

JIC: 45827 / 0

Title: COLD WORKING OF ATTACHMENT HOLES ON PRESSURE PANEL FR35-FR36 - REPAIR SOLUTION. SB_CONF.007.

Area:

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Job Instruction Card for - / -

ITEM ONE - COLD WORKING OF ATTACHMENT HOLES ON PRESSURE PANEL FR35-FR36 - REPAIR SOLUTION. SB_C0

| | | | |
|--------------------|--|-------------------------------|----------|
| Panels: | 191BB (LOWER HALF FUSELAGE - PANEL 2 - BOTTOM (LOWER) SURFACE), 191EB (LOWER HALF FUSELAGE - PANEL 5 - BOTTOM (LOWER) SURFACE), 191KB (LOWER HALF FUSELAGE - PANEL 10 - BOTTOM (LOWER) SURFACE), 192EB (LOWER HALF FUSELAGE - PANEL 5 - BOTTOM (LOWER) SURFACE), 192FB (LOWER HALF FUSELAGE - PANEL 6 - BOTTOM (LOWER) SURFACE), 192KB (LOWER HALF FUSELAGE - PANEL 10 - BOTTOM (LOWER) SURFACE), 241DF (UPPER HALF FUSELAGE - PANEL 4 - FLOOR PANEL), 241HF (), 242DF (UPPER HALF FUSELAGE - PANEL 4 - FLOOR PANEL), 242HF () | | |
| Zones: | 140 (CENTER WING SIDE: LR), 240 (MID PASSENGER COMPARTMENT SIDE: LR), 734 (MAIN DOOR SIDE: LH), 826 (AFT CARGO COMPARTMENT DOOR SIDE: RH), 831 (FORWARD PASSENGER/CREW DOOR SIDE: LH), 841 (FORWARD PASSENGER/CREW DOOR SIDE: RH) | | |
| References: | EASA AD: 2016-0206 CORR SB: 53-1263 Rev.02 | | |
| Material: | 08BAA9 | NON AQUEOUS CLEANER | 1.0 req. |
| | 14SBA1 | TEXTILE-LINT FREE COTTON | 2.0 req. |
| | 531263D01R13 | KIT | 1.0 req. |
| | 04CMA2 | WASH PRIMER | 1.0 req. |
| | 04EAC2 | PRIMER | 0.5 req. |
| | 04JME4 | TOP COAT POLYURETHANE- | 0.5 req. |
| | 531263D03R05 | KIT | 1.0 req. |
| | 04TMC9 | VARNISH-PROTECTIVE COMPONENT | 1.0 req. |
| | 04DAB2 | PRIMER EPOXY PAINT | 0.5 req. |
| | 06AAA1 | POLYSULFIDE SEALANT (DAN1159) | 0.5 req. |
| | 12ADB1 | CORROSION PREVENTIVE COMPOUND | 1.0 req. |
| Tools: | DKA320531263-1 | DURABLE TOOLING | 1.0 req. |
| | EKA320531263-1 | EXPENDABLE TOOLING | 1.0 req. |
| | FTIA320531263-1 | CAPITAL TOOLING | 1.0 req. |

STEP 01.

HEADER. APPROVAL DATA.

Prepared by: 10657 29 JAN 2018
Approved by: 11700 29 JAN 2018

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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.

 **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**

Partial embodiment of SB 53-1263 Rev.02 to only one side is possible if a crack is found on one side only.

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STEP 03.

STANDARD PRACTICES.

1. Tag all the parts you must remove and retain to make the subsequent installation easier.
2. For the identification of zones, refer to AMM 06-20-00, Page Block 001.
3. For the Frame (FR) identification, refer to AMM 06-31-53, Page Block 001.
4. For the identification of access panels, refer to AMM 06-41-52, Page Block 001 and AMM 06-41-53, Page Block 001.
5. To torque tighten the standard threaded fasteners, refer to AMM Task 20-21-11-911-001.
6. Do the corrosion prevention in accordance with SRM 51-22-00.
7. Remove and install fasteners in accordance with SRM 51-42-00.
8. Obtain fastener hole diameters and drill data in accordance with SRM 51-44-00.
9. Renew protective finish in accordance with SRM 51-75-12.
10. Apply sealant in accordance with SRM 51-24-00.
11. Obtain the fastener edge and margin data in accordance with SRM 51-47-00.
12. Obtain the cold expansion of fastener holes in accordance with SRM 51-48-00.
13. When you remove fasteners you must be careful that you do not damage the holes in the structure.
14. Reidentify with indelible marker in accordance with Process and Material Specification (PMS) 01-06-12.
15. Cut the rivets to the necessary length.
16. For the drilling of rivet holes:
 - Use a soft lead pencil and make marks to show the position of the rivet holes.
 - Make sure that you have the correct edge distance before you drill the fastener holes.
 - If not shown otherwise the tolerance for rivet holes is +0.1 mm (+ 0.004 in.).
 - Transfer-drill the existing holes with a pilot drill and a drill bush.
 - Drill the new fastener holes with a pilot drill of 2.5 mm (0.098 in.) diameter. Increase the hole diameter to the correct size for the fastener which you must install.
 - Deburr the holes after you have drilled them.
17. 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.
18. If the length of any fastener specified in this Job Instruction Card does not meet installation standards given in SRM Chapter 51, then a fastener of the same specification, or an approved substitute, with a length which meets the installation standards given in SRM Chapter 51 may be used. In addition, washers may be installed for fastener grip length in accordance with SRM Chapter 51.

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STEP 04.

Mech. Skill: B1

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JOB SET-UP.

 **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 the 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. For LH fuselage, remove and retain these access panels 191KB, 191BB and 191EB, refer to AMM Task 53-35-13-000-002.
3. For RH fuselage, remove and retain these access panels 192EB, 192KB and 192FB, refer to AMM Task 53-35-13-000-002.
4. Put access platform(s) in position below the FWD Cargo Compartment Door.
5. Open the FWD cargo compartment door 825, refer to AMM Task 52-30-00-860-001.
6. Remove the forward cargo-compartment partition, refer to AMM Task 25-54-12-000-001.
7. Remove the LH drive shaft 6008CM, refer to AMM Task 27-84-45-000-003.
8. Remove the RH drive shaft 6058CM, refer to AMM Task 27-84-43-000-003.
9. Remove the APU bleed-air ducts between Frame 35 and Frame 36, refer to AMM Task 36-12-41-000-001.
10. Remove the LH RAM air inlet, refer to AMM Task 21-61-51-000-002.
11. Remove the air ducts upstream of flow control valves, refer to AMM Task 21-51-51-000-002.
12. Remove the trim air ducts, refer to AMM Task 21-63-42-000-001.
13. Remove the pipes upstream to 16HM, refer to AMM Task 21-52-43-000-001.
14. As necessary, remove the fuselage overheat sensing elements, refer to AMM Task 36-22-18-000-001.
15. From the RH fuselage if necessary, remove and retain the potable water tank, refer to AMM Task 38-11-41-000-001.

----- CONTINUE IN STEP 05 -----

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STEP 05.

| Mech. Skill: B1 | MECH | INSP |
|--|------|------|
| <p>JOB SET-UP.</p> <p style="text-align: center;">----- CONTINUED FROM STEP 04 -----</p> <p>16. As necessary, remove and retain the insulation packs, refer to AMM Task 25-80-00-000-001. 17. As necessary, remove and retain the air conditioning ducts, refer to AMM Task 21-20-00-010-001. 18. If necessary, remove and retain the mixer unit, refer to AMM Task 21-21-43-000-002. 19. If necessary, loosen the vapor seal membrane from the vapor seal brackets, refer to AMM Task 28-13-42-000-001.</p> <div style="border: 1px solid #add8e6; padding: 10px; margin: 10px 0;"> <p style="text-align: center;"> NOTE</p> <div style="border: 1px solid #add8e6; padding: 5px;"> <ol style="list-style-type: none"> 1. The vapor seal is fragile. Be careful when you move the vapor seal. 2. It is not necessary to fully remove the vapor seal. Be careful if you partially remove the vapor seal </div> </div> <p>20. Remove the heat and sound insulation in the area between FR35 and FR36 LH and RH for access, refer to AMM Task 25-80-00-000-001.</p> | | |

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STEP 06.

