

JIC: **A320-71-22-00 / 01**

Title: **AD2016-0010 SB RA320710-160 INSPECTION OF AFT ENGINE MOUNT RETAINERS**

Area: **ENGINES**

ATA: **71-22**

Special Codes: **EN**

A/C: **BIV**

Job Instruction Card for - / -

INSPECTION - CFM56 ENGINE AFT MOUNT RETAINERS

Panels:	437AL (PYLON AND NACELLE - PANEL 1 - LEFT SIDE), 438AR (PYLON AND NACELLE - PANEL 1 - RIGHT SIDE), 447AL (PYLON AND NACELLE - PANEL 1 - LEFT SIDE), 448AR (PYLON AND NACELLE - PANEL 1 - RIGHT SIDE)		
Zones:	437 (FAN COWL SIDE: LH), 438 (FAN COWL SIDE: LH), 447 (FAN COWL SIDE: RH), 448 (FAN COWL SIDE: RH)		
References:	none		
Tools:	98D27803500001	TOOL-ZERO LOCKING, FLAP SLAT CTL LEV	1.0 req.
	98D71203500000	BOOTSTRAP-SYSTEM	1.0 req.

WORK STEP #1 ENGINE DATA - FOR INFORMATION

PLEASE RECORD THE ENGINE POSITION AND ENGINE SERIAL NUMBER IN THE TABLE BELOW:					
<table><tr><td>ENGINE POSITION # _____</td><td>ESN _____</td></tr></table>		ENGINE POSITION # _____	ESN _____		
ENGINE POSITION # _____	ESN _____				

WORK STEP #2 - GENERAL INFORMATION

Mech. Skill: A/B1	MECH	INSP
<p>WARNING: MAKE SURE THAT YOU OBEY ALL THE WARNINGS AND ALL THE CAUTIONS INCLUDED IN THE REFERENCED PROCEDURES.</p> <p>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:</p> <ul style="list-style-type: none"> - PUT PROTECTION, SUCH AS PLASTIC SHEETING, CLOTHS, ETC; AS NECESSARY ON WIRING AND COMPONENTS. - REGULARLY REMOVE ALL SHAVINGS, UNWANTED MATERIAL AND OTHER CONTAMINATION. <p>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.</p>		

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WORK STEP #3 - PREPARATION (00:30)

MAKE SURE THAT THE AIRCRAFT IS ELECTRICALLY GROUNDED
REFER TO AMM TASK 12-34-24-869-002.

PUT AN ACCESS PLATFORM IN POSITION.

RETRACT THE FLAPS AND THE SLATS ON THE GROUND.
REFER TO AMM TASK 27-50-00-866-009.

OPEN THE FAN COWL DOORS.
REFER TO AMM TASK 71-13-00-010-040.

OPEN THE THRUST REVERSER DOORS TO THE 45 DEGREE POSITION.
REFER TO AMM TASK 78-36-00-010-040.

MECH

INSP

WORK STEP #4 - INSPECTION OF AFT ENGINE MOUNT INNER RETAINERS (3 LOCATIONS)

NOTE: PAY CLOSE ATTENTION TO THE INNER BEND OF THE RETAINER

NOTE: THE CENTER RETAINER MAY BE DIFFICULT TO INSPECT.
IN CASE OF DOUBT, REMOVE THE RETAINER FOR INSPECTION AS PER WORK STEP 5 OF THIS JIC.

A) CLEAN ANY DIRT OR UNWANTED MATERIAL FROM THE AFT ENGINE MOUNT WITH A LINT-FREE COTTON CLOTH.

B) WITHOUT THE REMOVAL OF ANY HARDWARE, DO A VISUAL INSPECTION OF THE 238-0252-505 INNER RETAINER FOR CRACKS USING 10X MAGNIFICATION, MIRROR AND LIGHT.

I) FOR RETAINERS WITHOUT CRACKS AND NOT FAILED, NO FURTHER ACTION IS REQUIRED.
PROCEED WITH WORK STEP 9 OF THIS JIC.

