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ATA SYSTEM: 53

**TITLE: FUSELAGE - NOSE FORWARD FUSELAGE - REDESIGN OF THE DOUBLE JOGGLE AREA FRAME 16 LHS**

MODIFICATION No.:

160876P15989

ATA SYSTEM: 53

### TITLE: FUSELAGE - NOSE FORWARD FUSELAGE - REDESIGN OF THE DOUBLE JOGGLE AREA FRAME 16 LHS

#### REVISION TRANSMITTAL SHEET

This page transmits Revision No. 01 of Service Bulletin No. A320-53-1381.

#### A. ADDITIONAL WORK

No additional work is required by this revision.

#### B. REASON

Revision No. 01 issued to:

- Update the applicability
- Transform Service Bulletin data from ATA iSpec 2200 norm to ASD S1000D norm
- Remove the applicability note.

#### C. CHANGES

#### CONF 001

SERVICE BULLETIN	
General	Revised text and layout changes of this revision are not identified with revision bars Minor changes applied
SUMMARY	
REASON	Reason updated
APPLICABILITY	Applicability updated
PLANNING INFORMATION	
REASON	Reason updated
PUBLICATION AFFECTED	Publication affected updated
MATERIAL INFORMATION	
TOOLING	Quantity of aircraft standard tools updated
LIST OF NEW PARTS	
Part kit 531381A01R01	Cost and availability updated
Referenced parts for task set A320-A-53-XX-1381-01000-93AA-A Modification	Note added
ACCOMPLISHMENT INSTRUCTIONS	
Task set A320-A-53-XX-1381-01000-93AA-A Modification	
SAFETY INFORMATION	Note updated
PREPARATION	Note added

#### CONF 002

SERVICE BULLETIN	
General	Revised text and layout changes of this revision are not identified with revision bars

	Minor changes applied
SUMMARY	
REASON	Reason updated
APPLICABILITY	Applicability updated
PLANNING INFORMATION	
REASON	Reason updated
PUBLICATION AFFECTED	Publication affected updated
MATERIAL INFORMATION	
TOOLING	Quantity of aircraft standard tools updated
LIST OF NEW PARTS	
Part kit 531381A02R01	Cost and availability updated
Referenced parts for task set A320-A-53-XX-1381-01000-93AA-A Modification	Note added
ACCOMPLISHMENT INSTRUCTIONS	
Task set A320-A-53-XX-1381-01000-93AA-A Modification	
SAFETY INFORMATION	Note updated
PREPARATION	Note added

**CONF 003**

SERVICE BULLETIN	
General	Revised text and layout changes of this revision are not identified with revision bars Minor changes applied
SUMMARY	
REASON	Reason updated
APPLICABILITY	Applicability updated
PLANNING INFORMATION	
REASON	Reason updated
PUBLICATION AFFECTED	Publication affected updated
MATERIAL INFORMATION	
TOOLING	Quantity of aircraft standard tools updated
LIST OF NEW PARTS	
Part kit 531381A03R01	Cost and availability updated
Referenced parts for task set A320-A-53-XX-1381-01000-93AA-A Modification	Note added
ACCOMPLISHMENT INSTRUCTIONS	
Task set A320-A-53-XX-1381-01000-93AA-A Modification	
SAFETY INFORMATION	Note updated
PREPARATION	Note added

**CONF ALL****D. FILING INSTRUCTIONS**

This Service Bulletin has been generated electronically and is reissued as a complete document. Replace the complete document.

Put this Revision Transmittal Sheet in front of the Service Bulletin.

**E. HISTORY OF PREVIOUS REVISIONS**

No previous revision

**F. REVISION SEQUENCE**

ORIGINAL: Jun 14/18

REVISION No. : 01 - Sep 18/19

ATA SYSTEM: 53

**TITLE: FUSELAGE - NOSE FORWARD FUSELAGE - REDESIGN OF THE DOUBLE JOGGLE AREA FRAME 16 LHS****SUMMARY**

This summary is for information only and is not approved for modification of the aircraft.

**A. MODIFICATIONS****CONF 001**

MODIFICATION CLASSIFICATION	
MAJOR	None
MINOR	160876P15989

NOTE: As per EASA IR 21, a minor change is one that has no appreciable effect on the mass, balance, structural strength, reliability, operational characteristics affecting the airworthiness of the product. All other changes are major changes.