Mech. Skill: B1

MECH

INSP

REMOVE ITEMS INSTALLED ON THE PRESSURE PANEL BETWEEN FR35 AND FR36 LH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

1. To access the area to be modified on the pressure panel, remove and retain the compressor support bracket, refer to Fig. A-GBAAA Sheet 01 and Fig. A-GBAAA Sheet 02 (attached to the Work Order), remove:

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|--------------|----------------|-------------|---------|
| 8 | Fastener | - | - | Discard |
| 8 | Collar | - | - | Discard |
| 1 | Bracket Assy | D3847006201000 | Item (48) | Retain |

2. Clean the item removed for access, use Textile-Lint Free Cotton 14SBA1 made moist with Non Aqueous Cleaner-General 08BAA9.

3. Remove and discard the fasteners in the area to be modified, refer to Fig. AGBAAA Sheet 01 and Fig. A-GBAAA Sheet 02 (attached to the Work Order).

4. Remove from the pressure panel, refer to Fig. A-GBAAA Sheet 01, Fig. A-GBAAA Sheet 02, Fig. A-GBAAA Sheet 04 and Fig. A-GBAAA Sheet 06, Section E-E (attached to the Work Order).

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|--------------|----------------|-------------|--------|
| 2 | Nut-Plate | NAS1792A3-1 | Item (57) | Retain |
| 1 | Fitting | D2827004320300 | Item (55) | Retain |
| 1 | Profile assy | D2827004600500 | Item (54) | Retain |
| 1 | Profile assy | D2827004600900 | Item (56) | Retain |

NOTE

Items (54), (55) and (56) can be removed together in one piece.

| | | | | |
|---|---------------|----------------|-----------|--------|
| 2 | Bracket | D3627001600000 | Item (53) | Retain |
| 2 | Bracket | D9249179320000 | Item (61) | Retain |
| 1 | Angle-Bonding | A9249175120000 | Item (62) | Retain |

5. Clean the contact surfaces of the removed items, use Textile-Lint Free Cotton 14SBA1 made moist with Non Aqueous Cleaner-General 08BAA9.

----- CONTINUE IN STEP 07 -----

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STEP 07.

Mech. Skill: B1

MECH

INSP

REMOVE ITEMS INSTALLED ON THE PRESSURE PANEL BETWEEN FR35 AND FR36 LH.

----- CONTINUED FROM STEP 06 -----

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

6. Remove, refer to Fig. A-GBAAA Sheet 06, Sections F-F and H-H (attached to the Work Order):

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------------|--------------------------|----------------|-------------|---------|
| 1 | Beam Assy - Longitudinal | D5337090500000 | Item (58) | Retain |
| attached with: | | | | |
| 2 | Bolt | NSA5042C07-285 | Item (50) | Retain |
| 2 | Washer | D5337054320000 | Item (51) | Retain |
| 2 | Nut | NSA5060C5 | Item (52) | Retain |
| 2 | Pin-Cotter | MS24665-153 | Item (1) | Discard |

7. Clean the contact surfaces of the removed items, use Textile-Lint Free Cotton 14SBA1 made moist with Non Aqueous Cleaner-General 08BAA9.

8. Inspect the area of removed items for damage.

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STEP 08.

Mech. Skill: B1

MECH

INSP

REMOVE ITEMS INSTALLED ON THE PRESSURE PANEL BETWEEN FR35 AND FR36 RH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

1. To access the area to be modified on the pressure panel, remove fasteners from the water tank bracket, refer to Fig. A-GBAAA Sheet 01 and Fig. A-GBAAA Sheet 03 (attached to the Work Order), remove:

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|------------------|----------------|-------------|---------|
| 47 | Fastener | - | - | Discard |
| 47 | Collar | - | - | Discard |
| 1 | Crossbeam | D3817011320000 | Item (46) | Retain |
| 1 | Shear Plate Assy | D3817011400100 | Item (47) | Retain |

2. Clean the area, use Textile-Lint Free Cotton 14SBA1 made moist with Non Aqueous Cleaner-General 08BAA9.

3. Remove and discard the fasteners in the area to be modified, refer to Fig. A-GBAAA Sheet 01, Fig. A-GBAAA Sheet 03 and Fig. A-GBAAA Sheet 06 (attached to the Work Order).

4. Remove from the pressure panel, refer to Fig. A-GBAAA Sheet 01, Fig. A-GBAAA Sheet 03, Fig. A-GBAAA Sheet 05 and Fig. A-GBAAA Sheet 06, Section E-E (attached to the Work Order):

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|--------------|----------------|-------------|--------|
| 2 | Nut-Plate | NAS1792A3-1 | Item (57) | Retain |
| 1 | Profile assy | D2827004600400 | Item (63) | Retain |
| 1 | Fitting | D2827004320200 | Item (64) | Retain |
| 1 | Profile assy | D2827004600800 | Item (65) | Retain |

NOTE

Items (63), (64) and (65) can be removed together in one piece.

| | | | | |
|---|---------|----------------|-----------|--------|
| 2 | Bracket | D3627001600000 | Item (53) | Retain |
|---|---------|----------------|-----------|--------|

5. Clean the contact surfaces of the removed items, use Textile-Lint Free Cotton 14SBA1 made moist with Non Aqueous Cleaner-General 08BAA9.

----- CONTINUE IN STEP 09 -----

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STEP 09.

Mech. Skill: B1

MECH

INSP

REMOVE ITEMS INSTALLED ON THE PRESSURE PANEL BETWEEN FR35 AND FR36 RH.

----- CONTINUED FROM STEP 08 -----

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

6. Remove, refer to Fig. A-GBAAA Sheet 06, Sections F-F and H-H (attached to the Work Order):

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------------|--------------------------|----------------|-------------|---------|
| 1 | Beam Assy - Longitudinal | D5337090500000 | Item (58) | Retain |
| attached with: | | | | |
| 2 | Nut | NSA5060C5 | Item (52) | Retain |
| 2 | Washer | D5337054320000 | Item (51) | Retain |
| 2 | Bolt | NSA5042C07-285 | Item (50) | Retain |
| 2 | Pin-Cotter | MS24665-153 | Item (1) | Discard |

7. Clean the contact surfaces of the removed items, use Textile-Lint Free Cotton 14SBA1 made moist with Non Aqueous Cleaner-General 08BAA9.

8. Inspect the area of removed items for damage.

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STEP 10.

