

JIC: 14678 / 0

Title: INSPECTION OF MLG DOOR ACTUATOR FITTING ON KEEL BEAM.

Area: SYS2

ATA:

Special Codes:

A/C: BIV

Job Instruction Card for - / -

ITEM 1 - INSPECTION OF MLG DOOR ACTUATOR FITTING ON KEEL BEAM.

Panels: none
Zones: 734 (MAIN DOOR SIDE: LH), 744 (MAIN DOOR SIDE: RH)
References: EASA AD: 2012-0118 Rev.00
 SB: 53-1195 Rev.07
Material: 08BAA9 NON AQUEOUS CLEANER 1.0 req.
 NAS1149C1016R WASHER 1.0 req.
 MS24665-300 PIN-COTTER 1.0 req.
 04SAB2 VARNISH POLYURETHANE 1.0 req.
 06AAB1 POLYSULFIDE SEALANT-GENERAL 1.0 req.

STEP 01.

HEADER. APPROVAL DATA.

Prepared by : E10657 22 AUG 2017
 Approved by: P10686 22 AUG 2017

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STEP 02.

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GENERAL INFORMATION.

 **WARNING**

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

 **WARNING**

MAKE SURE THAT ALL THE CIRCUITS IN MAINTENANCE ARE ISOLATED BEFORE YOU SUPPLY ELECTRICAL POWER TO THE AIRCRAFT.

 **WARNING**

PUT THE SAFETY DEVICES AND THE WARNING NOTICES IN POSITION BEFORE YOU START A TASK ON OR NEAR:

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

 **WARNING**

OBEY THE HYDRAULIC SAFETY PROCEDURES.

 **WARNING**

MAKE SURE THAT THE GROUND SAFETY-LOCKS ARE IN POSITION ON THE LANDING GEAR AND THE WHEEL CHOCKS ARE IN POSITION.

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STEP 03.

GENERAL INFORMATION.

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 ELECTRICAL 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.

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STEP 04.

STANDARD PRACTICES.

1. Obey the general instructions when you remove and install the hydraulic components, refer to AMM Task 29-00-00-910-002.
2. Close all open tubes with blanking caps.
3. Put a spillage container in position to collect the hydraulic fluid when you disconnect a hydraulic tube.
4. Clean the inspection areas with Non Aqueous Cleaner-General 08BAA9.

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STEP 05.

Mech. Skill: B1

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PREPARATION.

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.

1. Make sure that the aircraft is electrically grounded, refer to AMM Task 12-34-24-869-002.
2. Energize the aircraft electrical circuits, refer to AMM Task 24-41-00-861-002.
3. Open the MLG doors, refer to AMM Task 32-12-00-010-001.

NOTE

Make sure that the appropriate MLG door safety equipment is installed.

4. Depressurize the Green hydraulic system, refer to AMM Task 29-10-00-864-001.
5. Disconnect the Power Transfer Unit (PTU) isolation coupling, refer to AMM Task 29-23-00-860-001.
6. Open, safety/lock and tag the applicable circuit breaker(s), refer to AMM Task 32-31-35-000-001.
7. Put the warning notices in position to tell persons not to operate the Green hydraulic system:
 - On the panel 40VU in the cockpit.
 - On the ground service panel of the Green hydraulic system.
8. Put the warning notices in the flight compartment to tell persons not to operate the landing gear doors.

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STEP 06.