**CONF 002**

MODIFICATION CLASSIFICATION	
MAJOR	None
MINOR	160876P15989

NOTE: As per EASA IR 21, a minor change is one that has no appreciable effect on the mass, balance, structural strength, reliability, operational characteristics affecting the airworthiness of the product. All other changes are major changes.

**CONF 003**

MODIFICATION CLASSIFICATION	
MAJOR	None
MINOR	160876P15989

NOTE: As per EASA IR 21, a minor change is one that has no appreciable effect on the mass, balance, structural strength, reliability, operational characteristics affecting the airworthiness of the product. All other changes are major changes.

**CONF ALL****B. REASON****(1) History**

Following the amount and severity of in-service findings and the high finding rate in the double joggle area, the need for an in-service action has been identified.

Definition of a new harmonised and unique inspection program for both Frame 16 and Frame 20 double joggle area taking into account the in-service findings.

**(2) Objective/Action**

The modification consists in redesigning the double joggle area at Frame 16 Left Hand (LH) side. It implies to apply cold working at Frame 16 LH side and install moderate interference fit fasteners.

The procedure as described in this Service Bulletin is to be performed if no AIRBUS repair and/or repair improvement has been previously performed in the same area. In case of repairs performed previously, please contact AIRBUS repair support department for further instructions.

Prior to Service Bulletin accomplishment, specific attention must be paid to the preparation, refer to paragraph 3.B Preparation.

**(3) Advantages**

The modification will contribute to avoid new in-service findings in the double joggle area.

Accomplishment of this Service Bulletin cancels the requirements of Service Bulletin No. Ref. SB A320-53-1373 for LH side.

**(4) Operational/Maintenance Consequences**

None

**C. GENERAL EVALUATION**

EVALUATION TABLE			
COMPLIANCE	RECOMMENDED	COST SAVING	NO
A/C OPERATION AFFECTED	NO	VENDOR SB	NO
CANCELS INSPECTION SB	YES	ETOPS AFFECTED	NO
PAX COMFORT AFFECTED	NO	POTENTIAL AD	NO
RELIABILITY AFFECTED	NO	STRUCTURAL LIFE EXTENSION	NO
LIFE LIMIT	NO	LINE MAINTENANCE AFFECTED	NO

**NOTE:** Service Bulletin recommended to be accomplished to prevent significant operational disruptions.

**D. MAINTENANCE CONFIGURATION**

**CONF 001**

No specific aircraft maintenance configuration required.

**CONF 002**

No specific aircraft maintenance configuration required.

**CONF 003**

No specific aircraft maintenance configuration required.

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**E. MATERIAL PRICE INFORMATION**

**CONF 001**

**(1) Modification**

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	QTY PER A/C	PRICE PER A/C	MAIN PARTS
Part kit 531381A01R01	1	420.00 USD	Bolts, nuts
Aircraft standard tools	See SB	See Note	FTI cold working tools, WCI cold working tools

NOTE: Price information to be obtained from the given supplier.

**CONF 002**

**(1) Modification**

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

<b>MATERIAL PRICE INFORMATION TABLE</b>			
<b>MATERIAL SET</b>	<b>QTY PER A/C</b>	<b>PRICE PER A/C</b>	<b>MAIN PARTS</b>
Part kit 531381A02R01	1	420.00 USD	Bolts, nuts
Aircraft standard tools	See SB	See Note	FTI cold working tools, WCI cold working tools

NOTE: Price information to be obtained from the given supplier.

**CONF 003**

**(1) Modification**

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

<b>MATERIAL PRICE INFORMATION TABLE</b>			
<b>MATERIAL SET</b>	<b>QTY PER A/C</b>	<b>PRICE PER A/C</b>	<b>MAIN PARTS</b>
Part kit 531381A03R01	1	420.00 USD	Bolts, nuts
Aircraft standard tools	See SB	See Note	FTI cold working tools, WCI cold working tools

NOTE: Price information to be obtained from the given supplier.