| Mech. Skill: NDT Dble. Rel. Skill: NDT | MECH | INSP |
|--|------|------|
| <p>INSPECT THE PRESSURE PANEL FASTENER HOLES LH.</p> <p>----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----</p> <div style="border: 1px solid orange; padding: 10px; text-align: center;"> <p> CAUTION</p> <div style="border: 1px solid black; padding: 5px; margin: 5px auto; width: 80%;"> <p>MAKE SURE THAT THE FASTENER HOLE EDGE DISTANCE IS CORRECT BEFORE THE INSTALLATION OF THE FINAL FASTENERS TO AVOID EXTENSIVE REPAIRS IN THE MODIFICATION AREA.</p> </div> </div> <p>Do the Eddy Current Rotating probe inspection of the fastener holes, refer to NTM 51-10-01 and Appendix 02 (attached to the Work Order) - Complementary information for Rototest Inspection.</p> <div style="border: 1px solid blue; padding: 10px; text-align: center;"> <p> NOTE</p> <div style="border: 1px solid black; padding: 5px; margin: 5px auto; width: 80%;"> <p>Only check the fastener holes where the fasteners have been removed.</p> </div> </div> <p>1. If a crack is found in a hole outside of the area where a repair can be made, refer to Fig. A-GCAAA Sheet 01, Fig. A-GCAAA Sheet 02, Fig. A-GCAAA Sheet 03, Fig. A-GCAAA Sheet 04 and Fig. A-GCAAA Sheet 05 (attached to the Work Order).</p> <p>1.1. Do an inspection to measure the length of the crack(s) to calculate the necessary cut out area, refer to NTM 51-10-08.</p> <p>1.2. Immediately inform Engineering Department or Customer Representative to contact AIRBUS and report the findings for further instructions before the next flight.</p> <p>2. If a crack is found in a hole that is within the area where a repair can be made, refer to Fig. A-GCAAA Sheet 01, Fig. A-GCAAA Sheet 02, Fig. A-GCAAA Sheet 03, Fig. A-GCAAA Sheet 04 and Fig. A-GCAAA Sheet 05 (attached to the Work Order).</p> <p>2.1. Do an inspection to measure the length of the crack(s) to calculate the necessary cut out area, refer to NTM 51-10-08.</p> <p><1> If the crack length exceeds the repair area, immediately inform Engineering Department or Customer Representative to contact AIRBUS and report the findings for further instructions before the next flight.</p> <p><2> If the crack length does not exceed the repair area, continue with the modification, go to Step12 "Modify the Pressure Panel LH".</p> <p>Crack (s) found (YES/NO): _____</p> <p>Does crack length exceed the repair area (YES/NO): _____</p> <p>Please provide NDT report reference with detailed information: _____</p> | | |

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STEP 11.

Mech. Skill: NDT Dble. Rel. Skill: NDT

MECH

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INSPECT THE PRESSURE PANEL FASTENER HOLES RH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

CAUTION

MAKE SURE THAT THE FASTENER HOLE EDGE DISTANCE IS CORRECT BEFORE THE INSTALLATION OF THE FINAL FASTENERS TO AVOID EXTENSIVE REPAIRS IN THE MODIFICATION AREA.

Do the Eddy Current Rotating probe inspection of the fastener holes, refer to NTM 51-10-01 and Appendix 02 - Complementary information for Rototest Inspection (attached to the Work Order).

NOTE

Only check the fastener holes where the fasteners have been removed.

1. If a crack is found in a hole outside of the area where a repair can be made, refer to Fig. A-GCAAA Sheet 01, Fig. A-GCAAA Sheet 02, Fig. A-GCAAA Sheet 03, Fig. A-GCAAA Sheet 04 and Fig. A-GCAAA Sheet 05 (attached to the Work Order).
 - 1.1. Do an inspection to measure the length of the crack(s) to calculate the necessary cut out area, refer to NTM 51-10-08.
 - 1.2. Immediately inform Engineering Department or Customer Representative to contact AIRBUS and report the findings for further instructions before the next flight.
2. If a crack is found in a hole that is within the area where a repair can be made, refer to Fig. A-GCAAA Sheet 01, Fig. A-GCAAA Sheet 02, Fig. A-GCAAA Sheet 03, Fig. A-GCAAA Sheet 04 and Fig. A-GCAAA Sheet 05 (attached to the Work Order).
 - 2.1. Do an inspection to measure the length of the crack(s) to calculate the necessary cut out area, refer to NTM 51-10-08.

<1> If the crack length exceeds the repair area, immediately inform Engineering Department or Customer Representative to contact AIRBUS and report the findings for further instructions before the next flight.

<2> If the crack length does not exceed the repair area, continue with the modification, go to SUBTASK 531263-831-205 004 Modify the Pressure Panel RH .

Crack (s) found (YES/NO): _____

Does crack length exceed the repair area (YES/NO): _____

Please provide NDT report reference with detailed information: _____

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STEP 12.

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

MECH

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MODIFY THE PRESSURE PANEL LH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

Refer to Fig. A-GCAAA Sheet 03, View C, Fig. A-GCAAA Sheet 04, View D and Fig. A-GBAAA Sheet 06, Section G-G (attached to the Work Order).

1. Cut the pressure panel, Item (59), to the maximum crack length, 30.00 mm (1.181 in), from the aft edge, refer to Fig. A-GCAAA Sheet 02 (attached to the Work Order), View B:

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM |
|----------|----------------|----------------|-------------|
| 1 | Plate-Pressure | D5337090121000 | Item (59) |

2. Deburr and clean the pressure panel, Item (59), use Non Aqueous Cleaner-General 08BAA9 and Textile-Lint Free Cotton 14SBA1.

3. Do an High Frequency Eddy Current (HFEC) inspection of the cut out area for cracks, refer to NTM 51-10-08.

3.1. If further crack(s) are found outside the cut out area immediately inform Engineering Department or Customer Representative to contact AIRBUS before next flight.

Crack(s) found (YES/NO): _____

4. If necessary, do the final cut out, refer to Fig. A-GCAAA Sheet 03, View C (attached to the Work Order).

5. Deburr if necessary and clean the area use Textile-Lint Free Cotton 14SBA1 made moist with Non Aqueous Cleaner-General 08BAA9.

6. Protect the cut out area, use:

| NAME | SPECIFICATION | QUANTITY |
|--|---------------|-------------|
| Wash Primer - Structure | 04CMA2 | As required |
| Primer Polyurethane Paint - Corrosion Inhibiting | 04EAC2 | As required |
| Top Coat Polyurethane - Grey Internal Structure | 04JME4 | As required |

7. Trim the Filler, Item 3, to fit the cut-out area with a 1.00 mm (0.039 in) gap all around and retain.

8. Mark on the pressure panel the position of the Doubler, Item 2.

9. Identify the fastener holes and all existing bracket holes, then mark the position of the new fastener holes, refer to Fig. A-GCAAA Sheet 01 and Fig. A-GCAAA Sheet 04 (attached to the Work Order) for pitch and edge distances.

10. Pre-drill the new fastener holes in the pressure panel.

----- CONTINUE IN STEP 13 -----

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STEP 13.

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

MECH

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MODIFY THE PRESSURE PANEL LH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

----- CONTINUED FROM STEP 12 -----

11. Put in position:

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM |
|----------|---------|----------------|-------------|
| 1 | Filler | R5337031120200 | Item 3 |
| 1 | Doubler | R5337031120000 | Item 2 |

 **NOTE**

Trim the Doubler, Item 2, and the Filler, Item 3, as necessary to the required contour.

12. Drill all the fastener holes for the Doubler, Item 2, and the Filler, Item 3, into the pressure panel to final diameter, refer to Fig. A-GBAAA Sheet 04, Fig. A-GBAAA Sheet 06, Fig. A-GCAAA Sheet 03, View C and Fig. A-GCAAA Sheet 04, View D (attached to the Work Order).

13. Remove the Filler, Item 3 and Doubler, Item 2.

14. Deburr and clean the area use Textile-Lint Free Cotton 14SBA1 made moist with Non Aqueous Cleaner-General 08BAA9.

15. On the pressure panel, refer to Fig. A-GBAAA Sheet 04, Fig. A-GCAAA Sheet 03, View C and Fig. A-GCAAA Sheet 04 (attached to the Work Order), put in position:

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM |
|----------|---------|----------------|-------------|
| 1 | Filler | R5337031120200 | Item 3 |
| 1 | Doubler | R5337031120000 | Item 2 |

PROPERTY OF "ROSSIYA AIRLINES" JSC

JIC: 45827 / 0

Title: COLD WORKING OF ATTACHMENT HOLES ON PRESSURE PANEL FR35-FR36 - REPAIR SOLUTION. SB_CONF.007.

Area:

ATA:

Special Codes:

A/C: BIV

Job Instruction Card for - / -

STEP 14.

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

MECH

INSP

MODIFY THE PRESSURE PANEL RH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

Refer to Fig. A-GCAAA Sheet 03, View C, Fig. A-GCAAA Sheet 05, View E and Fig. A-GBAAA Sheet 06, Section G-G (attached to the Work Order).