Mech. Skill: B1 Dble. Rel. Skill: B1	MECH	INSP
<p>INSPECTION OF THE KEEL BEAM MLG DOOR ACTUATOR FITTINGS LH/RH ON AIRCRAFT WITH TWIN WHEEL UNDERCARRIAGE.</p> <p>1. Do a visual inspection of the keel beam MLG door actuator fittings, LH/RH, for fretting/wear and condition of bearing.</p> <p>2. Verify the correct installation and adjustment of the door actuator, especially the presence of the spacer, refer to AMM Task 32-31-35-000-001.</p> <p>Measure the dimension (A).</p> <p>Refer to Figure 01 (Sheet 01) View A, Section A-A and Figure 01 (Sheet 02), Section B-B and Section C-C.</p> <p>LH Side dimension (A): _____ mm (in).</p> <p>RH Side dimension (A): _____ mm (in).</p> <p>3. Remove the MLG door actuator 2523GM and 2522GM, refer to AMM Task 32-31-35-000-001.</p> <div style="border: 1px solid blue; padding: 5px; margin: 10px 0;"> <p style="text-align: center;"> NOTE</p> <p style="border: 1px solid black; padding: 5px;">It is possible to do the HFEC and US inspection without complete removal of the MLG door actuator. It is only necessary to disconnect the upper actuator bolt.</p> </div>		

STEP 07.

Mech. Skill: NDT Dble. Rel. Skill: NDT	MECH	INSP
<p>INSPECTION OF THE KEEL BEAM MLG DOOR ACTUATOR FITTINGS LH/RH ON AIRCRAFT WITH TWIN WHEEL UNDERCARRIAGE.</p> <p>1. Do a High Frequency Eddy-Current (HFEC) and Ultrasonic (US) inspection on the keel beam actuator fittings LH/RH for crack(s).</p> <p>Refer to NTM 53-31-54 and NTM 53-31-60.</p> <p>Refer to Figure 01 (Sheet 02).</p> <p>2. Fill in the Inspection Report attached to the Work Order.</p> <p>LH Side. Damage or crack is found (YES/NO): _____</p> <p>RH Side. Damage or crack is found (YES/NO): _____</p> <p>If a damage or crack is found provide NDT Report reference: _____</p> <p>If no damage or crack is found proceed to the Step 09.</p> <p>If damage is found but no cracks are found immediately inform Engineering Department or Customer Representative to contact AIRBUS before next flight for further repair instructions.</p> <p>If cracks are found proceed to the Step 08.</p>		

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STEP 08.

Mech. Skill: B1 Dble. Rel. Skill: B1	MECH	INSP
<p>REPLACE THE MLG DOOR ACTUATOR FITTING.</p> <p>ATTENTION! THIS STEP IS ONLY REQUIRED IN CASE OF CRACK FINDINGS IN STEP 07. MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED IF YOU DO NOT PERFORM THIS STEP.</p> <p>Replace the MLG door actuator fitting before next flight, refer to the Repair Instruction R533-70501 attached to the Work Order.</p>		

STEP 09.

Mech. Skill: B1 Dble. Rel. Skill: B1	MECH	INSP
<p>INSPECTION OF THE KEEL BEAM MLG DOOR ACTUATOR FITTINGS LH/RH ON AIRCRAFT WITH TWIN WHEEL UNDERCARRIAGE.</p> <p>1. Install/adjust the MLG door actuator 2523GM and 2522GM. Refer to AMM Task 32-31-35-400-001.</p> <p>2. Measure the gap (A). Refer to Figure 01 (Sheet 02).</p> <p>3. If the dimension (A) is less than 0.1mm (0.004in.), then correct the gap (A), proceed to the Step 10 "Modification of the keel beam MLG door upper actuator attachment LH/RH to restore gap A, if below 0.1mm (0.004in.)."</p> <p>Dimension (A) LH is: _____ mm (in).</p> <p>Dimension (A) RH is: _____ mm (in).</p>		

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STEP 10.

Mech. Skill: B1 Dble. Rel. Skill: B1

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MODIFICATION OF THE KEEL BEAM MLG DOOR UPPER ACTUATOR ATTACHMENT LH/RH TO RESTORE GAP A, IF BELOW 0.1MM (0.004IN.).

ATTENTION! THIS STEP IS ONLY REQUIRED IN CASE OF FINDINGS IN STEP 09. MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP.

