

JIC: 44869 / 0

Title: INSPECTION OF ATTACHMENT HOLES ON PRESSURE PANEL. SB_CONFIG.002.

Area:

ATA:

Special Codes:

A/C: BIV

Job Instruction Card for - / -

ITEM ONE - INSPECTION OF ATTACHMENT HOLES ON PRESSURE PANEL. SB_CONFIG.002.

Panels:	191BB (LOWER HALF FUSELAGE - PANEL 2 - BOTTOM (LOWER) SURFACE), 191EB (LOWER HALF FUSELAGE - PANEL 5 - BOTTOM (LOWER) SURFACE), 192EB (LOWER HALF FUSELAGE - PANEL 5 - BOTTOM (LOWER) SURFACE), 192FB (LOWER HALF FUSELAGE - PANEL 6 - BOTTOM (LOWER) SURFACE), 825 (DOORS)		
Zones:	140 (CENTER WING SIDE: LR), 825 (FORWARD CARGO COMPARTMENT DOOR SIDE: RH)		
References:	EASA AD: 2016-0206 CORR SB: 53-1264 Rev.01		
Material:	08BAA9	NON AQUEOUS CLEANER	1.0 req.
	14SBA1	TEXTILE-LINT FREE COTTON	2.0 req.
	MS24665-151	PIN-COTTER	1.0 req.
	MS9021-117	PACKING-PREFORMED	9.0 req.
	12ABC1	CORROSION PREVENTIVE COMPOUND	1.0 req.
	05RAJ9	ADHESIVE FILM TAPE	1.0 req.
	05TGA1	TAPE-ADHESIVE	2.0 req.
	14QEB1	WIRE-LOCKING DIA. 0.6 MM	1.0 req.
	06ABA1	POLYSULFIDE SEALANT	1.0 req.
	03FAB1	MINERAL OIL BASE GREASE (VV-P-236)	1.0 req.
	03QDB1	DRY LUBRICANT-ANTI SEIZING PTFE	1.0 req.
	14JAB1	SEALING PROFILE	1.0 req.

STEP 01.

HEADER. APPROVAL DATA.

Prepared by: 10657 02 NOV 2017
Approved by: 11700 02 NOV 2017

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STEP 02.

GENERAL INFORMATION.

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⚠ 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.

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STEP 03.

STANDARD PRACTICES.

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1. For the identification of zones, refer to AMM 06-20-00, Page Block 001.
2. For the Frame (FR) identification, refer to AMM 06-31-53, Page Block 001.
3. For the identification of access panels, refer to AMM 06-41-52, Page Block 001 and AMM 06-41-53, Page Block 001.
4. Remove and install fasteners in accordance with SRM 51-42-00.
5. When you remove fasteners you must be careful that you do not damage the holes in the structure.
6. Do the surface protection of reworked areas in accordance with SRM 51-75-12.

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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 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. Remove and retain these access panels 191BB, 191EB, 192EB and 192FB, refer to AMM Task 53-35-13-000-002.
3. Put an access platform in position below the FWD Cargo Compartment Door.
4. Open the FWD cargo compartment door 825, refer to AMM Task 52-30-00-860-001.
5. Remove the forward cargo-compartment partition, refer to AMM Task 25-54-12-000-001.
6. As necessary, remove the fuselage overheat sensing elements, refer to AMM Task 36-22-18-000-001.
7. If necessary, remove and retain the potable water tank, refer to AMM Task 38-11-41-000-001.
8. As necessary, remove and retain the insulation packs, refer to AMM Task 25-80-00-000-001.
9. As necessary, remove and retain the air conditioning ducts, refer to AMM Task 21-20-00-010-001.
10. If necessary, remove and retain the mixer unit, refer to AMM Task 21-21-43-000-001.
11. If necessary, loosen the vapour seal membrane from the vapour seal brackets, refer to AMM Task 28-13-42-000-001.

 **NOTE**

You must take care when you work with the vapor seal. Prevent distortion of the metal attach frames and fittings. Make sure that there are no tears, scratches or wrinkled areas on the vapor seal membrane.

