

JIC: **45765 / 0**

Title: COLD EXPANSION OF ATTACHMENT HOLES ON PRESSURE PANEL FR35-FR36\_SB\_CONF.004.

Area:

ATA:

Special Codes:

A/C: **BIV**

Job Instruction Card for - / -

**ITEM ONE - COLD EXPANSION OF ATTACHMENT HOLES ON PRESSURE PANEL FR35-FR36\_SB\_CONF.004.**

<b>Panels:</b>	191BB (LOWER HALF FUSELAGE - PANEL 2 - BOTTOM (LOWER) SURFACE), 192FB (LOWER HALF FUSELAGE - PANEL 6 - BOTTOM (LOWER) SURFACE), 241DF (UPPER HALF FUSELAGE - PANEL 4 - FLOOR PANEL), 241HF (), 242DF (UPPER HALF FUSELAGE - PANEL 4 - FLOOR PANEL), 242HF (), 831 (DOORS), 841 (DOORS)		
<b>Zones:</b>	190 (BELLY FAIR, AIR CONDITON-ING & HYD COMPT SIDE: LR), 240 (MID PASSENGER COMPARTMENT SIDE: LR), 241 (CENTER PASSENGER COMPARTMENT SIDE: LH), 242 (CENTER PASSENGER COM-PARTMENT SIDE: RH), 800 (DOORS SIDE: LR)		
<b>References:</b>	EASA AD: 2016-0206 CORR SB: 53-1240 Rev.02		
<b>Material:</b>	08BAA9	NON AQUEOUS CLEANER	1.0 req.
	10ABC1	SURFACE PRETREATMENT	1.0 req.
	14SBA1	TEXTILE-LINT FREE COTTON	1.0 req.
	04CMA2	WASH PRIMER	1.0 req.
	04EAC2	PRIMER	0.5 req.
	04JME4	TOP COAT POLYURETHANE-	0.5 req.
	06AAA1	POLYSULFIDE SEALANT (DAN1159)	0.5 req.
	12ADB1	CORROSION PREVENTIVE COMPOUND	1.0 req.
<b>Tools:</b>	531240D02R02	KIT	1.0 req.
	DK-A320531240-4	DURABLE TOOLING	1.0 req.
	EK-A320531240-4	EXPENDABLE TOOLING	1.0 req.
	WCIA320531240-4	CAPITAL TOOLING	1.0 req.

**STEP 01.**

HEADER. APPROVAL DATA.

Prepared by:	10657	17 NOV 2017.
Approved by:	11700	17 NOV 2017

**MECH**
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## STEP 02.

### 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.

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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 06-41-53, Page Block 001.
5. To torque tighten the standard threaded fasteners, refer to AMM Task 20-21-11-911-001.
6. Obtain corrosion prevention data 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 the protective finish in accordance with SRM 51-75-12.
10. Apply sealant in accordance with SRM 51-24-00.
11. Obtain fastener edge and margin data in accordance with SRM 51-47-00.
12. Cold expand the 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. 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.

**MECH**
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**STEP 04.**
**JOB SET-UP.**

The job set-up procedure is done during implementation of Work Order for Service Bulletin No. A320-53-1264 (FUSELAGE - CENTER FUSELAGE - INSPECTION OF ATTACHMENT HOLES ON PRESSURE PANEL FR35 - FR36 (CENTER WING BOX)).

**MECH**
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**STEP 05.**
**REMOVE THE FASTENERS IN THE PRESSURE PANEL AT FR36.**

The removal of the fasteners is done during implementation of Work Order for Service Bulletin No. A320-53-1264 (FUSELAGE - CENTER FUSELAGE - INSPECTION OF ATTACHMENT HOLES ON PRESSURE PANEL FR35 - FR36 (CENTER WING BOX)).

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**STEP 06.**

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

**MECH**
**INSP**

PREPARE THE STRUCTURE TO INSTALL THE NEW FASTENERS AT FR36 LH.

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



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.

At FR36 LH, refer to Fig. A-GCAAB Sheet 01 (attached to the Work Order), View B and in accordance with SRM 51-48-00, do the cold expansion of the fastener holes.

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

Refer to WCI tool list No.	DK-A320531240-4	Durable tooling	1
or			
Refer to FTI tool list No.	DK-A320531240-2		

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.	EK-A320531240-2	Expendable tooling	1
or			
Refer to WCI tool list No.	EK-A320531240-4		

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

Refer to FTI tool list No.	FTIA320531240-2	Capital tooling	1
or			
Refer to WCI tool list No.	WCIA320531240-4		

5. Remove the sleeves.

6. Ream the holes to the final hole diameter in accordance with SRM 51-48-00 and Fig. A-GCAAB Sheet 01 (attached to the Work Order).

Refer to FTI tool list No.	DK-A320531240-2	Durable tooling	1
or			
Refer to WCI tool list No.	DK-A320531240-4		

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 in accordance with SRM 51-75-12 with Surface Pretreatment - Light Alloys 10ABC1.

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**STEP 07.**

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

**MECH**
**INSP**

PREPARE THE STRUCTURE TO INSTALL THE NEW FASTENERS AT FR36 RH.

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



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.

At FR36 RH, refer to Fig. A-GCAAB Sheet 01 (attached to the Work Order), View B and in accordance with SRM 51-48-00, do the cold expansion of the fastener holes.