1. Cut the pressure panel, Item (59), to the maximum crack length, 30.00 mm (1.181 in), from the aft edge, refer to Fig. A-GCAAA Sheet 02 (attached to the Work Order), View B:

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM |
|----------|----------------|----------------|-------------|
| 1 | Plate-Pressure | D5337090121000 | Item (59) |

2. Deburr and clean the pressure panel, Item (59), use Non Aqueous Cleaner-General 08BAA9 and Textile-Lint Free Cotton 14SBA1.

3. Do an High Frequency Eddy Current (HFEC) inspection of the cut out area for cracks, refer to NTM 51-10-08.

3.1. If further crack(s) are found outside the cut out area immediately inform Engineering Department or Customer Representative to contact AIRBUS before next flight.

Crack(s) found (YES/NO): _____

4. If necessary, do the final cut out, refer to Fig. A-GCAAA Sheet 03, View C (attached to the Work Order).

5. Deburr if necessary and clean the area use Textile-Lint Free Cotton 14SBA1 made moist with Non Aqueous Cleaner-General 08BAA9.

6. Protect the cut out area, use:

| NAME | SPECIFICATION | QUANTITY |
|--|---------------|-------------|
| Wash Primer - Structure | 04CMA2 | As required |
| Primer Polyurethane Paint - Corrosion Inhibiting | 04EAC2 | As required |
| Top Coat Polyurethane - Grey Internal Structure | 04JME4 | As required |

7. Trim the Filler, Item 3, to fit the cut-out area with a 1.00 mm (0.039 in) gap all around and retain.

8. Mark on the pressure panel the position of the Doubler, Item 2.

9. Identify the fastener holes and all existing bracket holes, then mark the position of the new fastener holes, refer to Fig. A-GCAAA Sheet 01 and Fig. A-GCAAA Sheet 04 (attached to the Work Order) for pitch and edge distances.

10. Pre-drill the new fastener holes in the pressure panel.

----- CONTINUE IN STEP 15 -----

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STEP 15.

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

MECH

INSP

MODIFY THE PRESSURE PANEL RH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

----- CONTINUED FROM STEP 14 -----

11. Put in position:

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM |
|----------|---------|----------------|-------------|
| 1 | Filler | R5337031120200 | Item 3 |
| 1 | Doubler | R5337031120000 | Item 2 |

 **NOTE**

Trim the Doubler, Item 2, and the Filler, Item 3, as necessary to the required contour.

12. Drill all the fastener holes for the Doubler, Item 2, and the Filler, Item 3, into the pressure panel to final diameter, refer to Fig. A-GBAAA Sheet 04, Fig. A-GBAAA Sheet 06, Fig. A-GCAAAA Sheet 03, View C and Fig. A-GCAAAA Sheet 04, View D (attached to the Work Order).

13. Remove the Filler, Item 3 and Doubler, Item 2.

14. Deburr and clean the area use Textile-Lint Free Cotton 14SBA1 made moist with Non Aqueous Cleaner-General 08BAA9.

15. On the pressure panel, refer to Fig. A-GBAAA Sheet 04, Fig. A-GCAAAA Sheet 03, View C and Fig. A-GCAAAA Sheet 04 (attached to the Work Order), put in position:

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM |
|----------|---------|----------------|-------------|
| 1 | Filler | R5337031120200 | Item 3 |
| 1 | Doubler | R5337031120000 | Item 2 |

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ATA:

Special Codes:

A/C: BIV

Job Instruction Card for - / -

STEP 16.

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

MECH

INSP

MODIFY THE LONGITUDINAL BEAM LH (ON BENCH).

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

1. Use the applicable tools to remove material from the Beam Assy-Longitudinal, Item (58), refer to Fig. A-GBAAA Sheet 06, Section G-G, and View K (attached to the Work Order).
2. Deburr and clean the area, use Textile-Lint Free Cotton 14SBA1 made moist with Non Aqueous Cleaner-General 08BAA9.
3. Protect the cut out area, use:

| NAME | SPECIFICATION | QUANTITY |
|--|---------------|-------------|
| Wash Primer - Structure | 04CMA2 | As required |
| Primer Polyurethane Paint - Corrosion Inhibiting | 04EAC2 | As required |
| Top Coat Polyurethane - Grey Internal Structure | 04JME4 | As required |

4. Reidentify the Beam Assy-Longitudinal, Item (58), use an applicable marker, refer to Process and Material Specification (PMS) 01-06-12.

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|--------------------------|----------------|-------------|---------------------|
| 1 | Beam Assy - Longitudinal | D5337090500000 | Item (58) | Retained at removal |
| becomes: | | | | |
| 1 | Beam Assy - Longitudinal | D5337239220000 | Item 58 | - |

5. Protect the markings, apply Varnish - Protective Component 04TMC9.

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ATA:

Special Codes:

A/C: BIV

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STEP 17.

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

MECH

INSP

MODIFY THE LONGITUDINAL BEAM RH (ON BENCH).

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

1. Use the applicable tools to remove material from the Beam Assy-Longitudinal, Item (58), refer to Fig. A-GBAAA Sheet 06 (attached to the Work Order), Section G-G and View K.
2. Deburr and clean the area, use: Textile-Lint Free Cotton 14SBA1 made moist with Non Aqueous Cleaner-General 08BAA9.
3. Protect the cut out area, use:

| NAME | SPECIFICATION | QUANTITY |
|--|---------------|-------------|
| Wash Primer - Structure | 04CMA2 | As required |
| Primer Polyurethane Paint - Corrosion Inhibiting | 04EAC2 | As required |
| Top Coat Polyurethane - Grey Internal Structure | 04JME4 | As required |

4. Reidentify the Beam Assy-Longitudinal, Item (58), use an applicable marker, refer to Process and Material Specification (PMS) 01-06-12.

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|--------------------------|----------------|-------------|---------------------|
| 1 | Beam Assy - Longitudinal | D5337090500000 | Item (58) | Retained at removal |
| becomes: | | | | |
| 1 | Beam Assy - Longitudinal | D5337239220000 | Item 58 | - |

5. Protect the markings, apply Varnish - Protective Component 04TMC9.

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ATA:

Special Codes:

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STEP 18.

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

MECH

INSP

INSTALL THE MODIFIED LONGITUDINAL BEAM LH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

Install the modified longitudinal beam LH, refer to Fig. A-GBAAA Sheet 04 and Fig. A-GBAAA Sheet 06 (attached to the Work Order).

1. Temporarily install:

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|--------------|--------------------------|----------------|-------------|---------------------|
| 1 | Beam Assy - Longitudinal | D5337239220000 | Item 58 | - |
| attach with: | | | | |
| 2 | Bolt | NSA5042C07-285 | Item (50) | Retained at removal |

2. If the Bolts, Item (50), do not fit, use the applicable tools to remove material from the Beam Assy-Longitudinal, Item 58, refer to Fig. A-GBAAA Sheet 06 (attached to the Work Order), Section GG and View K.

STEP 19.

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

MECH

INSP

INSTALL THE MODIFIED LONGITUDINAL BEAM RH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

Refer to Fig. A-GBAAA Sheet 05 and Fig. A-GBAAA Sheet 06 (attached to the Work Order).

1. Temporarily install:

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|--------------|--------------------------|----------------|-------------|---------------------|
| 1 | Beam Assy - Longitudinal | D5337239220000 | Item 58 | - |
| attach with: | | | | |
| 2 | Bolt | NSA5042C07-285 | Item (50) | Retained at removal |

2. If the Bolts, Item (50), do not fit, use the applicable tools to remove material from the Beam Assy-Longitudinal, Item 58, refer to Fig. A-GBAAA Sheet 06 (attached to the Work Order), Section GG and View K.

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ATA:

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STEP 20.

