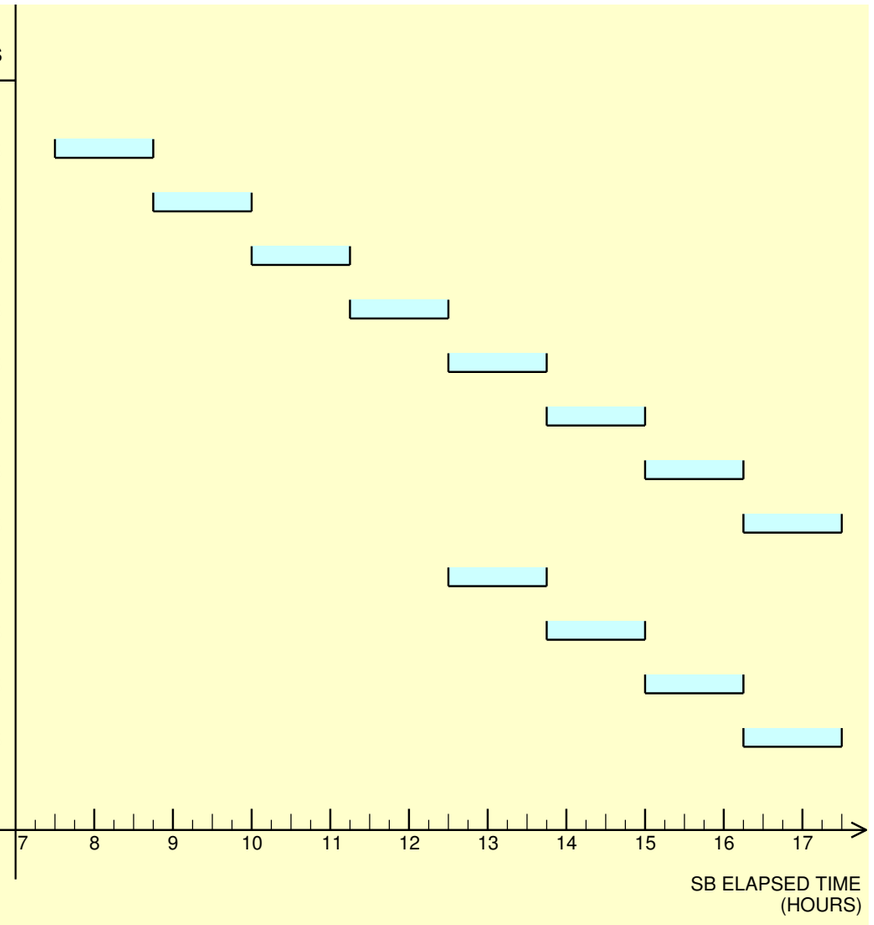


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 005, 009, 011, 015

**ELAPSED TIME ASSUMPTIONS SERVICE BULLETIN No A320–57–1208** 01 02

| STEPS | MH | PER | ET/S |
|---|---|---|---|
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 3 RH | 2.50 | 2 | 1.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 3 RH | 2.50 | 2 | 1.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 3 RH | 2.50 | 2 | 1.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 3 RH | 2.50 | 2 | 1.25 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 4 LH | 2.50 | 2 | 1.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 4 LH | 2.50 | 2 | 1.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 4 LH | 2.50 | 2 | 1.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 4 LH | 2.50 | 2 | 1.25 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 4 RH | 2.50 | 2 | 1.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 4 RH | 2.50 | 2 | 1.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 4 RH | 2.50 | 2 | 1.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 4 RH | 2.50 | 2 | 1.25 |