II) FOR RETAINERS WHICH ARE FOUND CRACKED OR FAILED - REPLACE THE RETAINERS AS PER WORK STEP 5 OF THIS JIC.

PLEASE CONTACT TO ENGINE GROUP OF ENGINEERING DEPARTMENT FOR MORE INFORMATION (RETURN CRACKED OR FAILED HARDWARE WITH THE DATA COLLECTION AND REPORTING SHEET TO GOODRICH)

MECH

INSP

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WORK STEP #5 - REMOVAL OF OUTER RETAINERS (00:30)
MECH
INSP

NOTE: THIS TASK CAN BE ACCOMPLISHED ON WING, EVEN THOUGH CLEARANCE IS TIGHT, USING THE FOLLOWING PROCEDURES:

A) WITHOUT THE USE OF THE ENGINE BOOTSTRAP SYSTEM, REMOVE THE FOLLOWING PARTS IN ACCORDANCE WITH AMM 71-22-11-000-043 SECTION 4.A. FOR CFM56-5B AND AMM 71-22-11-000-042 SECTION 4.A. FOR CFM56-5A:

THE NAS6303U5 BOLTS, THE VN936NP3C WASHERS, THE VN936NP3 WASHERS, AND THE NAS1805-3 NUTS THAT ATTACH THE OUTER RETAINERS TO THE INNER RETAINERS REFER TO FIGURE 2. RETAIN THE HARDWARE FOR INSTALLATION.

B) REMOVE THE OUTER RETAINERS 238-0253-509 AND 238-0253-511 (OR 238-0253-507). RETAIN THE HARDWARE FOR INSTALLATION.

REFER TO FIGURE 2 AND AMM 71-22-11-000-043 SECTION 4.A. FOR CFM56-5B AND AMM 71-22-11-000-042 SECTION 4.A. FOR CFM56-5A.

C) INSPECT FOR A GAP BETWEEN THE PIN HEAD AND ANTI-ROTATION BRACKET REFER TO FIGURE 2 AND 3.

I) IF THERE IS A GAP OF MORE THAN 0.001 INCH (0.025 MM), THEN PROCEED TO WORK STEP 6 OF THIS JIC BECAUSE THE ENGINE WEIGHT MUST BE SUPPORTED PER THE AMM, CHAPTER 71-22-11.

II) IF THE GAP IS LESS THAN 0.001 INCH (0.025MM), PROCEED TO WORK STEP 7 OF THIS JIC.

WORK STEP #6 - INSTALLATION OF BOOTSTRAP SYSTEM (00:30)
MECH
INSP

NOTE: BOOTSTRAP INSTALLATION IS NECESSARY ONLY IF A GAP IS FOUND BETWEEN THE PIN HEAD AND ANTI-ROTATION BRACKET

INSTALL THE BOOTSTRAP SYSTEM TO TAKE THE ENGINE WEIGHT OFF OF THE AFT ENGINE MOUNT

1)FOR CFM56-5B - REFER TO AMM TASK 71-22-11-000-043, SUBTASK 71-22-11-480-051

2)FOR CFM56-5A - REFER TO AMM TASK 71-22-11-000-042, SUBTASK 71-22-11-480-050

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WORK STEP #7 - REPLACEMENT OF THE INNER RETAINERS (01:00)
MECH
INSP

A) INSPECT THE NUTS P/N 83642-918 AND P/N 83642-1420 FOR ANY LOOSENESS OR WEAR. IF LOOSE OR WORN, REPLACE.
RECORD THE CONDITION OF NUTS IN SHEET 1.

B) APPLY TORQUE ON LARGE NUT P/N 83642-1420 IN THE TIGHTENING DIRECTION WITH AN OPEN END TYPE ADAPTER OR A TORQUE WRENCH AT 80 LBF.FT.
RECORD IF THERE IS ANY MOVEMENT OF THE NUT IN SHEET 1.

C) APPLY TORQUE ON SMALL NUT P/N 83642-918 IN THE TIGHTENING DIRECTION WITH A TORQUE WRENCH SET AT 35 LBF.FT.
RECORD IF THERE IS ANY MOVEMENT OF THE NUT IN SHEET 1.