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**F. APPLICABILITY**

This Service Bulletin is applicable to this (these) operator(s):

03Q 06R 10N 11K 11X 13Y 14S 15T 19R 20M 23R 25P 26L 28M 29S 31V 32Q 34L 36R 38W 39N 40N 40S 41N 41S 46L 46U 47P 48L 48O 49O 50T 56O 60U 61W 66X 68M 69X 72T 73W 76W 78X 82M 82U 83O 83Q 83V 84M 85T 86P 86Z 87Q 89Q 95V 95W 96O 96Q 96U 98W 98X 99W A1L AAF AAL AAR AAV AAW AAY ABL ABN ABQ ABY ACA ACI ADR AEE AFL AFR AHY AIC AIJ ALK AMC AMU AMV ANA ANR ANZ APJ ART ARU ASA ASL ASV ATR AUA AUH AVA AVJ AWC AWW AXM AZA AZU B2V BAV BAW BEC BEG BEL BGF BGH BKP BSX BTK BTN BUC C2C CBG CBJ CCA CCM CDC CEB CES CFG CGH CHB CLH CQH CQN CRK CSA CSC CSN CSZ CTB CTN CTV CYP DAL DKH DLH DNU DQA DRK DTR EAF EDW EIN ELB ERN ETD ETJ EVA EVE EWE EWG EYZ F2I FAD FBS FFT FHM FHY FIA FIN FLI FOO FRN G8E GAF GAP GBB GCR GFA GJT GLG GMI GOW GSW GWI GWR GZQ HDA HES HFM HFY HIM HKE HVN HXA I2L IAW IBE IBS IGO IND IRA IRB IRC IRM ISR IYE IZG JAD JAT JAV JBU JBU JCC JES JJP JOC JSA JST JZR KAC KHV KIS KKK KME KNE KZR LAA LAN LAO LBT LDM LFO LGW LKE LLM LMJ LMU LUR LWA LYX LZB MAC MAU MEA MJN MKR MLD MMA MMM MMO MRJ MSC MSR MXA MYX NIA NKS NMA NMB NVD NWK NWS O8K OHY OLY OMS ONE ORF OTC OTF OZW PAL PGT PIA PIC PKZ PTI QAF QDA QQE QSM QTR R1T RBA RBG RIH RJA RJD RNA ROT RSY RWZ RYL RYW RZO SAA SAS SAW SBI SDM SDR SEK SEY SFJ SFW SGQ SHJ SHU SKU SLK SND SNG SOL SSV SUD SVA SVR SWM SWR SYR SZN T2R TAE TAI TAM TAP TAR TBA TBZ TCN TCX TDR TGW THD THY TNA TSC TTW U6A UAL UEA UJX USA UZB VAW VIV VJC VKG VLG VNL VOE VOI VRE VTI VVC WHT WOW WRC WZZ