TOTAL MANHOURS 127.00
SB ELAPSED TIME 35.50

**NOTES:**

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

N_SB_571208_7_AAAC_02_00

Figure A-UAAAC - Sheet 02
Manpower Gantt Chart

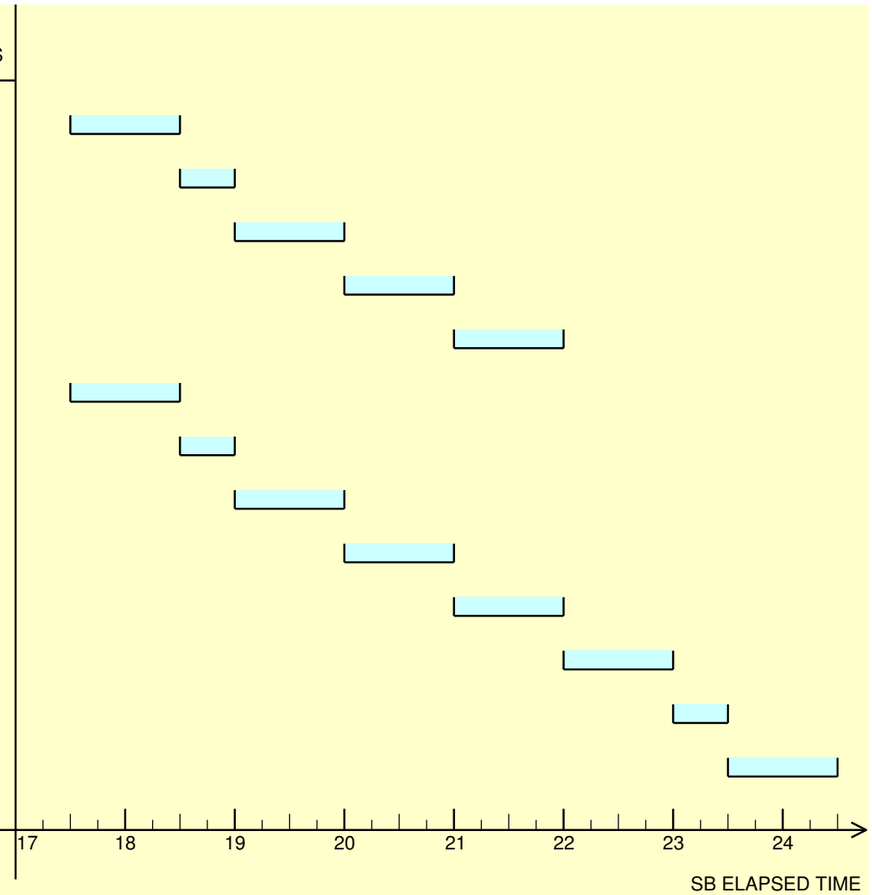


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 005, 009, 011, 015

**ELAPSED TIME ASSUMPTIONS SERVICE BULLETIN No A320–57–1208** 01 02

| STEPS | MH | PER | ET/S |
|---|---|---|---|
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 5 LH | 2.00 | 2 | 1.00 |
| OVERSIZE THE FASTENER HOLES OF THE METALLIC PACKER RIB 5 LH (ON BENCH) | 0.50 | 1 | 0.50 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 5 LH | 2.00 | 2 | 1.00 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 5 LH | 2.00 | 2 | 1.00 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 5 LH | 2.00 | 2 | 1.00 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 5 RH | 2.00 | 2 | 1.00 |
| OVERSIZE THE FASTENER HOLES OF THE METALLIC PACKER RIB 5 RH (ON BENCH) | 0.50 | 1 | 0.50 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 5 RH | 2.00 | 2 | 1.00 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 5 RH | 2.00 | 2 | 1.00 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 5 RH | 2.00 | 2 | 1.00 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 6 LH | 2.00 | 2 | 1.00 |
| OVERSIZE THE FASTENER HOLES OF THE METALLIC PACKER RIB 6 LH (ON BENCH) | 0.50 | 1 | 0.50 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 6 LH | 2.00 | 2 | 1.00 |