D) REMOVE THE FOLLOWING PARTS IN ACCORDANCE WITH AMM 71-22-11-000-043 SECTION 4.A. FOR CFM56-5B AND AMM 71-22-11-000-042 SECTION 4.A. FOR CFM56-5A THE NUTS P/N 83642-918 AND P/N 83642-1420.
RETAIN FOR INSTALLATION.

E) REMOVE AND REPLACE THE INNER RETAINER P/N 238-0252-505.
REFER TO FIGURE 2 AND SECTION 4.G. OF AMM 71-22-11-000-043 AND AMM 71-22-11-400-043 FOR CFM56-5B AND SECTION 4.G. OF AMM 71-22-11-000-042 AND AMM 71-22-400-042 FOR CFM56-5A.

WORK STEP #8 - INSTALLATION OF OUTER RETAINERS (00:30)
MECH
INSP

A) INSTALL THE FOLLOWING PARTS IN ACCORDANCE WITH AMM 71-22-11-400-043 SECTION 4.G.11 FOR CFM56-5B AND AMM 71-22-11-400-042 SECTION 4.G.11 FOR CFM56-5A:

THE 83642-1420 NUT, 83642-918 NUT, 238-0253-511 (OR 238-0253-507) OUTER RETAINER, 238-0253-509 OUTER RETAINER, NAS6303U5 BOLTS, VN936NP3C WASHERS, VN936NP3 WASHERS, AND NAS1805-3 NUTS.

B) IF INSTALLED, REMOVE THE BOOTSTRAP SYSTEM.

REFER TO AMM TASK 71-22-11-400-043, SUBTASK 71-22-11-080-050 FOR CFM56-5B AND AMM TASK 71-22-11-400-042, SUBTASK 71-22-11-080-051 FOR CFM56-5A.

WORK STEP #9 - CLOSE-UP
MECH
INSP

1)CLOSE THE THRUST REVERSER DOORS.
REFER TO AMM TASK 78-36-00-410-040.

2)CLOSE THE FAN COWL DOORS.
REFER TO AMM TASK 71-13-00-410-040.

3)WRITE IN ENGINE LOG AND/OR OTHER RECORDS THAT GOODRICH SERVICE BULLETIN RA32071-160 HAS BEEN INCORPORATED

4)REINSPECT ALL RETAINERS P/N 238-0252-505 EVERY 12 MONTHS IN ACCORDANCE WITH GOODRICH SERVICE BULLETIN RA32071-160

5)IF CRACKED OR FAILED RETAINERS ARE FOUND, POPULATE THE DATA COLLECTION AND REPORTING SHEET (SHEET 1) AND RETURN WITH THE FAILED RETAINERS TO GOODRICH THROUGH YOUR AEROSTRUCTURES AIRLINE SUPPORT MANAGER