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

Refer to FTI tool list No.	DK-A320531240-2	Durable tooling	1
or			
Refer to WCI tool list No.	DK-A320531240-4		

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.	EK-A320531240-2	Expendable tooling	1
or			
Refer to WCI tool list No.	EK-A320531240-4		

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

Refer to FTI tool list No.	FTIA320531240-2	Capital tooling	1
or			
Refer to WCI tool list No.	WCIA320531240-4		

5. Remove the sleeves.

6. Ream the holes to the final hole diameter in accordance with SRM 51-48-00 and Fig. A-GCAAB Sheet 01 (attached to the Work Order).

Refer to WCI tool list No.

Refer to FTI tool list No.	DK-A320531240-2	Durable tooling	1
or			
Refer to WCI tool list No.	DK-A320531240-4		

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 in accordance with SRM 51-75-12 with Surface Pretreatment - Light Alloys 10ABC1.

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**STEP 08.**

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

**MECH**
**INSP**

INSTALL THE NEW FASTENERS IN THE PRESSURE PANEL AT FR36 LH.

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



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.

1. In the pressure panel at FR36 LH temporarily install 2 (two) Washers, P/N D5337239120000, Figure Item 1.

Refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D (attached to the Work Order).

2. Make sure that the washers, Item 1, are installed flat and not on the radius.

If necessary rework the washers.

Refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D (attached to the Work Order).

3. Remove the washers.

4. Apply protective treatment to the reworked washers, Item 1. Use:

NAME	SPECIFICATION	QUANTITY
Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

5. In the pressure panel at FR36 LH, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02 (attached to the Work Order), Views C and D, and in accordance with SRM 51-42-00, wet install:

QUANTITY	NAME	PART NUMBER	FIGURE ITEM
2	Bolt	EN6115K3A8	Item 6
2	Collar	ASNA2538-3A	Item 3
2	Washer	D5337239120000	Item 1
with:			
As required	Polysulfide Sealant - General Purpose Brushable	06AAA1	-

6. Torque tighten fasteners, refer to AMM Task 20-21-11-911-001.

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

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## STEP 09.

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

MECH

INSP

INSTALL THE NEW FASTENERS IN THE PRESSURE PANEL AT FR36 LH.

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

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

7. To the fasteners, apply in accordance with SRM 51-75-12:

NAME	SPECIFICATION	QUANTITY
Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required
and		
Corrosion Preventive Compound	12ADB1	As required

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**STEP 10.**

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

**MECH**
**INSP**

INSTALL THE NEW FASTENERS IN THE PRESSURE PANEL AT FR36 RH.

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



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.

- In the pressure panel at FR36 RH temporarily install 2 (two) Washers, P/N D5337239120000, Figure Item 1.  
Refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D (attached to the Work Order).
- Make sure that the washers, Item 1, are installed flat and not on the radius.  
If necessary rework the washers.  
Refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D (attached to the Work Order).
- Remove the washers.
- Apply protective treatment to the washers, Item 1. Use:

NAME	SPECIFICATION	QUANTITY
Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

- In the pressure panel at FR36 RH, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, Views C and D (attached to the Work Order), and in accordance with SRM 51-42-00, wet install:

QUANTITY	NAME	PART NUMBER	FIGURE ITEM
2	Bolt	EN6115K3A8	Item 6
2	Collar	ASNA2538-3A	Item 3
2	Washer	D5337239120000	Item 1

with:

As required	Polysulfide Sealant - General Purpose Brushable	06AAA1	-
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- Torque tighten fasteners, refer to AMM Task 20-21-11-911-001.

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



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**STEP 11.**

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

**MECH**
**INSP**

INSTALL THE NEW FASTENERS IN THE PRESSURE PANEL AT FR36 RH.

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

----- CONTINUED FROM STEP 10 -----

7. To the fasteners, apply in accordance with SRM 51-75-12:

NAME	SPECIFICATION	QUANTITY
Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required
and		
Corrosion Preventive Compound	12ADB1	As required

**STEP 12.**

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

**MECH**
**INSP**

PREPARATION FOR TEST.

1. Install the potable water tank, refer to AMM Task 38-11-41-400-002.
2. Install the heat and sound insulation between FR35 and FR36 that was removed for access, refer to AMM Task 25-80-00-400-001.
3. Install the overheating 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. Install the forward cargo-compartment partition, refer to AMM Task 25-54-12-400-001.

**STEP 13.**

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

**MECH**
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OPERATIONAL TEST.

1. 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.
2. Do an operational test of the water distribution system if the potable water system was removed, refer to AMM 38-12-00, Page Block 501.
3. Do an operational test of the overheat detection system, refer to AMM Task 36-22-00-710-001.
4. Do the leak test of the air conditioning distribution ducts, refer to AMM Task 21-20-00-710-050.

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## STEP 14.

Mech. Skill: B1	MECH	INSP
<p>CLOSE-UP.</p> <ol style="list-style-type: none"> <li>1. Make sure that the work areas are clean and clear of tools and other items of equipment.</li> <li>2. If necessary, install the insulation blankets, refer to AMM Task 25-80-00-400-001.</li> <li>3. Install the access panels 191BB and 192FB, refer to AMM Task 53-35-13-400-002.</li> <li>4. Remove the access platform.</li> <li>5. Put the aircraft back to its initial configuration.</li> </ol>		

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