### G. CONCURRENT REQUIREMENTS

None

### H. NATURE OF THE WORK

#### CONF 001

##### (1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

AIRCRAFT	YES
EQUIPMENT	NO

#### CONF 002

##### (1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

AIRCRAFT	YES
EQUIPMENT	NO

#### CONF 003

##### (1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

AIRCRAFT	YES
EQUIPMENT	NO

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### I. MANPOWER

#### CONF 001

##### (1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

MANPOWER	
TOTAL MAN-HOURS	22.35 h
ELAPSED TIME (HOURS)	22.35 h

#### CONF 002

##### (1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

MANPOWER	
TOTAL MAN-HOURS	22.35 h
ELAPSED TIME (HOURS)	22.35 h

#### CONF 003

##### (1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

MANPOWER	
TOTAL MAN-HOURS	22.35 h

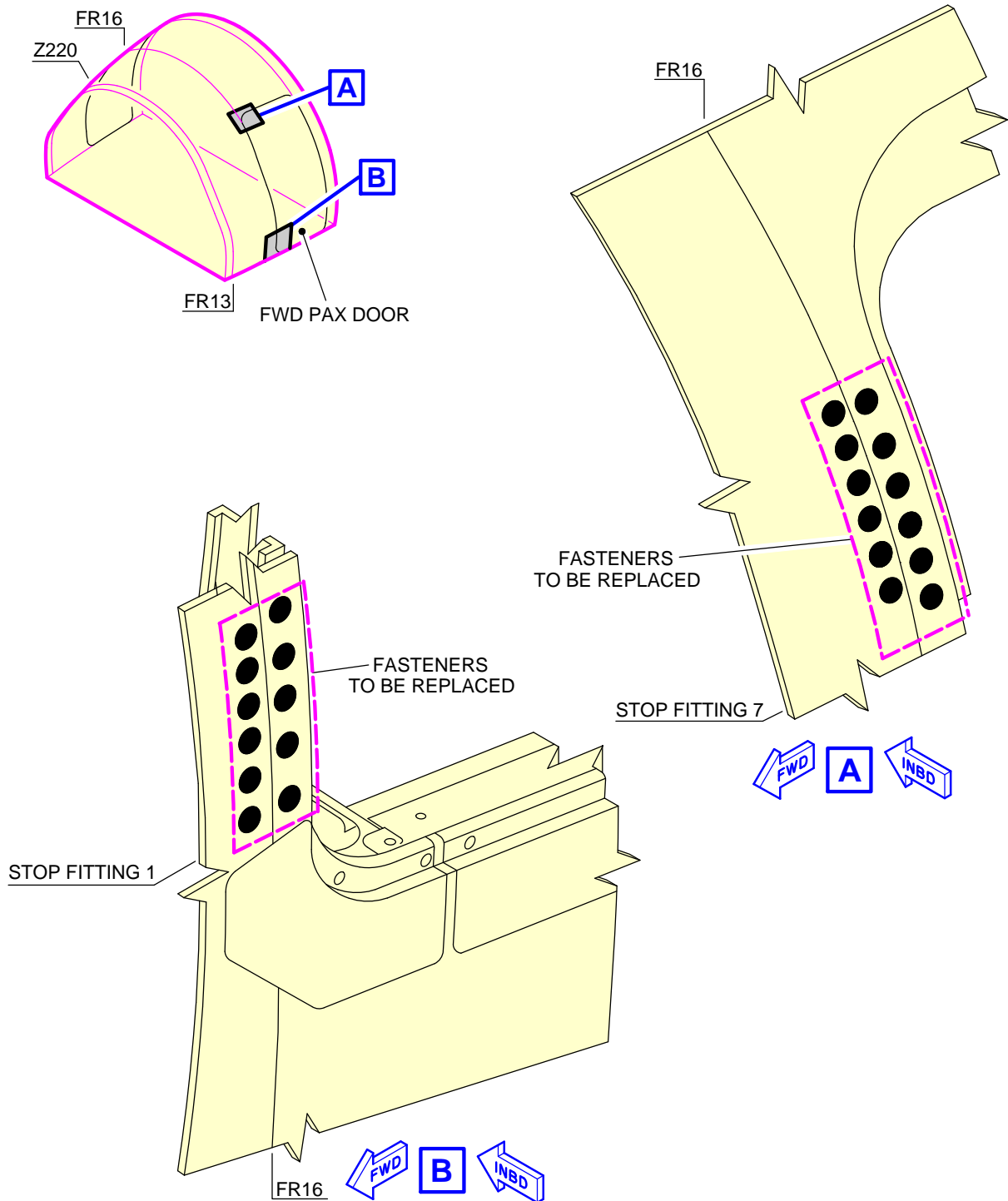


<b>MANPOWER</b>	
ELAPSED TIME (HOURS)	22.35 h

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### J. GENERAL OVERVIEW

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ICN-A320-A-53XX1381-A-FAPE3-00A39-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A39-A-001-01 SHEET 1/1

ATA SYSTEM: 53

**TITLE: FUSELAGE - NOSE FORWARD FUSELAGE - REDESIGN OF THE DOUBLE JOGGLE AREA FRAME 16 LHS****1. PLANNING INFORMATION****A. APPLICABILITY**

NOTE: This modification is applicable by Service Bulletin only.

NOTE: The intent of this modification is achieved in production on:

- A319 aircraft with MSN 09020 and subsequent
- A320 aircraft with MSN 08786 thru 08797, 08824 and subsequent
- A321 aircraft with MSN 08791, 08822 thru 08854, 08858 and subsequent through modification No. 160917P15988.

NOTE: This Service Bulletin is only applicable to aircraft on which MOD No. 160917P15988 (FUSELAGE - NOSE FORWARD FUSELAGE - REDESIGN THE DOUBLE JOGGLE AREA FRAME 16 AND 20 (SERIAL SOLUTION)) is not embodied.

NOTE: This Service Bulletin is not applicable to A319 CORPO JET and A318 ELITE.