TOTAL MANHOURS 127.00
SB ELAPSED TIME 35.50

**NOTES:**

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

N_SB_571208_7_AAAC_03_01

Figure A-UAAAC - Sheet 03
Manpower Gantt Chart

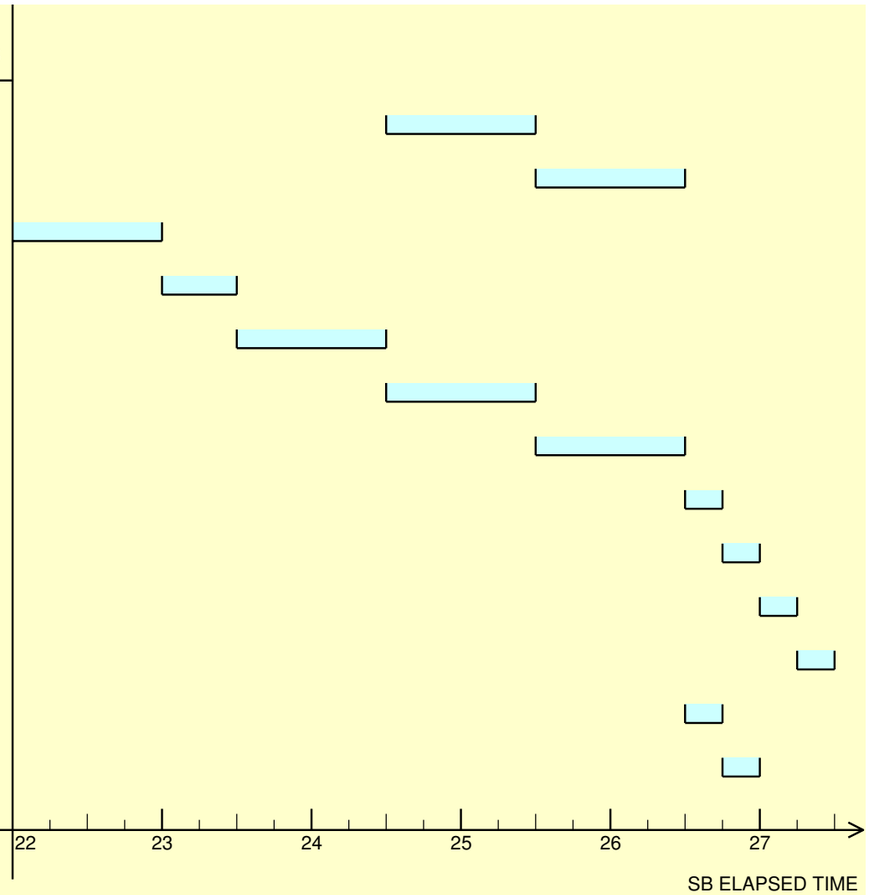


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 005, 009, 011, 015

**ELAPSED TIME ASSUMPTIONS SERVICE BULLETIN No A320–57–1208** 01 02

| STEPS | MH | PER | ET/S |
|---|---|---|---|
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 6 LH | 2.00 | 2 | 1.00 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 6 LH | 2.00 | 2 | 1.00 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 6 RH | 2.00 | 2 | 1.00 |
| OVERSIZE THE FASTENER HOLES OF THE METALLIC PACKER RIB 6 RH (ON BENCH) | 0.50 | 1 | 0.50 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 6 RH | 2.00 | 2 | 1.00 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 6 RH | 2.00 | 2 | 1.00 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 6 RH | 2.00 | 2 | 1.00 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 6B LH | 0.50 | 2 | 0.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 6B LH | 0.50 | 2 | 0.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 6B LH | 0.50 | 2 | 0.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 6B LH | 0.50 | 2 | 0.25 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 6B RH | 0.50 | 2 | 0.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 6B RH | 0.50 | 2 | 0.25 |
| TOTAL MANHOURS | 127.00 | | |
| SB ELAPSED TIME | 35.50 | | |