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FIGURE 1

EXAMPLE OF CRACKED RETAINER



Inspection of Retainer Bend for Cracks
Figure 1

MECH

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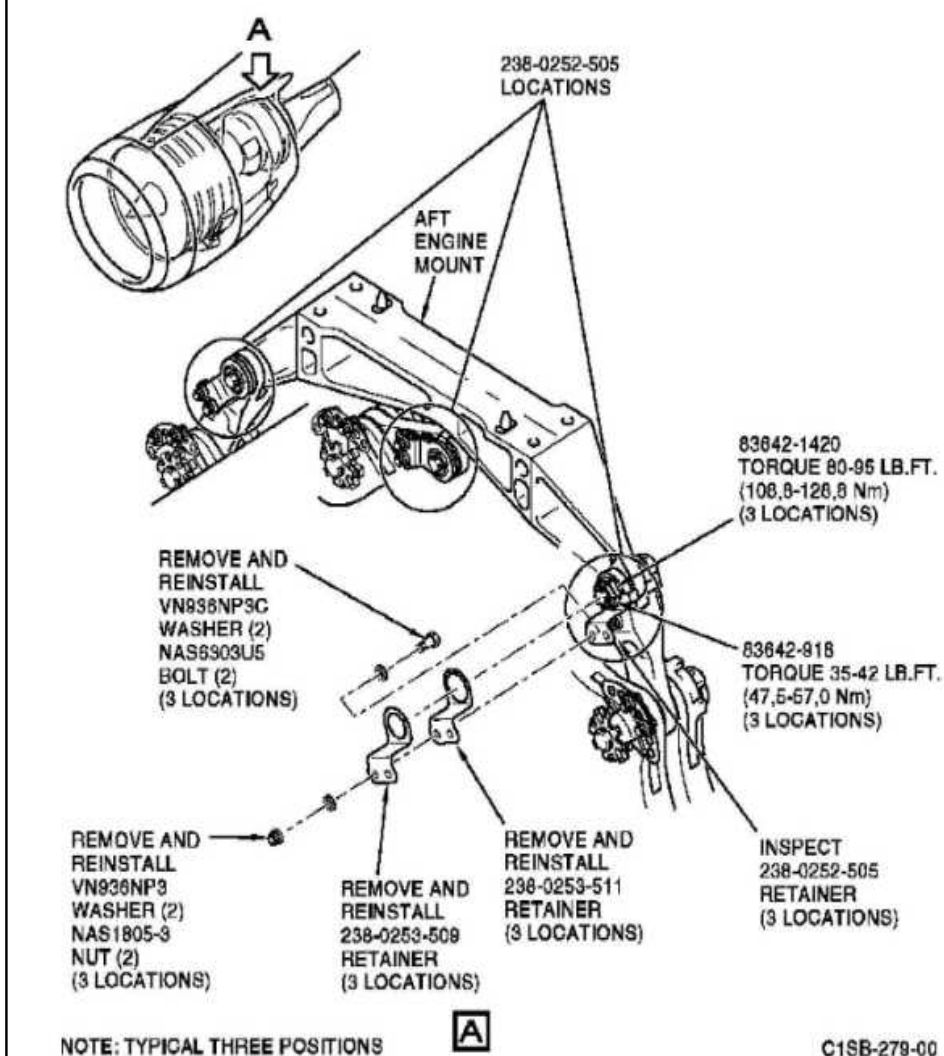
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FIGURE 2

LOCATIONS



Assembly and Disassembly of Retainer
Figure 2

MECH

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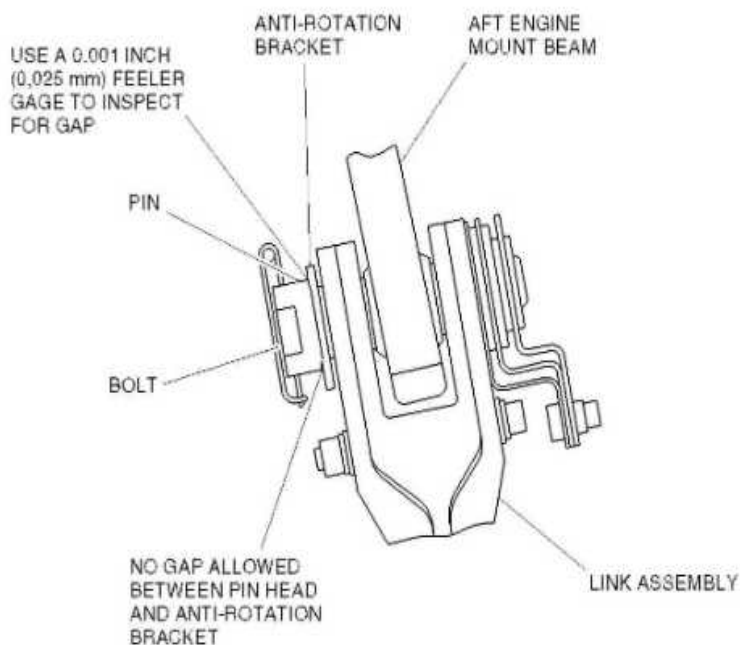
Job Instruction Card for - / -