**(1) Models**

***ON A/C 02035, 02059, 02071, 02081, 02100, 02109, 02317, 02328, 02333, 02344, 02350, 02358, 02367, 02377, 02582, 02601, 02686, 02750, 02918, 02931, 02951, 02955, 02967, 02972, 03009, 03220, 03225***

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***ON A/C 02394, 02523, 02544, 02552, 02575, 04007, 04039***

318-112

***ON A/C 03635***

318-121

***ON A/C 03030, 03062, 03214, 03216, 03371, 03390, 03469, 03509, 03585, 03602, 03606, 03642***

318-122

***ON A/C 00750, 00755, 00763, 00790, 00821, 00837, 00906, 00917, 00933, 00938, 00979, 00985, 00998, 01000, 01020, 01025, 01034, 01036, 01100, 01106, 01120, 01127, 01151, 01165, 01169, 01176, 01180, 01190, 01201, 01216, 01247, 01267, 01271, 01344, 01362, 01404, 01415, 01444, 01449, 01471, 01488, 01505, 01524, 01560, 01583, 01616, 01622, 01640, 01645, 01654, 01677, 01679, 01684, 01699, 01733, 01743, 01753, 01759, 01761, 01803, 01841, 01851, 01863, 01876, 01890, 01938, 02010, 02030, 02037, 02043, 02050, 02052, 02053, 02062, 02069, 02072, 02091, 02093, 02103, 02119, 02120, 02129, 02170, 02176, 02179, 02181, 02184, 02196, 02213, 02214, 02222, 02228, 02230, 02236, 02240, 02241, 02243, 02245, 02249, 02251, 02253, 02258, 02260, 02264, 02279, 02283, 02287, 02289, 02300, 02311, 02318, 02332, 02353, 02360, 02365, 02370, 02380, 02382, 02385, 02392, 02400, 02402, 02412, 02436, 02456, 02460, 02463, 02465, 02471, 02477, 02481, 02492, 02495, 02497, 02503, 02512, 02514, 02516, 02527, 02528, 02538, 02548, 02556, 02565, 02578, 02586, 02588, 02605, 02625, 02636, 02638, 02646, 02677, 02681, 02691, 02700, 02702, 02715, 02716, 02727, 02735, 02742, 02744, 02751, 02754, 02763, 02765, 02769, 02777, 02779, 02782, 02786, 02788, 02790, 02795, 02803, 02806, 02812, 02818, 02821, 02827, 02829, 02831, 02843, 02852, 02854, 02860, 02866, 02870, 02873, 02876, 02884, 02889, 02897, 02923, 02938, 02946, 02959, 02961, 03003, 03036, 03041, 03053, 03059, 03061, 03078, 03082, 03084, 03088, 03090, 03118, 03122, 03134, 03137, 03176, 03179, 03184, 03209, 03255, 03281, 03298, 03320, 03336, 03380, 03411, 03413, 03426, 03432, 03442, 03443, 03466, 03537, 03544, 03555, 03569, 03571, 03608, 03615, 03634,***

03651, 03657, 03675, 03683, 03702, 03720, 03735, 03742, 03744, 03746, 03754, 03763, 03774, 03788, 03794, 03799, 03808, 03810, 03824, 03838, 03844, 03845, 03854, 03888, 03942, 03998, 04004, 04040, 04048, 04056, 04069, 04076, 04080, 04087, 04125, 04129, 04132, 04313, 04327, 04380, 04385, 04418, 04425, 04427, 04437, 04444, 04451, 04624, 04635, 04640, 04667, 04693, 04705, 04717, 04744, 04759, 04764, 04778, 04781, 04785, 04787, 04837, 04859, 04875, 04910, 05018, 05130, 05294, 05383, 05424