**NOTES:**

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

N_SB_571208_7_AAAC_04_01

Figure A-UAAAC - Sheet 04
Manpower Gantt Chart

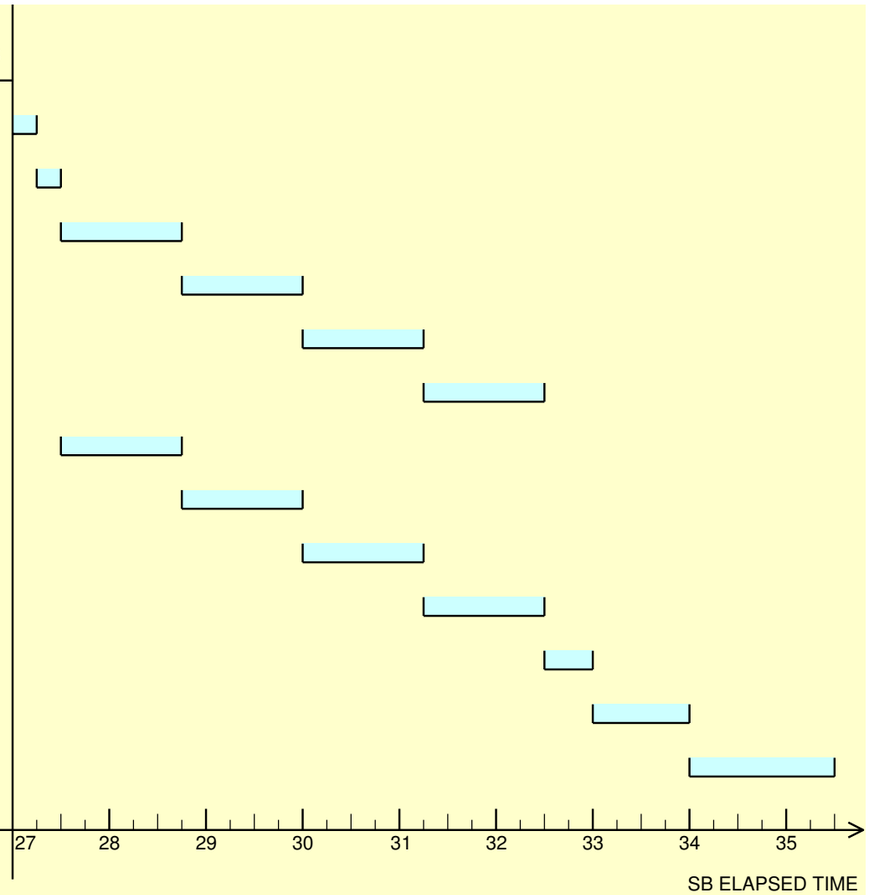


Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF 005, 009, 011, 015

**ELAPSED TIME ASSUMPTIONS SERVICE BULLETIN No A320–57–1208** 01 02

| STEPS | MH | PER | ET/S |
|---|---|---|---|
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 6B RH | 0.50 | 2 | 0.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 6B RH | 0.50 | 2 | 0.25 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 7 LH | 2.50 | 2 | 1.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB RIB 7 LH | 2.50 | 2 | 1.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 7 LH | 2.50 | 2 | 1.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 7 LH | 2.50 | 2 | 1.25 |
| REMOVE THE FASTENERS FROM THE CLEAT TO STRINGER WEBS RIB 7 RH | 2.50 | 2 | 1.25 |
| OVERSIZE THE FASTENER POSITIONS IN THE CLEAT TO STRINGER WEBS RIB 7 RH | 2.50 | 2 | 1.25 |
| DO AN EDDY CURRENT INSPECTION OF THE FASTENER POSITIONS OF THE CLEAT TO STRINGER WEBS RIB 7 RH | 2.50 | 2 | 1.25 |
| INSTALL THE FASTENERS OF THE CLEAT TO STRINGER WEBS RIB 7 RH | 2.50 | 2 | 1.25 |
| REPLACE THE LP FUEL FILTERS | 1.00 | 2 | 0.50 |
| TESTS | 1.00 | 1 | 1.00 |
| CLOSE–UP | 1.50 | 1 | 1.50 |




TOTAL MANHOURS 127.00
SB ELAPSED TIME 35.50

**NOTES:**

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

N_SB_571208_7_AAAC_05_00

Figure A-UAAAC - Sheet 05
Manpower Gantt Chart



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

# TITLE: WINGS - GENERAL - INTRODUCE UPPER CLEAT TO STRINGER ATTACHMENTS AT RIBS 2 - 7. MODIFICATION BY SB DUE TO WFD

MODIFICATION No.: 159478J4359 162156J4442

## 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.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

SERVICE BULLETIN
QUALITY PERCEPTION FORM

Use this form to tell us what is your perception of the quality of this Service Bulletin. The reported data that you provide us will be used to analyse areas of difficulties and to take corrective action to further improve the quality of our Service Bulletins.
We thank you for the time you have taken in completing this form.

(Please rate on a scale of 1 to 4, with 4 being the highest score)

| | | | | |
|---|---|---|---|---|
| - Quality rating of this SB | 4 | 3 | 2 | 1 |
| - Quality rating of the Accomplishment Instructions | 4 | 3 | 2 | 1 |
| - Quality rating of the Illustrations | 4 | 3 | 2 | 1 |
| - Is this SB easy to understand ? | Y / N | | | |

If you have had difficulties in the accomplishment of this SB please quote below the area(s) and give a short description of the issue.

| | Planning | | Material | | Instructions |
|---|---|---|---|---|---|
| X | Effectivity | X | Kit content | X | Preparation |
| X | Reason | X | List of Materials Operator Supplied | X | Mod/Inspection |
| X | Manpower | X | Industry support | X | Test |
| X | References | X | Re-identification | X | Close-Up |
| X | Publication | X | Tooling | X | Illustrations |

Comments:

Operator: Date:

Name/Title:

Please return this form to:

AIRBUS
CUSTOMER SERVICES DIRECTORATE
1 Rond Point Maurice Bellonte
31707 BLAGNAC CEDEX FRANCE

Attn : SEM4 Service Bulletins Management
FAX : (33) 5 61 93 42 51

Or via your Resident Customer Support Office.



Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.