FIGURE 3

LOCATIONS

CAUTION:

DO NOT TORQUE THE AFT ENGINE MOUNT LINK NUTS IF THERE IS A GAP BETWEEN THE PIN AND THE ANTI-ROTATION BRACKET. DAMAGE CAN OCCUR TO THE PIN AND BEARING. USE A 0.001 INCH (0.025 mm) FEELER GAGE TO INSPECT FOR A GAP BETWEEN THE PIN HEAD AND THE ANTI-ROTATION BRACKET. IF THERE IS A GAP OF MORE THAN 0.001 INCH (0.025 mm), THE ENGINE WEIGHT MUST BE SUPPORTED PER AMM 71-22-11 BEFORE THE NUT CAN BE TORQUED.



c1sb-287-00

Typical Engine Attach Hardware - Gap Test
Figure 3

MECH

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SHEET 1 - REPORT
MECH
INSP

PLEASE FILL IN THE REPORT

DATA COLLECTION SHEET FOR SERVICE BULLETIN RA32071-160																			
OPERATOR DATA																			
OPERATOR: _____	A/C MODEL: _____	CSN: _____																	
DATE INSPECTED: _____	ENGINE MODEL: _____	TSO: _____																	
A/C MSN: _____	TSN: _____	CSO: _____																	
ENGINE 1 S/N _____	PLEASE INDICATE THE CONDITION OF RETAINERS AT EACH LOCATION: <table border="1"> <thead> <tr> <th></th> <th>BRIGHT OR DULL</th> <th>INTACT, CRACKED OR FAILED</th> <th>IF CRACKED, CRACK LENGTH</th> </tr> </thead> <tbody> <tr> <td>LEFT:</td> <td></td> <td></td> <td></td> </tr> <tr> <td>CENTER:</td> <td></td> <td></td> <td></td> </tr> <tr> <td>RIGHT:</td> <td></td> <td></td> <td></td> </tr> </tbody> </table>				BRIGHT OR DULL	INTACT, CRACKED OR FAILED	IF CRACKED, CRACK LENGTH	LEFT:				CENTER:				RIGHT:			
	BRIGHT OR DULL	INTACT, CRACKED OR FAILED	IF CRACKED, CRACK LENGTH																
LEFT:																			
CENTER:																			
RIGHT:																			
	HISTORY OF RETAINER MAINTENANCE, IF ANY:																		
	CONDITION OF ALL NUTS (WORN, LOOSE, ETC): <table border="1"> <thead> <tr> <th></th> <th>LARGE NUT</th> <th>SMALL NUT</th> </tr> </thead> <tbody> <tr> <td>LEFT:</td> <td></td> <td></td> </tr> <tr> <td>CENTER:</td> <td></td> <td></td> </tr> <tr> <td>RIGHT:</td> <td></td> <td></td> </tr> </tbody> </table>				LARGE NUT	SMALL NUT	LEFT:			CENTER:			RIGHT:						
	LARGE NUT	SMALL NUT																	
LEFT:																			
CENTER:																			
RIGHT:																			
ENGINE 2 S/N _____	PLEASE INDICATE THE CONDITION OF RETAINERS AT EACH LOCATION: <table border="1"> <thead> <tr> <th></th> <th>BRIGHT OR DULL</th> <th>INTACT, CRACKED OR FAILED</th> <th>IF CRACKED, CRACK LENGTH</th> </tr> </thead> <tbody> <tr> <td>LEFT:</td> <td></td> <td></td> <td></td> </tr> <tr> <td>CENTER:</td> <td></td> <td></td> <td></td> </tr> <tr> <td>RIGHT:</td> <td></td> <td></td> <td></td> </tr> </tbody> </table>				BRIGHT OR DULL	INTACT, CRACKED OR FAILED	IF CRACKED, CRACK LENGTH	LEFT:				CENTER:				RIGHT:			
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LEFT:																			
CENTER:																			
RIGHT:																			

Data Collection and Reporting Sheet
Sheet 1

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