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ON A/C 00578, 00612, 00621, 00629, 00646, 00654, 00713, 00727, 00734, 00767, 00794, 00833, 00885, 00890, 00896, 00904, 00922, 00929, 00946, 00949, 00972, 00997, 01016, 01018, 01019, 01029, 01033, 01038, 01040, 01046, 01048, 01051, 01055, 01069, 01073, 01077, 01084, 01086, 01089, 01095, 01097, 01102, 01107, 01109, 01122, 01124, 01135, 01136, 01147, 01155, 01160, 01170, 01172, 01182, 01184, 01203, 01205, 01209, 01245, 01252, 01254, 01263, 01265, 01269, 01275, 01277, 01283, 01285, 01287, 01289, 01297, 01301, 01303, 01309, 01311, 01313, 01315, 01317, 01319, 01326, 01328, 01331, 01336, 01340, 01342, 01348, 01352, 01354, 01358, 01360, 01364, 01369, 01371, 01377, 01378, 01382, 01388, 01389, 01391, 01393, 01429, 01494, 01515, 01562, 01577, 01579, 01592, 01598, 01601, 01603, 01612, 01618, 01625, 01630, 01634, 01668, 01673, 01706, 01718, 01722, 01740, 01742, 01745, 01750, 01756, 01765, 01770, 01778, 01779, 01781, 01786, 01791, 01805, 01808, 01846, 01853, 01866, 01872, 01882, 01884, 01886, 01901, 01916, 01925, 01936, 01963, 01980, 01997, 02012, 02019, 02033, 02057, 02066, 02074, 02078, 02083, 02086, 02101, 02113, 02122, 02124, 02126, 02127, 02131, 02174, 02186, 02198, 02209, 02224, 02262, 02265, 02266, 02271, 02319, 02378, 02387, 02398, 02406, 02416, 02420, 02427, 02442, 02446, 02448, 02450, 02483, 02494, 02518, 02547, 02593, 02607, 02611, 02617, 02624, 02628, 02629, 02632, 02644, 02652, 02662, 02709, 02729, 02733, 02746, 02762, 02773, 02774, 02811, 02836, 02849, 02857, 02878, 02879, 02905, 02907, 02913, 02925, 02935, 02954, 02985, 03019, 03024, 03028, 03043, 03054, 03094, 03096, 03102, 03108, 03139, 03169, 03171, 03181, 03188, 03202, 03204, 03245, 03271, 03285, 03288, 03300, 03305, 03309, 03324, 03331, 03344, 03346, 03347, 03364, 03377, 03385, 03388, 03403, 03406, 03407, 03415, 03417, 03436, 03445, 03447, 03452, 03533, 03551, 03560, 03564, 03586, 03589, 03604, 03620, 03660, 03661, 03684, 03686, 03687, 03689, 03700, 03704, 03727, 03728, 03733, 03790, 03818, 03822, 03834, 03853, 03865, 03872, 03874, 03892, 03895, 03905, 03918, 03950, 03970, 03983, 04020, 04029, 04038, 04052, 04071, 04089, 04121, 04127, 04141, 04164, 04182, 04258, 04268, 04275, 04332, 04455, 04511, 04663, 04691, 04713, 04734, 04756, 04796, 04841, 04871, 05005, 05085, 05097, 05239, 05284, 05293, 05366, 05400

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ON A/C 00598, 00600, 00618, 00625, 00637, 00644, 00647, 00660

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ON A/C 00546, 00572, 00609, 00610, 00616, 00623, 00627, 00634, 00636, 00639, 00641, 00649, 00651, 00656, 00670, 00672, 00679, 00682, 00688, 00689, 00691, 00693-00695, 00697, 00700, 00711, 00717, 00719, 00721, 00723, 00728, 00729, 00732, 00736, 00738, 00740, 00742, 00744, 00752, 00757, 00769, 00773, 00779, 00785, 00800, 00813, 00817, 00829, 00831, 00840, 00845, 00853, 00860, 00869, 00875, 00880, 01058, 01062, 01071, 01078, 01090, 01091, 01126, 01129, 01131, 01149, 01164, 01167, 01191, 01230, 01249, 01324, 01325, 01346, 01392, 01414, 01434, 01453, 01456, 01479, 01483, 01498, 01501, 01520, 01543, 01549, 01567, 01570, 01582, 01659, 01662, 01683, 01685, 01693, 01709, 01714, 01738, 01746, 01752, 01766, 01774, 01796, 01800, 01810, 01815, 01819, 01820, 01824, 01828, 01833, 01839, 01870, 01875, 01897, 01923, 01959, 01976, 01982, 01990, 02002, 02013, 02026, 02028, 02039, 02047, 02087, 02095, 02369, 02373, 02464, 02474, 02618, 02641

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ON A/C 01541, 01551, 02237, 02269, 02285, 02293, 02298, 02306, 02346, 02499, 02508, 02519, 02525, 02532, 02541, 02545, 02546, 02551, 02554, 02555, 02557, 02558, 02561, 02581, 02672, 02684, 02693, 02757, 02805, 02819, 02825, 02839, 02841, 02847, 02890, 03065, 03168, 03186, 03226, 03250, 03467, 03518, 03647, 03691, 03828, 03903, 04200,

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**(3) MSN by configuration**



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MSN	CONFIGURATION
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MSN	CONFIGURATION
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MSN	CONFIGURATION
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**CONF 002**

MSN	CONFIGURATION
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**CONF 003**

MSN	CONFIGURATION
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MSN	CONFIGURATION
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MSN	CONFIGURATION
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**CONF ALL**

**(4) Configuration definition**

**CONF 001**

**Configuration 001**

CONF 001 is applicable for all the aircraft on which MOD No. 155093P13407 and MOD No. 158520P15531 are not embodied.