NOTE

If deviation occurred from the procedure, contact Airbus to provide further action before the next flight.

1. Preparation.

Do the Job Set-up procedure as given in AMM Task 32-31-35-000-001.

2. Remove the upper actuator attachment LH/RH:

Refer to AMM Task 32-31-35-000-001.

Refer to Figure 02 (Sheet 01), Figure 02 (Sheet 02) and Figure 02 (Sheet 03).

2.1. Disconnect the connectors, Item (3) from the actuating-cylinder, Item (4).

2.2. Put blanking plugs on the disconnected line ends.

2.3. Remove from the door actuator, Item (2):

QUANTITY	NAME	FIGURE ITEM	NOTE
1	Cotter Pin	Item (9)	Discard
1	Nut	Item (7)	Retain
1	Washer	Item (6)	Retain
1	Spacer	Item (5)	Retain
1	Bolt	Item (1)	Retain

3. Install the upper actuator attachment LH/RH:

Refer to AMM Task 32-31-35-400-001.

Refer to Figure 02 (Sheet 01), Figure 02 (Sheet 02) and Figure 02 (Sheet 03).

3.1. Install:

QUANTITY	NAME	PART NUMBER	FIGURE ITEM	NOTE
1	Bolt	-	Item (1)	Retained at removal
1	Washer	NAS1149C1016R	Item 8	-
1	Nut	-	Item (7)	Retained at removal
1	Washer	-	Item (6)	Retained at removal
1	Spacer	-	Item (5)	Retained at removal

----- CONTINUE IN STEP 11 -----

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STEP 11.

Mech. Skill: B1 Dble. Rel. Skill: B1	MECH	INSP
<p>MODIFICATION OF THE KEEL BEAM MLG DOOR UPPER ACTUATOR ATTACHMENT LH/RH TO RESTORE GAP A, IF BELOW 0.1MM (0.004IN.).</p> <p style="text-align: center;">----- CONTINUED FROM STEP 10 -----</p> <p style="text-align: center;">ATTENTION! THIS STEP IS ONLY REQUIRED IN CASE OF FINDINGS IN STEP 09. MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP.</p> <p>3.2. Tighten the nuts (7). For torque values, refer to AMM Task 32-31-35-400-001.</p> <p>3.3. Make sure that the gap A between washer(s) and bracket(s) is not less than 0.1 mm (0.004 in.). If the gap is not correct then do this subtask again or inform Engineering Department or Customer Representative to contact AIRBUS before next flight for further repair instructions.</p> <p>The gap A is correct (not less than 0.1 mm (0.004 in.) YES/NO: _____</p> <p>3.4. Install 1 (one) Pin-Cotter P/N MS24665-300, Figure Item 9.</p> <p>3.5. Connect the connectors (3) to the actuating-cylinder (4) and torque to between 2.9 and 3.2 m.daN (21.39 and 23.60 lbf.ft).</p> <p>3.6. Put a mark on the connectors, Item (3) and actuating-cylinder, Item (4) connectors, apply Varnish Polyurethane - Marking Structure 04SAB2.</p> <p>3.7. Lubricate the bearings at each end of the actuating-cylinder, Item (4) through the lubrication fittings, Item (2), refer to AMM Task 12-22-32-640-001.</p> <p>3.8. Apply to the heads of the bolts, Item (1) Polysulfide Sealant - General Purpose Fillet 06AAB1.</p> <p>4. Close-up. Do the close-up procedure as given in AMM Task 32-31-35-400-001.</p>		

STEP 12.

Mech. Skill: B1 Dble. Rel. Skill: B1	MECH	INSP
<p>TEST.</p> <p>1. Remove the safety clip(s) and/or tag(s) and close/unlock the applicable circuit breaker(s), refer to AMM Task 32-31-35-400-001.</p> <p>2. Remove the access platform(s) from the work area zone 734 left-hand main landing gear door and/or zone 744 for the right-hand main landing gear door.</p> <p>3. Do the operational test of the main gear doors, refer to AMM Task 32-31-00-710-002.</p>		

STEP 13.

