

JIC: A320-71-11-00 / 01

Title: INLET COWL LIP SKIN INSPECTION FOR CRACKS

Area:

ATA: 71

Special Codes:

A/C: BIS

Job Instruction Card for - / -

ITEM ONE - INLET COWL LIP SKIN INSPECTION FOR CRACKS

Panels: none

Zones: 433 (AIR INTAKE LIP SIDE: LH), 434 (AIR INTAKE LIP SIDE: LH), 443 (AIR INTAKE LIP SIDE: RH), 444 (AIR INTAKE LIP SIDE: RH)

References: VSB: RA32071-120 Rev.04

STEP 01

HEADER

 **APPROVAL DATA**

Prepared by: 84506 date: 30 Nov 2016
 Approved by: 23543 date: 30 Nov 2016

MECH	INSP

STEP 02

 **NOTE**

SAFE A/C FOR MAINTENANCE

MECH	INSP

STEP 03

ENGINE #1

Perform Readout of Intake Cowl

- P/N: _____
- S/N: _____

MECH	INSP

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Do a Visual Inspection of the Intake Cowl Lip Structure (ref. SB RA32071-120)

NOTE

CRACK LENGTH IS MEASURED FROM THE EDGE OF THE COUNTERSINK TO THE END OF THE CRACK.

(1) Inspect the lip skin outer rivet hole locations for cracks.
(See Illustration 1, 2, and 3 and Table 1).

WARNING

METHYL ETHYL KETONE (MEK) IS FLAMMABLE AND VAPOR IS HARMFUL. USE IN A WELL VENTILATED AREA. AVOID LONG PERIODS OF BREATHING OR REPEATED CONTACT WITH SKIN. IT CAN CAUSE IRRITATION OF EYES, NOSE, THROAT AND SKIN. HIGH CONCENTRATION CAN CAUSE IMPAIRED JUDGEMENT.
PROTECTIVE GLOVES SHOULD BE WORN DURING USE. IT CAN CAUSE DERMATITIS BY REMOVING SKIN OILS. PRIOR TO USE OF THIS PRODUCT, CAREFULLY READ THE APPLICABLE "MATERIAL SAFETY DATA SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

(a) Wipe the lip skin outer rivet holes around the entire inlet cowl circumference with a clean cotton cloth moist with Methyl Ethyl Ketone (MEK) or equivalent. Wipe the surface dry before the MEK becomes vapor.
(b) Visually inspect the outer rivet holes around the entire inlet cowl lip skin circumference. A 10x magnifier and

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inlet cowl lip skin circumference. A 10x magnifier and flashlight may be used to aide in this inspection.
 (c) Record inspection findings i.e. crack length(s) and crack hole location(s), and report on whether SB RA32071-112 'INLET COWL – FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated, on the Inspection Report, Table 1.

(2) If no crack(s) are present, report on whether SB RA32071-112 'INLET COWL –FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated on the Inspection Report, Table 1.

(3) Inspect the lip skin inner rivet hole locations for cracks.
 a) Wipe the lip skin inner rivet holes around the entire inlet cowl circumference with a clean cotton cloth moist with Methyl Ethyl Ketone (MEK) or equivalent.
 b) Visually inspect the inner rivet holes around the entire inlet cowl lip skin circumference. A 10x magnifier and flashlight may be used to aide in this inspection.
 c) In case of finding at inner rivet row do corrective action before next flight.

 **WARNING**

FOR INNER RIVET ROW NO CRACKS ALLOWED.

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STEP 04

MECH

INSP

If cracks are found forward of the outer row fasteners they shall be evaluated as follows.

- If crack(s) are present forward of the fastener with crack length(s) up to 0.250 inch (6.35 mm), continue in service with repeat inspection at intervals of 24 months, and report on whether SB RA32071-112 'INLET COWL – FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated, on the Inspection Report, Table 1.
- If crack(s) are present forward of the fastener with crack length(s) greater than 0.250 inch (6.35mm) but less than 0.500 inch (12.7mm), continue in-service with repeat inspection at intervals of 8 months, and report on whether SB RA32071-112 'INLET COWL – FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated, on the Inspection Report, Table 1.
- If crack(s) are present forward of the fastener with crack length(s) of .500 inch (12.7 mm) or greater, repair or replace the lip skin segment(s) per the applicable SRM Repair within 4 months, and report on whether SB RA32071-112 'INLET COWL – FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated, on the Inspection Report, Table 1.