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

MECH

INSP

PREPARE THE STRUCTURE AT BRACKET LOCATION LH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

CAUTION

MAKE SURE THAT THE FASTENER HOLE EDGE DISTANCE IS CORRECT BEFORE THE INSTALLATION OF THE FINAL FASTENERS TO AVOID EXTENSIVE REPAIRS IN THE MODIFICATION AREA.

Refer to Fig. A-GBAAA Sheet 04, View D, Fig. A-GBAAA Sheet 07, View N and Fig. A-GBAAA Sheet 08 (attached to the Work Order).

1. Countersink the fastener holes at the two positions for the rivets, Item 24, in the pressure panel before installation of doubler, Item 2.
2. Aircraft with additional bracket, Item (62), install:

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|---------------|----------------|-------------|---------------------|
| 1 | Angle-Bonding | A9249175120000 | Item (62) | Retained at removal |
| with: | | | | |
| 2 | Rivet | EN6069KE4-10 | Item 24 | - |

NOTE

Make sure the fasteners are installed dry.

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ATA:

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STEP 21.

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

MECH

INSP

TEMPORARILY INSTALL PROFILE ASSEMBLIES LH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

Temporarily Install the profile assemblies, refer to Fig. A-GBAAA Sheet 04, View D, Fig. A-GBAAA Sheet 06, Section E-E and Fig. A-GBAAA Sheet 08 (attached to the Work Order).

1. Put in position 1 (one) Wedge P/N R5337031120400, Item 4.
2. Transfer drill the existing holes to the Wedge, Item 4.
3. Put in position on the pressure panel:

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|--------------|----------------|-------------|---------------------|
| 1 | Profile assy | D2827004600500 | Item (54) | Retained at removal |
| 1 | Fitting | D2827004320300 | Item (55) | Retained at removal |
| 1 | Profile assy | D2827004600900 | Item (56) | Retained at removal |
| 2 | Nut-Plate | NAS1792A3-1 | Item (57) | Retained at removal |

STEP 22.

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

MECH

INSP

TEMPORARILY INSTALL PROFILE ASSEMBLIES RH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

Temporarily install the profile assemblies, refer to Fig. A-GBAAA Sheet 05, View E, Fig. A-GBAAA Sheet 06, Section E-E and Fig. A-GBAAA Sheet 08 (attached to the Work Order).

1. Put in position 1 (one) Wedge P/N R5337031120400, Item 4.
2. Transfer drill the existing holes to the Wedge, Item 4.
3. Put in position on the pressure panel:

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|--------------|----------------|-------------|---------------------|
| 1 | Profile assy | D2827004600400 | Item (63) | Retained at removal |
| 1 | Fitting | D2827004320200 | Item (64) | Retained at removal |
| 1 | Profile assy | D2827004600800 | Item (65) | Retained at removal |
| 2 | Nut-Plate | NAS1792A3-1 | Item (57) | Retained at removal |

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JIC: 45827 / 0

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Area:

ATA:

Special Codes:

A/C: BIV

Job Instruction Card for - / -

STEP 23.

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

MECH

INSP

COLD WORK THE FASTENER HOLES LH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

CAUTION

MAKE SURE THAT THE FASTENER HOLE EDGE DISTANCE IS CORRECT BEFORE THE INSTALLATION OF THE FINAL FASTENERS TO AVOID EXTENSIVE REPAIRS IN THE MODIFICATION AREA.

Refer to Fig. A-GBAAA Sheet 04, View D, Fig. A-GBAAA Sheet 07, View L, M, N and P and Fig. A-GBAAA Sheet 08 (attached to the Work Order).

Do the cold expansion of the fastener holes in accordance with SRM 51-48-00.

NOTE

Equipment must not show signs of wear.

1. Oversize the holes to the start diameter in accordance with SRM 51-48-00.

Refer to FTI tool list No.

DKA320531263-1

Durable tooling

1

OR

Refer to WCI tool list No.

DKA320531263-1

Durable tooling

1

2. Clean the drilled areas with Non Aqueous Cleaner - General 08BAA9 and Textile-Lint Free Cotton 14SBA1.

3. Install the sleeves in accordance with SRM 51-48-00.

Refer to FTI tool list No.

EKA320531263-1

Expendable tooling

1

OR

Refer to WCI tool list No.

EKA320531263-1

Expendable tooling

1

----- CONTINUE IN STEP 24 -----

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JIC: 45827 / 0

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Area:

ATA:

Special Codes:

A/C: BIV

Job Instruction Card for - / -

STEP 24.

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

MECH

INSP

COLD WORK THE FASTENER HOLES LH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

----- CONTINUED FROM STEP 23 -----

4. Do the cold expansion of the fastener holes in accordance with SRM 51-48-00.

Refer to FTI tool list No.

FTIA320531263-1

Capital tooling

1

OR

Refer to WCI tool list No.

WCIA320531263-1

Capital tooling

1

5. Remove the sleeves.

6. Ream the holes to the final hole diameter in accordance with SRM 51-48-00.

Refer to FTI tool list No.

DKA320531263-1

Durable tooling

1

OR

DKA320531263-1

Durable tooling

1

7. Deburr and clean the fastener holes with Non Aqueous Cleaner-General 08BAA9 and Textile-Lint Free Cotton 14SBA1.

8. Renew the protective finish of the holes with Surface Pretreatment - Light Alloys Chemical 10ABC1.

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JIC: 45827 / 0

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Area:

ATA:

Special Codes:

A/C: BIV

Job Instruction Card for - / -

STEP 25.

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

MECH

INSP

COLD WORK THE FASTENER HOLES RH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

CAUTION

MAKE SURE THAT THE FASTENER HOLE EDGE DISTANCE IS CORRECT BEFORE THE INSTALLATION OF THE FINAL FASTENERS TO AVOID EXTENSIVE REPAIRS IN THE MODIFICATION AREA.

Refer to Fig. A-GBAAA Sheet 05, View E, Fig. A-GBAAA Sheet 07, View Q and Fig. A-GBAAA Sheet 08 (attached to the Work Order).

Do the cold expansion of the fastener holes in accordance with SRM 51-48-00.

NOTE

Equipment must not show signs of wear.

1. Oversize the holes to the start diameter in accordance with SRM 51-48-00.

Refer to FTI tool list No.

DKA320531263-1

Durable tooling

1

OR

Refer to WCI tool list No.

DKA320531263-1

Durable tooling

1

2. Clean the drilled areas with Non Aqueous Cleaner - General 08BAA9 and Textile-Lint Free Cotton 14SBA1.

3. Install the sleeves in accordance with SRM 51-48-00.

Refer to FTI tool list No.

EKA320531263-1

Expendable tooling

1

OR

Refer to WCI tool list No.

EKA320531263-1

Expendable tooling

1

----- CONTINUE IN STEP 26 -----

PROPERTY OF "ROSSIYA AIRLINES" JSC

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ATA:

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A/C: BIV

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STEP 26.

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

MECH

INSP

COLD WORK THE FASTENER HOLES RH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

----- CONTINUED FROM STEP 25 -----

4. Do the cold expansion of the fastener holes in accordance with SRM 51-48-00.

Refer to FTI tool list No.

FTIA320531263-1

Capital tooling

1

OR

Refer to WCI tool list No.

WCIA320531263-1

Capital tooling

1

5. Remove the sleeves.

6. Ream the holes to the final hole diameter in accordance with SRM 51-48-00.

Refer to FTI tool list No.

DKA320531263-1

Durable tooling

1

OR

Refer to WCI tool list No.

DKA320531263-1

Durable tooling

1

7. Deburr and clean the fastener holes with Non Aqueous Cleaner-General 08BAA9 and Textile-Lint Free Cotton 14SBA1.

8. Renew the protective finish of the holes with Surface Pretreatment - Light Alloys Chemical 10ABC1.

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ATA:

Special Codes:

A/C: BIV

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STEP 27.