Mech. Skill: B1	MECH	INSP
<p>CLOSE-UP.</p> <p>1. Make sure that the work areas are clean and clear of tools and other items of equipment.</p> <p>2. Make sure that the MLG doors are closed, refer to AMM Task 32-12-00-410-001.</p> <p>3. Remove the warning notice(s).</p> <p>4. Remove the access platform(s).</p> <p>5. De-energize the ground service network, refer to AMM Task 24-42-00-862-001.</p> <p>6. Put the aircraft back to its initial configuration.</p>		

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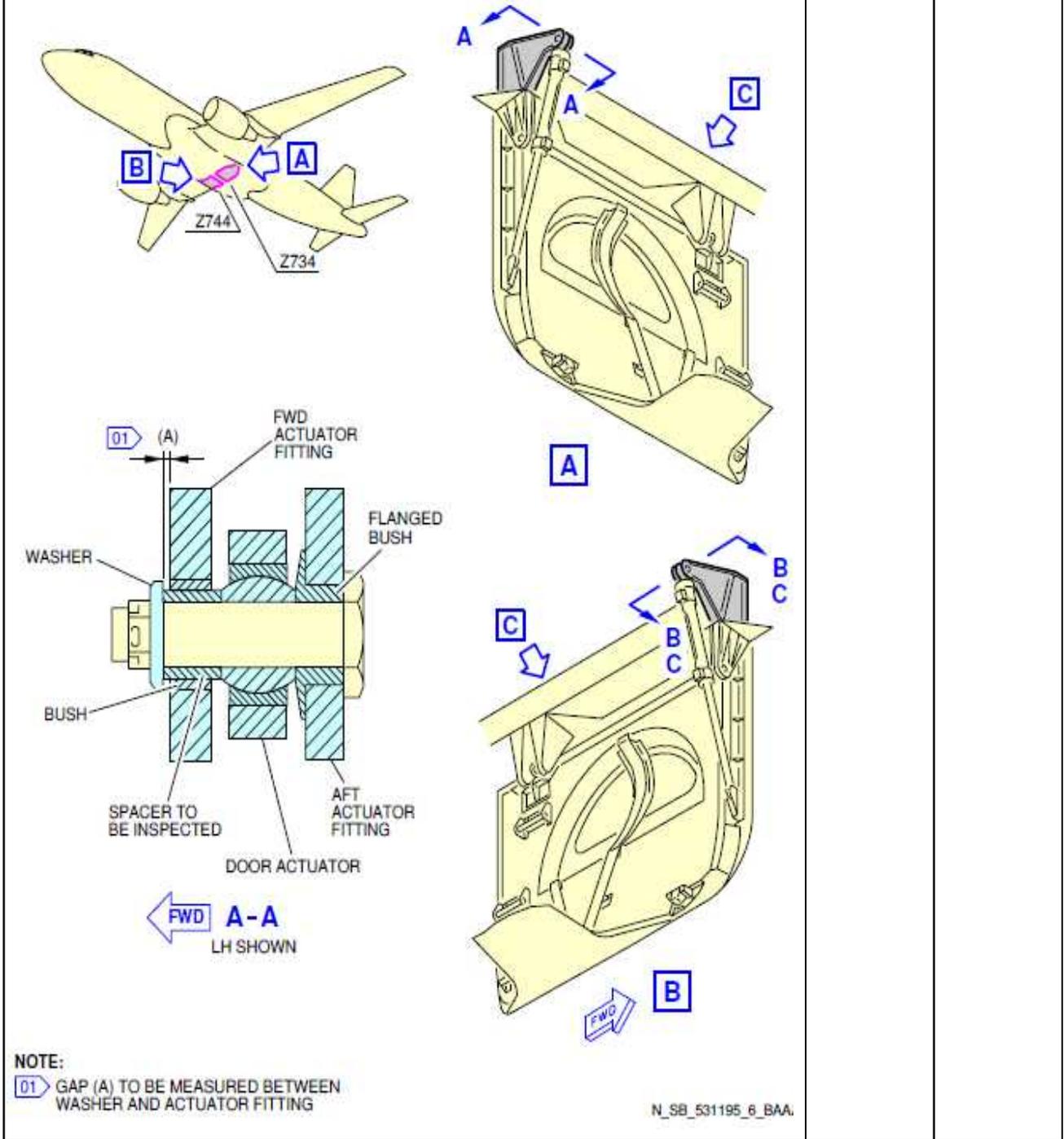
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FIGURE 01 (SHEET 01).