FINDINGS: YES [] NO []

In case of any Findings write in details at Table 1

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STEP 05

MECH

INSP

If cracks are found that are aft of the outer row fasteners they shall be evaluated as follows:

- Crack(s) present aft of the fastener are acceptable if it ends 0.050 inch (1.3mm) from the lipskin trailing edge. If crack length(s) are .10 inch (2.6mm) or less, continue in-service with repeat inspection within 24 months, intervals and report on whether SB RA32071-112 'INLET COWL – FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated, on the Inspection Report, Table 1.
- Crack(s) present aft of the fastener are acceptable if it ends 0.050 inch (1.3mm) from the lipskin trailing edge. If crack length(s) are greater than .10 inch (2.6mm) but meet the 0.050 inch remaining material requirement, continue in-service with repeat inspection at intervals of 8 months and report on whether SB RA32071-112 'INLET COWL – FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated, on the Inspection Report, Table 1.
- If cracks present aft of the fastener are long enough to reduce the remaining material to less than 0.050 inch (1.3 mm), repair or replace the lip skin segment(s) per the applicable SRM Repair within 4 months, and report on whether SB RA32071-112 'INLET COWL – FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated, on the Inspection Report, Table 1.

FINDINGS: YES [] NO []

In case of any Findings write in details at Table 1

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STEP 06

MECH

INSP

If outer rivet row circumferential cracks (cracks running in the direction of an adjacent fastener) are found they shall be evaluated as follows:

- Circumferential cracks are acceptable provided they are not longer than 50% of the distance between fasteners (countersink edge to countersink edge). Repeat inspection of circumferential cracks is required at intervals of 24 months.
- If circumferential cracks are longer than 50% of the distance between fasteners repair or replace the lip skin segment(s) per the applicable SRM Repair within 4 months, and report on whether SB RA32071-112 'INLET COWL – FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated, on the Inspection Report, Table 1.

FINDINGS: YES [] NO []

In case of any Findings write in details at Table 1

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STEP 08

MECH

INSP

In case of Findings (Step 4, 5, 6) open DIR with most restrictive limit according to Table 1

Transmit the Inspection Report, Table 1, to Goodrich Aerostructures. Include all pertinent aircraft information i.e. aircraft MSN, Hours/Cycles, Inlet S/N and, when applicable, crack length(s) and crack hole location(s), and report on whether SB RA32071-112 'INLET COWL – FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated.

Transmit Inspection Reports to:

- Goodrich Aerostructures Group
Attn: CFM56-5A/-5B Project Engineer
e-mail: sina.emami@goodrich.com
- structure@rossiya-airlines.com

STEP 09

MECH

INSP

ENGINE #2

Perform Readout of Intake Cowl

- P/N: _____
- S/N: _____

Do a Visual Inspection of the Intake Cowl Lip Structure (ref. SB RA32071-120)

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NOTE

CRACK LENGTH IS MEASURED FROM THE EDGE OF THE COUNTERSINK TO THE END OF THE CRACK.

- (1) Inspect the lip skin outer rivet hole locations for cracks.
(See Illustration 1, 2, and 3 and Table 2).

WARNING

METHYL ETHYL KETONE (MEK) IS FLAMMABLE AND VAPOR IS HARMFUL. USE IN A WELL VENTILATED AREA. AVOID LONG PERIODS OF BREATHING OR REPEATED CONTACT WITH SKIN. IT CAN CAUSE IRRITATION OF EYES, NOSE, THROAT AND SKIN. HIGH CONCENTRATION CAN CAUSE IMPAIRED JUDGEMENT.
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- (a) Wipe the lip skin outer rivet holes around the entire inlet cowl circumference with a clean cotton cloth moist with Methyl Ethyl Ketone (MEK) or equivalent. Wipe the surface dry before the MEK becomes vapor.
(b) Visually inspect the outer rivet holes around the entire inlet cowl lip skin circumference. A 10x magnifier and flashlight may be used to aide in this inspection.