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

MECH

INSP

INSTALL THE BRACKETS, FITTING, PROFILES AND FASTENERS LH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

On the pressure panel LH, install the brackets, fitting, profiles and fasteners, refer to Fig. A-GBAAA Sheet 04, Fig. A-GBAAA Sheet 06, Fig. A-GBAAA Sheet 07 and Fig. A-GBAAA Sheet 08 (attached to the Work Order).

1. Put into position, refer to Fig. A-GBAAA Sheet 04 (attached to the Work Order), View D:

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|---------|----------------|-------------|---------------------|
| 1 | Filler | R5337031120200 | Item 3 | - |
| 1 | Doubler | R5337031120000 | Item 2 | - |
| 2 | Bracket | D9249179320000 | Item (61) | Retained at removal |

2. Wet install:

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|--------------------------|----------------|-------------|------|
| 1 | Beam Assy - Longitudinal | D5337239220000 | Item 58 | - |

attach with:

| | | | | |
|---|--------|----------------|-----------|---------------------|
| 2 | Bolt | NSA5042C07-285 | Item (50) | Retained at removal |
| 2 | Washer | D5337054320000 | Item (51) | Retained at removal |
| 2 | Nut | NSA5060C5 | Item (52) | Retained at removal |
| 2 | Pin | MS24665-153 | Item 1 | |

Use:

| | | | | |
|-------------|---|--------|---|---|
| As required | Polysulfide Sealant - General Purpose Brushable | 06AAA1 | - | - |
|-------------|---|--------|---|---|

NOTE

Install the AFT Bolt, Item (50), to the Beam Assy - Longitudinal, Item 58, before installing the FWD Bolt.

3. Torque Nut, Item (52) from 0.5 to 1.4 daNm (3.67 to 10.33 lbft).

----- CONTINUE IN STEP 28 -----

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ATA:

Special Codes:

A/C: BIV

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STEP 28.

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

MECH

INSP

INSTALL THE BRACKETS, FITTING, PROFILES AND FASTENERS LH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

----- CONTINUED FROM STEP 27 -----

4. Install, refer to Fig. A-GBAAA Sheet 04, View D Fig. A-GBAAA Sheet 07, View N and Fig. A-GBAAA Sheet 08 (attached to the Work Order), install:

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|---------------|----------------|-------------|---------------------|
| 1 | Angle-Bonding | A9249175120000 | Item (62) | Retained at removal |
| 4 | Bolt | EN6115K3-3 | Item 13 | - |
| 4 | Nut | ASNA2528-3 | Item 11 | - |

NOTE

Make sure these fasteners are installed dry.

5. Wet install the items that follow, refer to Fig. A-GBAAA Sheet 04, Fig. A-GBAAA Sheet 06, Fig. A-GBAAA Sheet 07 and Fig. A-GBAAA Sheet 08 (attached to the Work Order):

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|--------------|----------------|-------------|---------------------|
| 1 | Fitting | D2827004320300 | Item (55) | Retained at removal |
| 1 | Profile assy | D2827004600500 | Item (54) | Retained at removal |
| 1 | Profile assy | D2827004600900 | Item (56) | Retained at removal |
| 1 | Wedge | R5337031120400 | Item 4 | - |
| 1 | Shim | R5337031120600 | Item 5 | - |
| 2 | Pin | DAN5-6-5X | Item 26 | - |
| 2 | Collar | DAN11-6X | Item 8 | - |
| 4 | Pin | DAN7-6-6X | Item 14 | - |
| 4 | Collar | DAN14-6 | Item 9 | - |
| 8 | Bolt | EN6115K3-2 | Item 12 | - |
| 8 | Nut | ASNA2528-3 | Item 11 | - |

----- CONTINUE IN STEP 29 -----

PROPERTY OF "ROSSIYA AIRLINES" JSC

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STEP 29.

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

MECH

INSP

INSTALL THE BRACKETS, FITTING, PROFILES AND FASTENERS LH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

----- CONTINUED FROM STEP 28 -----

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|--------|----------------|-------------|------|
| 2 | Bolt | EN6115K3A8 | Item 16 | - |
| 2 | Nut | ASNA2538-3A | Item 37 | - |
| 2 | Washer | D5337239120000 | Item 6 | - |

NOTE

Rework Washer, Item 6 if necessary, refer to Fig. A-GBAAA Sheet 06 (attached to the Work Order), View J.

| | | | | |
|---|-------|-------------|---------|---|
| 2 | Rivet | EN6081D5-07 | Item 18 | - |
|---|-------|-------------|---------|---|

NOTE

The quantity of rivets, Item 18, can change related to the installation of the additional brackets, Item (61).

| | | | | |
|----|-------|-------------|---------|---|
| 15 | Rivet | EN6081D5-05 | Item 17 | - |
|----|-------|-------------|---------|---|

NOTE

The quantity of rivets, Item 17, can change related to the installation of the additional brackets, Item (61).

| | | | | |
|----|--------|-------------|---------|---|
| 13 | Rivet | EN6081D5-08 | Item 19 | - |
| 3 | Pin | DAN5-6-7Y | Item 28 | - |
| 4 | Pin | DAN5-6-8Y | Item 29 | - |
| 7 | Collar | NSA5330-6 | Item 7 | - |
| 6 | Pin | DAN5-6-5 | Item 30 | - |
| 6 | Collar | NSA5075-6 | Item 25 | - |

----- CONTINUE IN STEP 30 -----

PROPERTY OF "ROSSIYA AIRLINES" JSC

JIC: 45827 / 0

Title: COLD WORKING OF ATTACHMENT HOLES ON PRESSURE PANEL FR35-FR36 - REPAIR SOLUTION. SB_CONF.007.

Area:

ATA:

Special Codes:

A/C: BIV

Job Instruction Card for - / -

STEP 30.

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

MECH

INSP

INSTALL THE BRACKETS, FITTING, PROFILES AND FASTENERS LH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

----- CONTINUED FROM STEP 29 -----

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|-------------|---|-------------|-------------|------|
| 30 | Rivet | EN6081D6-09 | Item 21 | - |
| Use: | | | | |
| As required | Polysulfide Sealant - General Purpose Brushable | 06AAA1 | - | - |

6. Torque Nuts, Item 11 and Item 37 from 0.5 to 1.4 daNm (3.67 to 10.33 lbft).

7. Wet install the items that follow, refer to Fig. A-GBAAA Sheet 04, Fig. A-GBAAA Sheet 06 and Fig. A-GBAAA Sheet 08 (attached to the Work Order):

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|-------------|---|-------------|-------------|---------------------|
| 2 | Nut-Plate | NAS1792A3-1 | Item (57) | Retained at removal |
| 3 | Rivet | EN6081D7-07 | Item 22 | - |
| 3 | Rivet | EN6081D8-08 | Item 23 | - |
| Use: | | | | |
| As required | Polysulfide Sealant - General Purpose Brushable | 06AAA1 | - | - |

8. Wet install, refer to Fig. A-GBAAA Sheet 04 and Fig. A-GBAAA Sheet 08 (attached to the Work Order):

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|-------------|---|----------------|-------------|---------------------|
| 2 | Bracket | D3627001600000 | Item (53) | Retained at removal |
| 2 | Rivet | EN6081D5-05 | Item 17 | - |
| 2 | Rivet | EN6081D5-07 | Item 18 | - |
| Use: | | | | |
| As required | Polysulfide Sealant - General Purpose Brushable | 06AAA1 | - | - |

----- CONTINUE IN STEP 31 -----

PROPERTY OF "ROSSIYA AIRLINES" JSC

JIC: 45827 / 0

Title: COLD WORKING OF ATTACHMENT HOLES ON PRESSURE PANEL FR35-FR36 - REPAIR SOLUTION. SB_CONF.007.

Area:

ATA:

Special Codes:

A/C: BIV

Job Instruction Card for - / -

STEP 31.