CONF 001 retrofits following modifications: 160876P15989.

**CONF 002**

**Configuration 002**

CONF 002 is applicable for all the aircraft on which MOD No. 155093P13407 is embodied and on which MOD No. 158520P15531 is not embodied.

CONF 002 retrofits following modifications: 160876P15989.

**CONF 003**

**Configuration 003**

CONF 003 is applicable for all the aircraft on which MOD No. 155093P13407 is not embodied and on which MOD No. 158520P15531 is embodied.

CONF 003 retrofits following modifications: 160876P15989.



**CONF ALL****B. CONCURRENT REQUIREMENTS**

None

**C. REASON****(1) History**

Following the amount and severity of in-service findings and the high finding rate in the double joggle area, the need for an in-service action has been identified.

Definition of a new harmonised and unique inspection program for both Frame 16 and Frame 20 double joggle area taking into account the in-service findings.

**(2) Objective/Action**

The modification consists in redesigning the double joggle area at Frame 16 Left Hand (LH) side. It implies to apply cold working at Frame 16 LH side and install moderate interference fit fasteners.

The procedure as described in this Service Bulletin is to be performed if no AIRBUS repair and/or repair improvement has been previously performed in the same area. In case of repairs performed previously, please contact AIRBUS repair support department for further instructions.

Prior to Service Bulletin accomplishment, specific attention must be paid to the preparation, refer to paragraph 3.B Preparation.

**(3) Advantages**

The modification will contribute to avoid new in-service findings in the double joggle area.

Accomplishment of this Service Bulletin cancels the requirements of Service Bulletin No. Ref. SB A320-53-1373 for LH side.

**(4) Operational/Maintenance Consequences**

None

**D. DESCRIPTION**

To accomplish this Service Bulletin it is necessary to:

**(1) Modification**

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

**CONF 001**

- 1 Remove the Fasteners from the Frame 16 Double Joggle Area, on the LH Side

**CONF 002**

- 1 Remove the Fasteners from the Frame 16 Double Joggle Area, on the LH Side

**CONF 003**

- 1 Remove the Fasteners from the Frame 16 Double Joggle Area, on the LH Side

**CONF ALL**

- 2 Do a Rotating Probe Inspection of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side

**CONF 001**

- CONF 002**      3      Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side
- CONF 003**      3      Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side
- CONF 001**      3      Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side
- CONF 002**      4      Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side
- CONF 003**      4      Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side
- CONF 003**      4      Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side
- CONF ALL**

**E. COMPLIANCE**

**(1) Classification**

RECOMMENDED: Service Bulletin recommended to be accomplished to prevent significant operational disruptions.

**(2) Accomplishment Timescale**

Accomplishment of this Service Bulletin is recommended at the earliest opportunity where manpower and facilities are available.

**F. APPROVAL**

The technical content of this document is approved under the authority of Design Organisation Approval No. EASA.21J.031.

If an aircraft listed in the applicability has a modification or repair embodied that is not of AIRBUS origin, and which affects the content of this Service Bulletin, the operator is responsible for obtaining approval by its airworthiness authority for any adaptation necessary before incorporation of the Service Bulletin.

**G. MANPOWER**

**CONF 001**

The manpower estimates given in this Service Bulletin are based on the direct labor cost to do the work. These estimates assume that the work will be done by experienced personnel, and may need to be revised upwards to suit operator’s circumstances. The estimates do not include the time to prepare, plan or inspect the work. Manufacture and procurement of parts and tools, drying times for paints, sealants, etc., and general administration work are also not included.