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(c) Record inspection findings i.e. crack length(s) and crack hole location(s), and report on whether SB RA32071-112 'INLET COWL – FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated, on the Inspection Report, Table 2.

(2) If no crack(s) are present, report on whether SB RA32071-112 'INLET COWL – FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated on the Inspection Report, Table 2.

- (3) Inspect the lip skin inner rivet hole locations for cracks.
- a) Wipe the lip skin inner rivet holes around the entire inlet cowl circumference with a clean cotton cloth moist with Methyl Ethyl Ketone (MEK) or equivalent.
 - b) Visually inspect the inner rivet holes around the entire inlet cowl lip skin circumference. A 10x magnifier and flashlight may be used to aide in this inspection.
 - c) In case of finding at inner rivet row do corrective action before next flight.

 **WARNING**

FOR INNER RIVET ROW NO CRACKS ALLOWED.

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STEP 10

MECH

INSP

If cracks are found forward of the outer row fasteners they shall be evaluated as follows.

- If crack(s) are present forward of the fastener with crack length(s) up to 0.250 inch (6.35 mm), continue in service with repeat inspection at intervals of 24 months, and report on whether SB RA32071-112 'INLET COWL – FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated, on the Inspection Report, Table 2.
- If crack(s) are present forward of the fastener with crack length(s) greater than 0.250 inch (6.35mm) but less than 0.500 inch (12.7mm), continue in-service with repeat inspection at intervals of 8 months, and report on whether SB RA32071-112 'INLET COWL – FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated, on the Inspection Report, Table 2.
- If crack(s) are present forward of the fastener with crack length(s) of .500 inch (12.7 mm) or greater, repair or replace the lip skin segment(s) per the applicable SRM Repair within 4 months, and report on whether SB RA32071-112 'INLET COWL – FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated, on the Inspection Report, Table 2.

FINDINGS: YES [] NO []

In case of any Findings write in details at Table 2

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STEP 11

MECH

INSP

If cracks are found that are aft of the outer row fasteners they shall be evaluated as follows:

- Crack(s) present aft of the fastener are acceptable if it ends 0.050 inch (1.3mm) from the lipskin trailing edge. If crack length(s) are .10 inch (2.6mm) or less, continue in-service with repeat inspection within 24 months, intervals and report on whether SB RA32071-112 'INLET COWL – FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated, on the Inspection Report, Table 2.
- Crack(s) present aft of the fastener are acceptable if it ends 0.050 inch (1.3mm) from the lipskin trailing edge. If crack length(s) are greater than .10 inch (2.6mm) but meet the 0.050 inch remaining material requirement, continue in-service with repeat inspection at intervals of 8 months and report on whether SB RA32071-112 'INLET COWL – FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated, on the Inspection Report, Table 2.
- If cracks present aft of the fastener are long enough to reduce the remaining material to less than 0.050 inch (1.3 mm), repair or replace the lip skin segment(s) per the applicable SRM Repair within 4 months, and report on whether SB RA32071-112 'INLET COWL – FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated, on the Inspection Report, Table 2.

FINDINGS: YES [] NO []

In case of any Findings write in details at Table 2

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STEP 12

MECH

INSP

If outer rivet row circumferential cracks (cracks running in the direction of an adjacent fastener) are found they shall be evaluated as follows:

- Circumferential cracks are acceptable provided they are not longer than 50% of the distance between fasteners (countersink edge to countersink edge). Repeat inspection of circumferential cracks is required at intervals of 24 months.
- If circumferential cracks are longer than 50% of the distance between fasteners repair or replace the lip skin segment(s) per the applicable SRM Repair within 4 months, and report on whether SB RA32071-112 'INLET COWL – FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated, on the Inspection Report, Table 2.