INSPECTION AREA.



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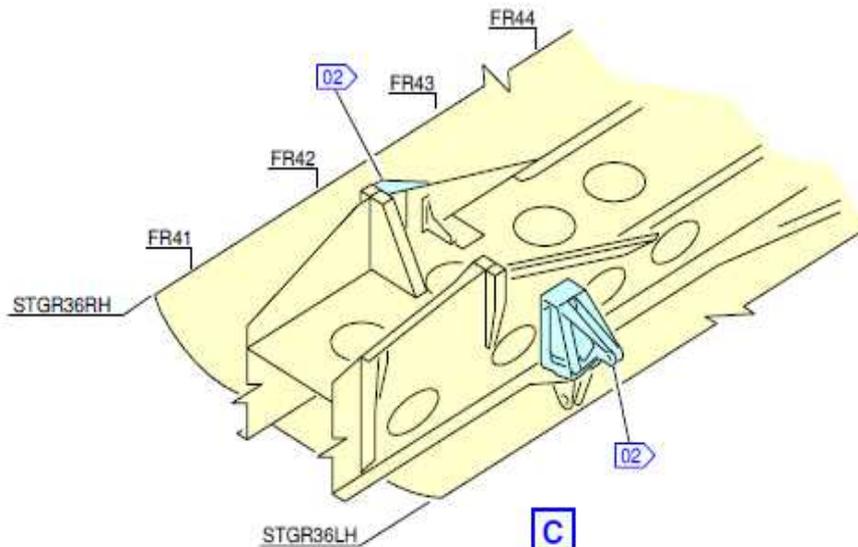
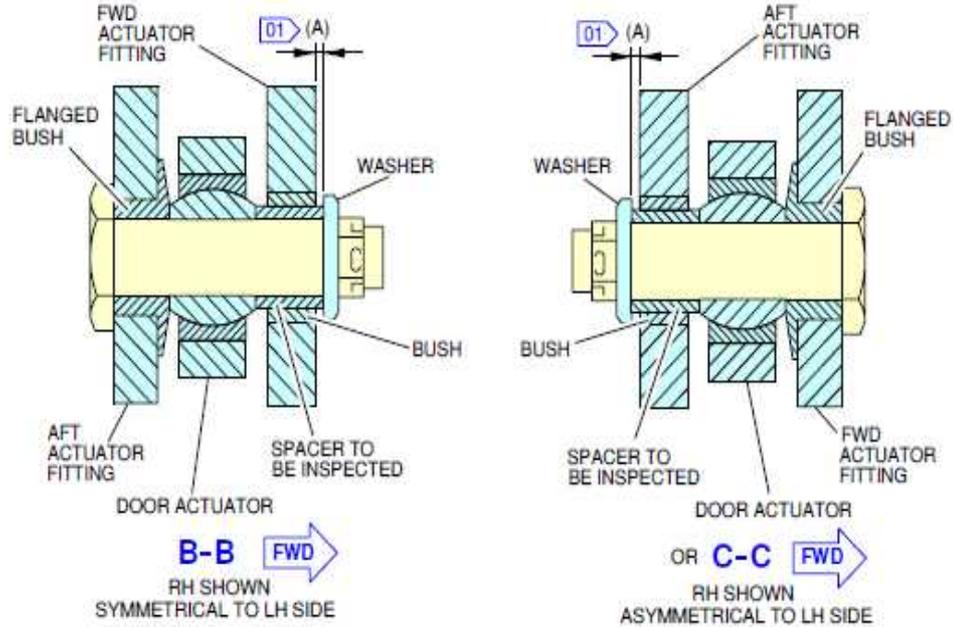
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FIGURE 01 (SHEET 02).