It is not necessary to fully remove the vapor seal.

12. Remove the heat and sound insulation in the area between Frame 35 and Frame 36 LH and RH for access, refer to AMM Task 25-80-00-000-001.

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STEP 05.

Mech. Skill: B1	MECH	INSP
<p>REMOVE FASTENERS.</p> <p>1. Remove and discard the two fasteners, as shown at hole position A and hole position B, refer to Figure 01 (Sheet 01).</p> <p>2. Clean the holes with Textile-Lint Free Cotton 14SBA1 made moist with Non Aqueous Cleaner-General 08BAA9.</p>		

STEP 06.

Mech. Skill: NDT Dble. Rel. Skill: NDT	MECH	INSP
<p>SPECIAL DETAILED INSPECTION OF THE FASTENER HOLES ON THE PRESSURE PANEL BETWEEN FR35 AND FR36 UNDER THE LONGITUDINAL BEAM.</p> <p>1. Do the Special Detailed Inspection - rotating probe method (procedure "A") on hole A and hole B in accordance with NTM Task 51-10-01-250-801. Refer to Figure 01 (Sheet 01) and Figure 01 (Sheet 02).</p> <p>2. Fill in the Inspection Report attached to the Work Order.</p> <p>LH Side crack found (YES/NO): _____</p> <p>RH Side crack found (YES/NO): _____</p> <p>NDT Report reference (in case of findings): _____ _____ _____</p> <p>- If a crack is found outside of the area where a repair can be made, refer to Figure 01 (Sheet 02): Immediately inform Engineering Department or Customer Representative to contact AIRBUS before next flight for further repair instructions.</p> <p>- If a crack is found within the area where the panel can be repaired with a cut-out section, refer to Figure 01 (Sheet 02): Before the next flight, do the repair and cold working procedure of the hole in accordance with Service Bulletin No. A320-53-1263. Get the dedicated Work Order from MCC or Customer Representative.</p> <p>- If no crack is found: Before the next flight, do the cold working procedure of the hole in accordance with Service Bulletin No. A320-53-1240. Get the dedicated Work Order from MCC or Customer Representative.</p>		

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STEP 07.

Mech. Skill: B1	MECH	INSP
<p>PREPARATION FOR TEST.</p> <ol style="list-style-type: none"> 1. Install the potable water tank, refer to AMM Task 38-11-41-400-002. 2. Install the heat and sound insulation between Frame 35 and Frame 36 that was removed for access, refer to AMM Task 25-80-00-400-001. 3. Install the overheat sensing elements, refer to AMM Task 36-22-18-400-001. 4. If removed before, install the air conditioning ducts, refer to AMM Task 21-20-00-410-001. 5. If removed before, install the mixer unit, refer to AMM Task 21-21-43-400-002. 6. If removed before, install the vapour seal membrane to the vapour seal brackets, refer to AMM Task 28-13-42-400-001. 7. Install the forward cargo-compartment partition, refer to AMM Task 25-54-12-400-001. 		

STEP 08.

Mech. Skill: B1 Dble. Rel. Skill: B1	MECH	INSP
<p>LEAK TEST.</p> <ol style="list-style-type: none"> 1. Do a leak check of the air supply system, refer to AMM Task 38-41-00-790-002. 2. Operate the air conditioning system and make sure there are no leaks at the installed ducts, refer to AMM Task 12-33-21-618-001. 		

STEP 09.

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. If necessary, install the insulation packs, refer to AMM Task 25-80-00-400-001. 3. Install the access panels 191BB, 191EB, 192EB, 192FB, refer to AMM Task 53-35-13-400-002. 4. Close the FWD cargo compartment door 825, refer to AMM Task 52-30-00-860-002. 5. Remove the access platform(s). 6. Put the aircraft back to its initial configuration. 		

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STEP 10.

Mech. Skill: B1

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FOLLOW UP ACTIONS REPORT.

Please fill in the tables below in accordance with the inspection results.