FINDINGS: YES [] NO []

In case of any Findings write in details at Table 2

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STEP 14

In case of Findings (Step 10, 11, 12) open DIR with most restrictive limit according to Table 2

Transmit the Inspection Report, Table 2, to Goodrich Aerostructures. Include all pertinent aircraft information i.e. aircraft MSN, Hours/Cycles, Inlet S/N and, when applicable, crack length(s) and crack hole location(s), and report on whether SB RA32071-112 'INLET COWL – FORWARD BULKHEAD STIFFENER REMOVAL' has been incorporated.

Transmit Inspection Reports to:

- Goodrich Aerostructures Group
Attn: CFM56-5A/-5B Project Engineer
e-mail: sina.emami@goodrich.com
- structure@rossiya-airlines.com

MECH

INSP

STEP 15

 **NOTE**

Return the a/c to serviceable conditions

MECH

INSP

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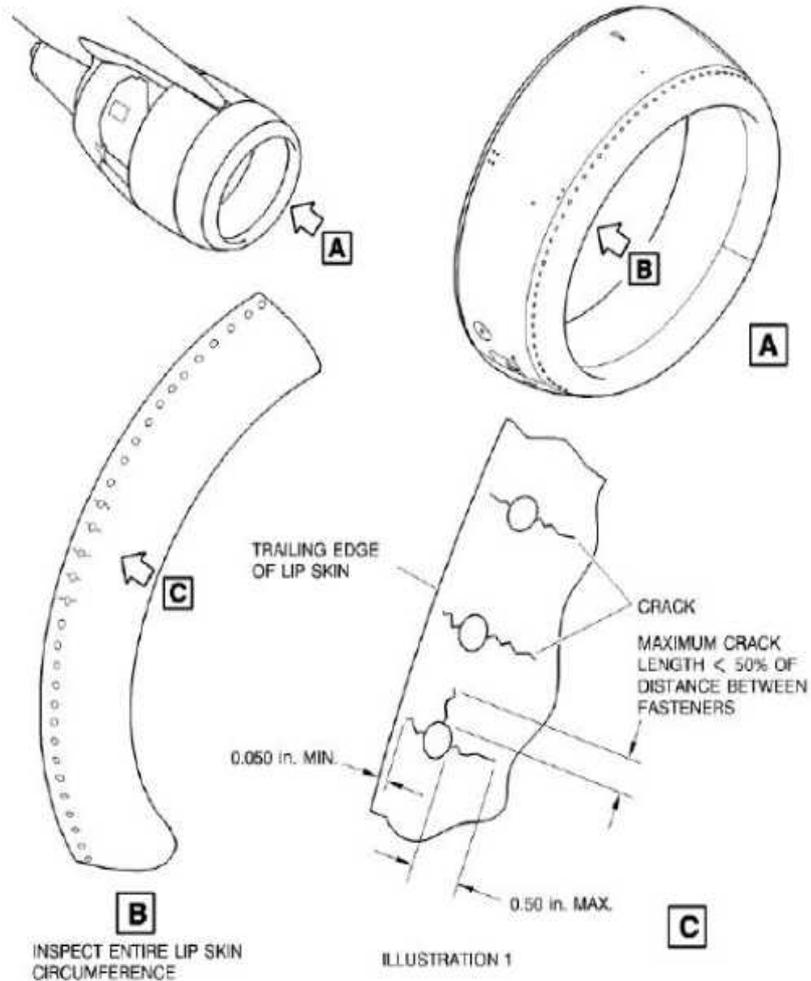
STEP 16

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Illustration 1

Goodrich Aerostructures Service Bulletin



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Illustration 2

Goodrich Aerostructures Service Bulletin

USE ILLUSTRATION 2 FOR GUIDANCE FOR RE-INSPECTION ONCE CRACKS HAVE BEEN FOUND UPON INITIAL INSPECTION.

REPEAT INSPECTION WITHIN 24 MONTHS. REPAIR WITHIN 4 MONTHS, IF CRACK LENGTH IS GREATER THAN 50% OF THE DISTANCE BETWEEN FASTENERS.