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

MECH

INSP

INSTALL THE BRACKETS, FITTING, PROFILES AND FASTENERS LH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

----- CONTINUED FROM STEP 30 -----

9. Wet install the compressor support bracket removed for access, refer to Fig. A-GBAAA Sheet 04 and Fig. A-GBAAA Sheet 08, install (attached to the Work Order):

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|--------------|----------------|-------------|---------------------|
| 1 | Bracket Assy | D3847006201000 | Item (48) | Retained at removal |
| 4 | Pin | DAN7-6-7Y | Item 39 | - |
| 4 | Collar | DAN14-6Y | Item 40 | - |
| 4 | Pin | DAN5-5-5 | Item 20 | - |
| 4 | Collar | NSA5075-5 | Item 38 | - |

10. Apply surface protection to rivets, use:

| NAME | SPECIFICATION | QUANTITY |
|---|---------------|-------------|
| Primer Epoxy Paint - Corrosion Inhibiting | 04DAB2 | As required |
| Top Coat Polyurethane - Grey Internal Structure | 04JME4 | As required |

11. Repair water repellent coating, use Corrosion Preventive Compound - Water Displacing 12ADB1.

PROPERTY OF "ROSSIYA AIRLINES" JSC

JIC: 45827 / 0

Title: COLD WORKING OF ATTACHMENT HOLES ON PRESSURE PANEL FR35-FR36 - REPAIR SOLUTION. SB_CONF.007.

Area:

ATA:

Special Codes:

A/C: BIV

Job Instruction Card for - / -

STEP 32.

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

MECH

INSP

INSTALL THE BRACKETS, FITTING, PROFILES AND FASTENERS RH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

On the pressure panel RH, install the brackets, fitting, profiles and fasteners, refer to Fig. A-GBAAA Sheet 05, Fig. A-GBAAA Sheet 06, Fig. A-GBAAA Sheet 07 and Fig. A-GBAAA Sheet 08 (attached to the Work Order).

1. Put into position, refer to Fig. A-GBAAA Sheet 05 (attached to the Work Order):

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM |
|----------|---------|----------------|-------------|
| 1 | Filler | R5337031120200 | Item 3 |
| 1 | Doubler | R5337031120000 | Item 2 |

2. Wet install:

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|--------------------------|----------------|-------------|------|
| 1 | Beam Assy - Longitudinal | D5337239220000 | Item 58 | - |

attach with:

| | | | | |
|---|--------|----------------|-----------|---------------------|
| 2 | Bolt | NSA5042C07-285 | Item (50) | Retained at removal |
| 2 | Washer | D5337054320000 | Item (51) | Retained at removal |
| 2 | Nut | NSA5060C5 | Item (52) | Retained at removal |
| 2 | Pin | MS24665-153 | Item 1 | - |

Use:

| | | | | |
|-------------|---|--------|---|---|
| As required | Polysulfide Sealant - General Purpose Brushable | 06AAA1 | - | - |
|-------------|---|--------|---|---|

NOTE

Install the AFT Bolt, Item (50), to the Beam Assy - Longitudinal, Item 58, before installing the FWD Bolt.

3. Torque Nut, Item (52) from 0.5 to 1.4 daNm (3.67 to 10.33 lbf).

----- CONTINUE IN STEP 33 -----

PROPERTY OF "ROSSIYA AIRLINES" JSC

JIC: 45827 / 0

Title: COLD WORKING OF ATTACHMENT HOLES ON PRESSURE PANEL FR35-FR36 - REPAIR SOLUTION. SB_CONF.007.

Area:

ATA:

Special Codes:

A/C: BIV

Job Instruction Card for - / -

STEP 33.

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

MECH

INSP

INSTALL THE BRACKETS, FITTING, PROFILES AND FASTENERS RH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

----- CONTINUED FROM STEP 32 -----

4. Wet install the items that follow, refer to Fig. A-GBAAA Sheet 05, Fig. A-GBAAA Sheet 06, Fig. A-GBAAA Sheet 07 and Fig. A-GBAAA Sheet 08 (attached to the Work Order):

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|--------------|----------------|-------------|---------------------|
| 1 | Profile assy | D2827004600400 | Item (63) | Retained at removal |
| 1 | Fitting | D2827004320200 | Item (64) | Retained at removal |
| 1 | Profile assy | D2827004600800 | Item (65) | Retained at removal |
| 1 | Wedge | R5337031120400 | Item 4 | - |
| 1 | Shim | R5337031120600 | Item 5 | - |
| 1 | Pin | DAN5-6-5X | Item 26 | - |
| 1 | Collar | DAN11-6X | Item 8 | - |
| 4 | Pin | DAN7-6-6X | Item 14 | - |
| 4 | Collar | DAN14-6 | Item 9 | - |
| 8 | Bolt | EN6115K3-2 | Item 12 | - |
| 8 | Nut | ASNA2528-3 | Item 11 | - |
| 2 | Bolt | EN6115K3A8 | Item 16 | - |
| 2 | Nut | ASNA2538-3A | Item 37 | - |
| 2 | Washer | D5337239120000 | Item 6 | - |

NOTE

Rework Washer, Item 6 if necessary, refer to Fig. A-GBAAA Sheet 06, View J.

| | | | | |
|----|-------|-------------|---------|---|
| 2 | Rivet | EN6081D5-07 | Item 18 | - |
| 16 | Rivet | EN6081D5-05 | Item 17 | - |
| 13 | Rivet | EN6081D5-08 | Item 19 | - |
| 3 | Pin | DAN5-6-7Y | Item 28 | - |

----- CONTINUE IN STEP 34 -----

PROPERTY OF "ROSSIYA AIRLINES" JSC

JIC: 45827 / 0

Title: COLD WORKING OF ATTACHMENT HOLES ON PRESSURE PANEL FR35-FR36 - REPAIR SOLUTION. SB_CONF.007.

Area:

ATA:

Special Codes:

A/C: BIV

Job Instruction Card for - / -

STEP 34.

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

MECH

INSP

INSTALL THE BRACKETS, FITTING, PROFILES AND FASTENERS RH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

----- CONTINUED FROM STEP 33 -----

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|--------|-------------|-------------|------|
| 4 | Pin | DAN5-6-8Y | Item 29 | - |
| 7 | Collar | NSA5330-6 | Item 7 | - |
| 6 | Pin | DAN5-6-5 | Item 30 | - |
| 6 | Collar | NSA5075-6 | Item 25 | - |
| 35 | Rivet | EN6081D6-09 | Item 21 | - |

Use:

| | | | | |
|-------------|---|--------|---|---|
| As required | Polysulfide Sealant - General Purpose Brushable | 06AAA1 | - | - |
|-------------|---|--------|---|---|

5. Torque Nuts, Item 11 and Item 37 from 0.5 to 1.4 daNm (3.67 to 10.33 lbf).

6. Wet install the items that follow, refer to Fig. A-GBAAA Sheet 05 and Fig. A-GBAAA Sheet 06 (attached to the Work Order):

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|-----------|-------------|-------------|---------------------|
| 2 | Nut-Plate | NAS1792A3-1 | Item (57) | Retained at removal |
| 3 | Rivet | EN6081D7-07 | Item 22 | - |
| 3 | Rivet | EN6081D8-08 | Item 23 | - |

Use:

| | | | | |
|-------------|---|--------|---|---|
| As required | Polysulfide Sealant - General Purpose Brushable | 06AAA1 | - | - |
|-------------|---|--------|---|---|

----- CONTINUE IN STEP 35 -----

PROPERTY OF "ROSSIYA AIRLINES" JSC

JIC: 45827 / 0

Title: COLD WORKING OF ATTACHMENT HOLES ON PRESSURE PANEL FR35-FR36 - REPAIR SOLUTION. SB_CONF.007.

Area:

ATA:

Special Codes:

A/C: BIV

Job Instruction Card for - / -

STEP 35.