POSITION FR 36 LH	
FINDING (MARK BY TICK)	
NO [] ----->	APPLICATION OF SB 53-1240
YES [] ----->	WITHIN REPAIRABLE AREA ? (MARK BY TICK)
YES [] ----->	APPLICATION OF SB 53-1263
NO [] ----->	REQUEST TO AIRBUS

POSITION FR 36 RH	
FINDING (MARK BY TICK)	
NO [] ----->	APPLICATION OF SB 53-1240
YES [] ----->	WITHIN REPAIRABLE AREA ? (MARK BY TICK)
YES [] ----->	APPLICATION OF SB 53-1263
NO [] ----->	REQUEST TO AIRBUS

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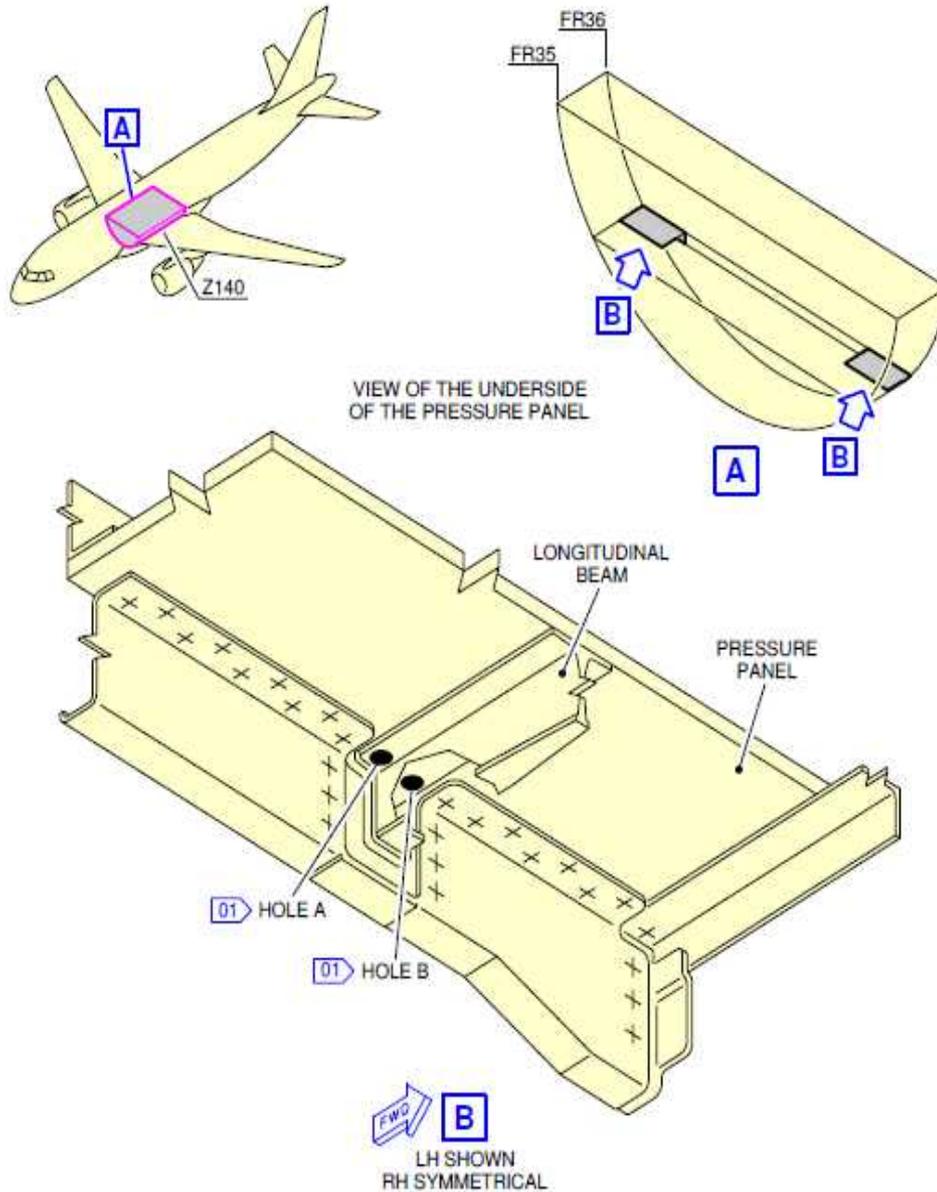
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FIGURE 01 (SHEET 01).