INSPECTION AREA.



NOTE:

- 01 GAP (A) TO BE MEASURED BETWEEN WASHER AND ACTUATOR FITTING
- 02 ACTUATOR FITTINGS TO BE INSPECTED

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ATA:

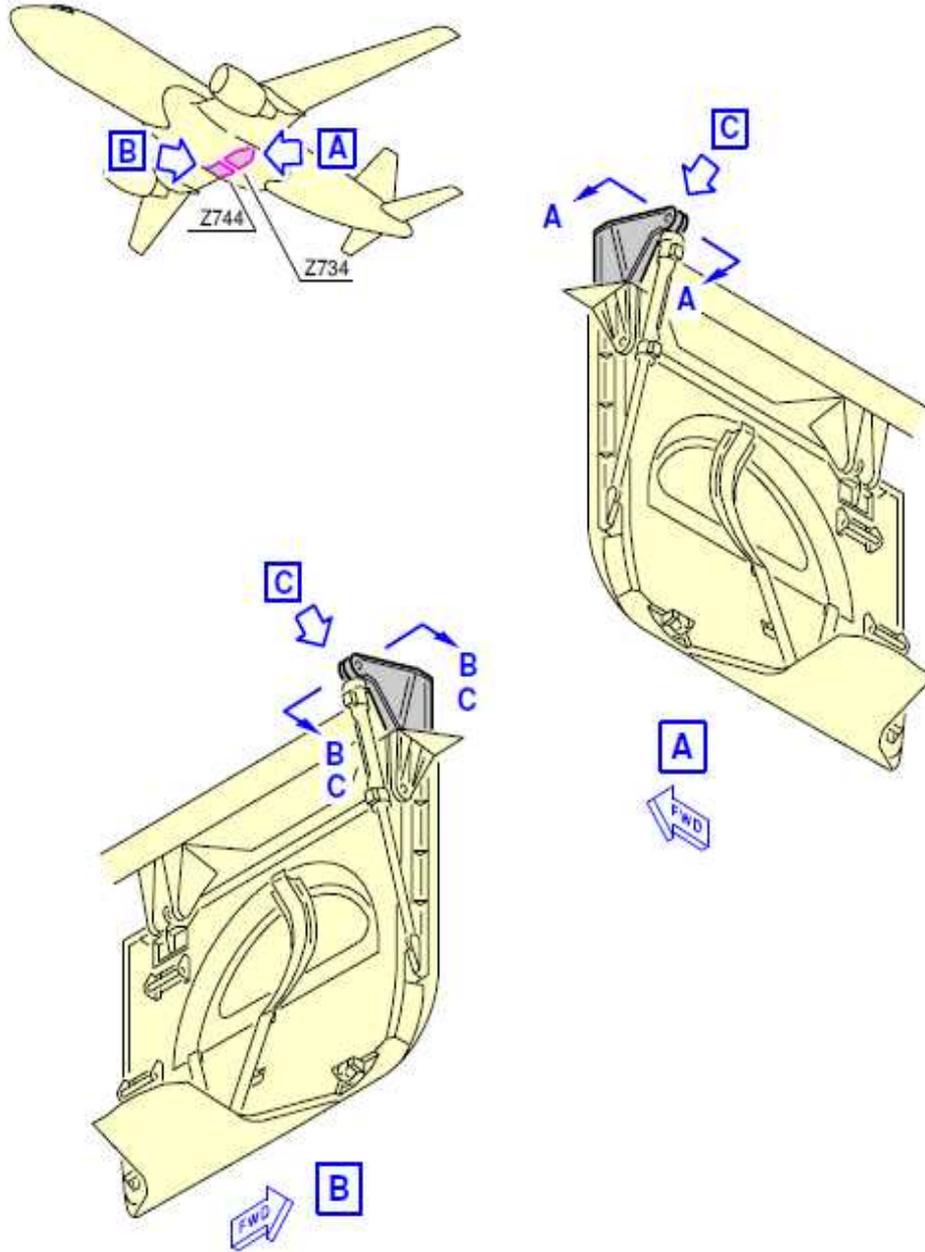
Special Codes:

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FIGURE 02 (SHEET 01).

MODIFICATION OF THE KEEL BEAM MLG DOOR UPPER ACTUATOR FITTINGS LH/RH ON AIRCRAFT WITH TWIN WHEEL UNDERCARRIAGE.



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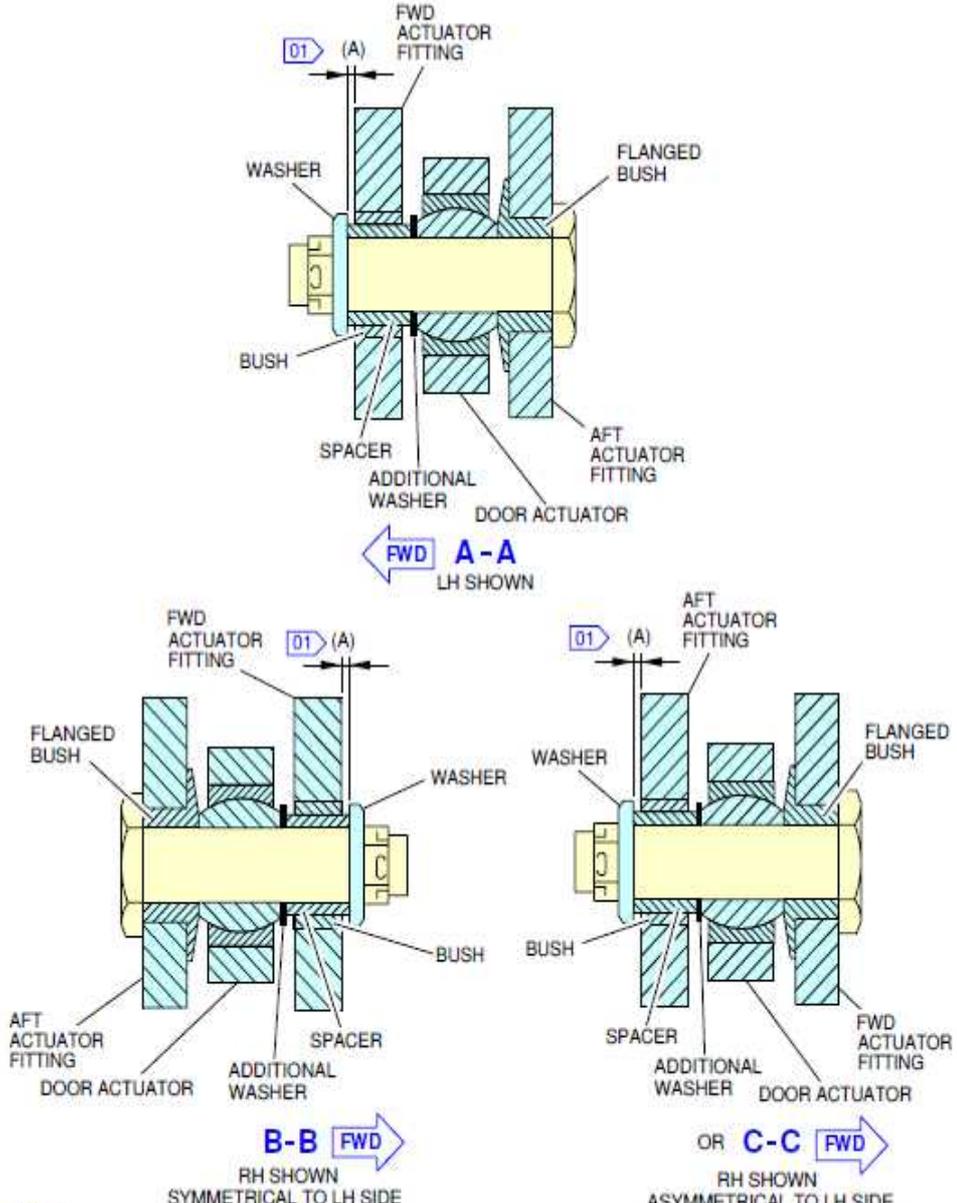
A/C: BIV