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

MECH

INSP

INSTALL THE BRACKETS, FITTING, PROFILES AND FASTENERS RH.

----- MARK THIS STEP AS NOT APPLICABLE (N/A) OR NOT REQUIRED (N/R) IF YOU DO NOT PERFORM THIS STEP -----

----- CONTINUED FROM STEP 34 -----

7. Wet install the items that follow, refer to Fig. A-GBAAA Sheet 05, Fig. A-GBAAA Sheet 06 and Fig. A-GBAAA Sheet 08 (attached to the Work Order):

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|-------------|---|----------------|-------------|---------------------|
| 2 | Bracket | D3627001600000 | Item (53) | Retained at removal |
| 2 | Rivet | EN6081D5-05 | Item 17 | - |
| 2 | Rivet | EN6081D5-07 | Item 18 | - |
| Use: | | | | |
| As required | Polysulfide Sealant - General Purpose Brushable | 06AAA1 | - | - |

8. Install the water tank bracket removed for access, refer to Fig. A-GBAAA Sheet 05 and Fig. A-GBAAA Sheet 08 (attached to the Work Order):

Install:

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|------------------|----------------|-------------|---------------------|
| 1 | Crossbeam | D3817011320000 | Item (46) | Retained at removal |
| 1 | Shear Plate Assy | D3817011400100 | Item (47) | Retained at removal |
| 40 | Rivet | LN9198-4016CF | Item 41 | - |
| 6 | Pin | DAN7-5-3 | Item 42 | - |
| 5 | Pin | DAN7-6-6 | Item 43 | - |
| 1 | Pin | DAN7-6-7 | Item 44 | - |
| 1 | Pin | DAN7-6-5 | Item 45 | - |
| 6 | Collar | DAN12-5 | Item 49 | - |
| 7 | Collar | DAN12-6 | Item 50 | - |

9. Apply surface protection to rivets, use:

| NAME | SPECIFICATION | QUANTITY |
|---|---------------|-------------|
| Primer Epoxy Paint - Corrosion Inhibiting | 04DAB2 | As required |
| Top Coat Polyurethane - Grey Internal Structure | 04JME4 | As required |

10. Repair water repellent coating, use Corrosion Preventive Compound - Water Displacing 12ADB1.

PROPERTY OF "ROSSIYA AIRLINES" JSC

JIC: 45827 / 0

Title: COLD WORKING OF ATTACHMENT HOLES ON PRESSURE PANEL FR35-FR36 - REPAIR SOLUTION. SB_CONF.007.

Area:

ATA:

Special Codes:

A/C: BIV

Job Instruction Card for - / -

STEP 36.

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

MECH

INSP

RE-IDENTIFY THE PRESSURE PLATE.

1. Reidentify with an applicable marker, refer to Process and Material Specification (PMS) 01-06-12 and Fig. A-GBAAA Sheet 06 (attached to the Work Order).

| QUANTITY | NAME | PART NUMBER | FIGURE ITEM | NOTE |
|----------|----------------|----------------|-------------|---------------------|
| 1 | Plate-Pressure | D5337090121200 | Item (59) | Retained at removal |
| becomes: | | | | |
| 1 | Plate-Pressure | D5337239220600 | Item 59 | - |

NOTE

Mark the new part number next to the old part number.

2. Apply Varnish-Protective Component 04TMC9.

STEP 37.

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

MECH

INSP

PREPARATION FOR TEST LH.

1. Install the retained air conditioning ducts, refer to AMM Task 21-20-00-410-001.
2. Install the fuselage overheat sensing elements, if removed, refer to AMM Task 36-22-18-400-001.
3. Install the drive shaft 6008CM, refer to AMM Task 27-84-45-400-004.
4. Install the APU bleed air ducts between FR35 and FR36, refer to AMM Task 36-12-41-400-001.
5. Install the LH RAM air inlet, refer to AMM Task 21-61-51-400-002.
6. Install the air ducts upstream of flow control valves, refer to AMM Task 21-51-51-400-002.
7. Install the trim air ducts, refer to AMM Task 21-63-42-400-001.
8. Install the pipes upstream to 16HM, refer to AMM Task 21-52-43-400-001.

STEP 38.

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

MECH

INSP

PREPARATION FOR TEST RH.

1. Install the retained air conditioning ducts, refer to AMM Task 21-20-00-410-001.
2. Install the fuselage overheat sensing elements, if removed, refer to AMM Task 36-22-18-400-001.
3. Install the retained mixer unit, refer to AMM Task 21-21-43-400-002.
4. Install the retained potable water tank, refer to AMM Task 38-11-41-400-002.
5. Install the drive shaft 6058CM, refer to AMM Task 27-84-43-400-003.
6. Install the APU bleed air ducts between FR35 and FR36, refer to AMM Task 36-12-41-400-001.
7. Install the air ducts upstream of flow control valves, refer to AMM Task 21-51-51-400-002.
8. Install the trim air ducts, refer to AMM Task 21-63-42-400-001.
9. Install the pipes upstream to 16HM, refer to AMM Task 21-52-43-400-001.

PROPERTY OF "ROSSIYA AIRLINES" JSC

JIC: 45827 / 0

Title: COLD WORKING OF ATTACHMENT HOLES ON PRESSURE PANEL FR35-FR36 - REPAIR SOLUTION. SB_CONF.007.

Area:

ATA:

Special Codes:

A/C: BIV

Job Instruction Card for - / -

STEP 39.

| Mech. Skill: B1 Dble. Rel. Skill: B1 | MECH | INSP |
|--|------|------|
| <p>OPERATIONAL TEST.</p> <ol style="list-style-type: none"> 1. Do a functional check of the vapor and seal and vent/drain system, refer to AMM Task 28-12-42-400-001. 2. Do an operational test of the water quantity indicating system if the potable water system was removed, refer to AMM Task 38-13-00-710-001. 3. Do an operational test of the water distribution system if the potable water system was removed, refer to AMM Task 38-12-00-710-001, AMM Task 38-12-00-710-002 or AMM Task 38-12-00-710-003. 4. Do an operational test of the overheat detection system, refer to AMM Task 36-22-00-710-001. | | |

STEP 40.

| Mech. Skill: B1 | MECH | INSP |
|---|------|------|
| <p>CLOSE-UP.</p> <ol style="list-style-type: none"> 1. Make sure that the work areas are clean and clear of tools and other items of equipment. 2. Install the insulation packs, if removed, refer to AMM Task 25-80-00-400-001. 3. Carefully reconnect the vapor seal membrane to the vapor seal brackets, refer to AMM Task 28-13-42-400-001. <div style="border: 1px solid #add8e6; padding: 10px; margin: 10px 0;"> <p style="text-align: center;"> NOTE</p> <div style="border: 1px solid #add8e6; padding: 5px; margin: 5px auto; width: 80%;"> <p>The vapor seal is fragile. Be careful when you move the vapor seal.</p> </div> </div> <ol style="list-style-type: none"> 4. If removed, install the air conditioning ducts, refer to AMM Task 21-20-00-401-001. 5. Install the forward cargo-compartment partition, refer to AMM Task 25-54-12-400-001. 6. Install these access panels 191BB, 191EB and 191KB, refer to AMM Task 53-35-13-400-002. 7. Install these access panels 192EB, 192FB and 192KB, refer to AMM Task 53-35-13-400-002. 8. Install the passenger seats between Frame 35.8 and Frame 42, refer to AMM Task 25-21-41-400-001. 9. Install the textile floor covering between Frame 35.8 and Frame 42, refer to AMM Task 25-28-41-400-001. 10. Install the floor panels 241DF and 241HF, refer to AMM Task 53-32-12-400-002. 11. Install the floor panels 242DF and 242HF, refer to AMM Task 53-32-12-400-002. 12. Remove the access platform(s). 13. Put the aircraft back to its initial configuration. | | |

PROPERTY OF "ROSSIYA AIRLINES" JSC