INSPECTION OF FASTENER HOLES A AND B ON THE PRESSURE PANEL BETWEEN FR35 AND FR36.



NOTE:

01 FASTENERS TO BE REMOVED, AS SHOWN, FOR SPECIAL DETAILED INSPECTION OF HOLES.

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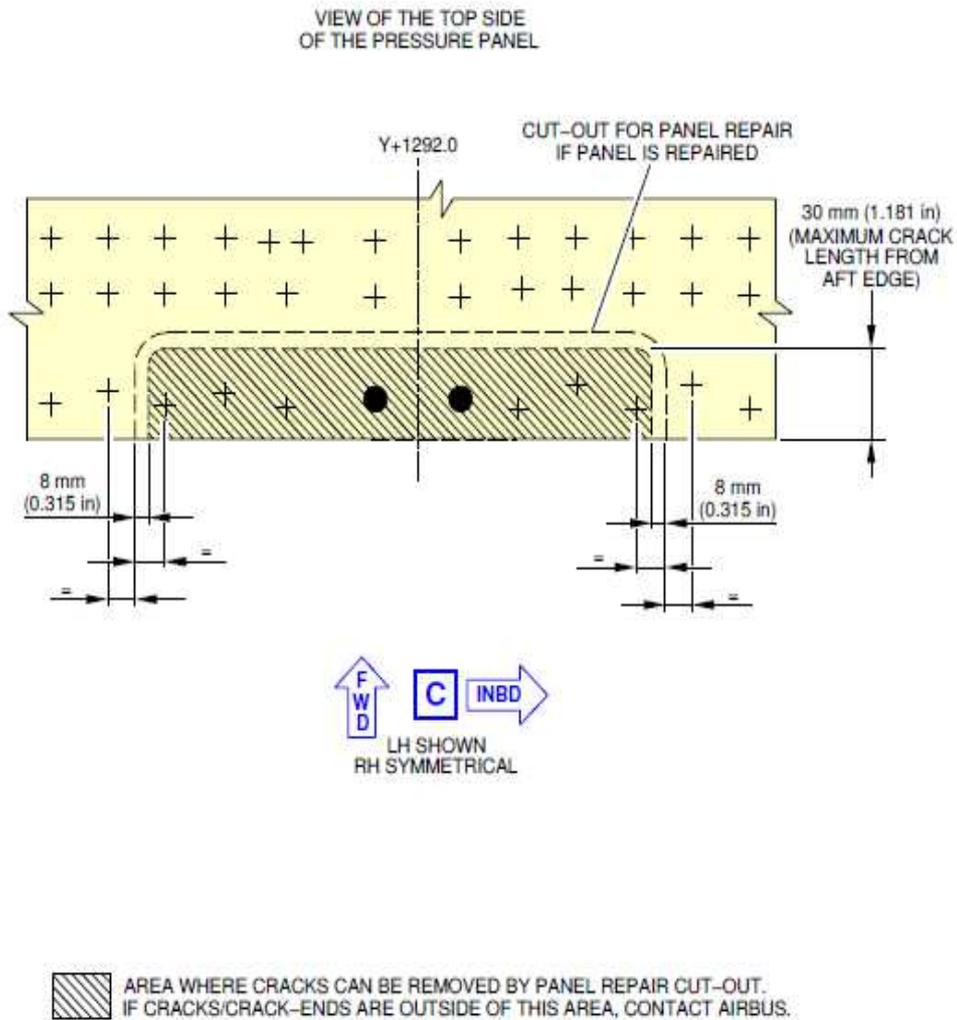
Special Codes:

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FIGURE 01 (SHEET 02).

INSPECTION OF FASTENER HOLES A AND B ON THE PRESSURE PANEL BETWEEN FR35 AND FR36.



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