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FIGURE 02 (SHEET 02).

MODIFICATION OF THE KEEL BEAM MLG DOOR UPPER ACTUATOR FITTINGS LH/RH ON AIRCRAFT WITH TWIN WHEEL UNDERCARRIAGE.

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NOTE:
 [01] GAP (A) TO BE MEASURED BETWEEN WASHER AND ACTUATOR FITTING

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ATA:

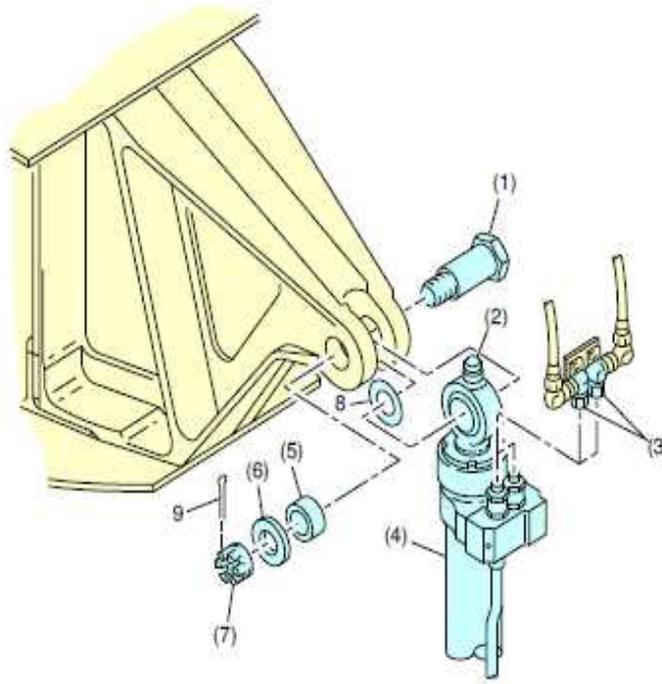
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FIGURE 02 (SHEET 03).

MODIFICATION OF THE KEEL BEAM MLG DOOR UPPER ACTUATOR FITTINGS LH/RH ON AIRCRAFT WITH TWIN WHEEL UNDERCARRIAGE.



- 02 LH SHOWN
- 03 LH SHOWN
RH SYMMETRICAL

NOTE:

- 02 FOR ASYMMETRICAL INSTALLATION OF THE BOLTS:
LH SIDE: THE BOLT, ITEM (1), MUST BE INSTALLED FROM AFT ACTUATOR FITTING WITH FLANGED BUSH
RH SIDE: THE BOLT, ITEM (1), MUST BE INSTALLED FROM FWD ACTUATOR FITTING WITH FLANGED BUSH
- 03 FOR SYMMETRICAL INSTALLATION OF THE BOLTS:
THE BOLT, ITEM (1), MUST BE INSTALLED FROM AFT ACTUATOR FITTING WITH FLANGED BUSH

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