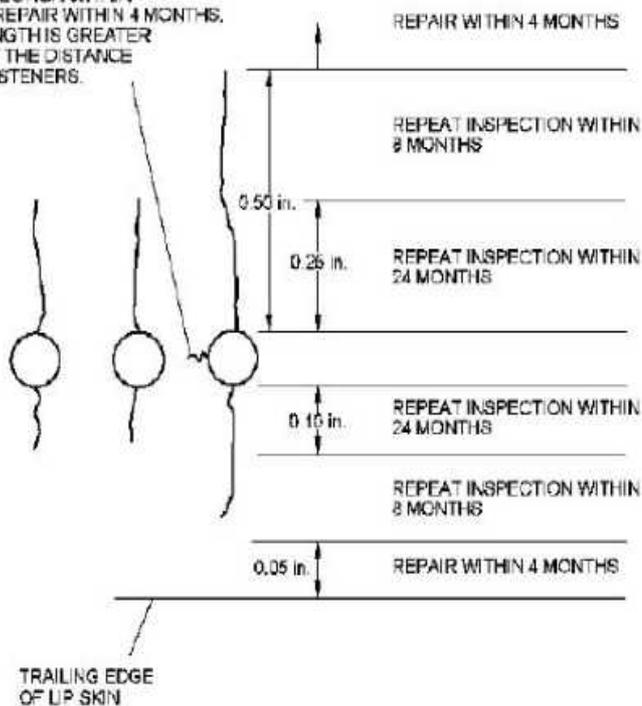


ILLUSTRATION 2

CBSB-169-02

* Use this Illustration to Identify Lip Skin Fastener No. and Segment No.

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Illustration 3

Goodrich Aerostructures Service Bulletin

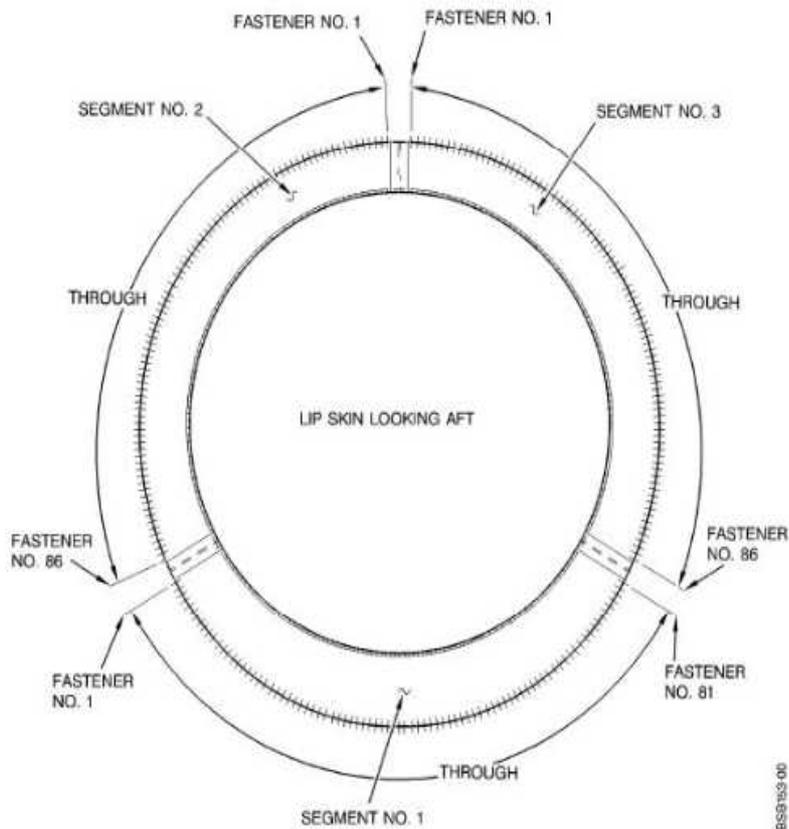


Illustration 3

PROPERTY OF "ROSSIYA AIRLINES" JSC