**(1) Modification**

- (a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

PREPARATION		
Job Set-up	1.50 h	
PROCEDURE		
Remove the Fasteners from the Frame 16 Double Joggle Area, on the LH Side	4.00 h	

Do a Rotating Probe Inspection of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	1.00 h	
Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	4.00 h	
Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side	7.75 h	
<b>PREPARATION FOR TEST</b>		
None		
<b>TEST</b>		
Testing	0.10 h	
<b>CLOSE-UP</b>		
Close-up	4.00 h	
<b>TOTAL MAN-HOURS</b>	<b>22.35 h</b>	
<b>ELAPSED TIME (HOURS)</b>	<b>22.35 h</b>	

**NOTE:** If galleys or lavatories must be removed for access, additional man-hours can apply.

**CONF 002**

The manpower estimates given in this Service Bulletin are based on the direct labor cost to do the work. These estimates assume that the work will be done by experienced personnel, and may need to be revised upwards to suit operator’s circumstances. The estimates do not include the time to prepare, plan or inspect the work. Manufacture and procurement of parts and tools, drying times for paints, sealants, etc., and general administration work are also not included.

**(1) Modification**

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

<b>PREPARATION</b>		
Job Set-up	1.50 h	
<b>PROCEDURE</b>		
Remove the Fasteners from the Frame 16 Double Joggle Area, on the LH Side	4.00 h	
Do a Rotating Probe Inspection of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	1.00 h	
Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	4.00 h	
Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side	7.75 h	
<b>PREPARATION FOR TEST</b>		
None		
<b>TEST</b>		
Testing	0.10 h	
<b>CLOSE-UP</b>		
Close-up	4.00 h	
<b>TOTAL MAN-HOURS</b>	<b>22.35 h</b>	
<b>ELAPSED TIME (HOURS)</b>	<b>22.35 h</b>	

**NOTE:** If galleys or lavatories must be removed for access, additional man-hours can apply.

### CONF 003

The manpower estimates given in this Service Bulletin are based on the direct labor cost to do the work. These estimates assume that the work will be done by experienced personnel, and may need to be revised upwards to suit operator's circumstances. The estimates do not include the time to prepare, plan or inspect the work. Manufacture and procurement of parts and tools, drying times for paints, sealants, etc., and general administration work are also not included.

#### (1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

PREPARATION		
Job Set-up	1.50 h	
PROCEDURE		
Remove the Fasteners from the Frame 16 Double Joggle Area, on the LH Side	4.00 h	
Do a Rotating Probe Inspection of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	1.00 h	
Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	4.00 h	
Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side	7.75 h	
PREPARATION FOR TEST		
None		
TEST		
Testing	0.10 h	
CLOSE-UP		
Close-up	4.00 h	
TOTAL MAN-HOURS	22.35 h	
ELAPSED TIME (HOURS)	22.35 h	

**NOTE:** If galleys or lavatories must be removed for access, additional man-hours can apply.

### CONF ALL

#### H. WEIGHT AND BALANCE

Not changed

#### I. ELECTRICAL LOAD DATA

Not changed

#### J. REFERENCES

### CONF 001

#### (1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

<b>AIRCRAFT MAINTENANCE MANUAL (AMM)</b>	
06-20-00, Page Block 001	06-31-53, Page Block 001
Task 12-34-24-869-002	Task 20-21-11-911-001
Task 25-23-45-000-002	25-31-00
Task 25-23-45-400-006	
25-41-00	Task 25-80-00-000-001
	Task 25-80-00-400-001
Task 52-10-00-010-001	
Task 52-10-00-410-001	
<b>ELECTRICAL STANDARD PRACTICES MANUAL (ESPM)</b>	
20-55-00	
<b>IN SERVICE INFORMATION (ISI)</b>	
51.48.00001	
<b>NON DESTRUCTIVE TEST MANUAL (NTM)</b>	
Task 51-10-01-250-801	
<b>SERVICE BULLETIN (SB)</b>	
A320-53-1373	
<b>STRUCTURAL REPAIR MANUAL (SRM)</b>	
51-24-00	51-40-00
51-42-00	51-43-00
51-44-00	51-46-00
51-48-00	51-75-12
<b>TECHNICAL FOLLOW UP (TFU)</b>	
53.11.00.022	

STANDARDS MANUAL (SM)

CONSUMABLE MATERIAL LIST (CML)

**CONF 002**

**(1) Modification**

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

<b>AIRCRAFT MAINTENANCE MANUAL (AMM)</b>	
06-20-00, Page Block 001	06-31-53, Page Block 001
Task 12-34-24-869-002	Task 20-21-11-911-001
Task 25-23-45-000-002	25-31-00
Task 25-23-45-400-006	
25-41-00	Task 25-80-00-000-001
	Task 25-80-00-400-001

<b>AIRCRAFT MAINTENANCE MANUAL (AMM)</b>	
Task 52-10-00-010-001	
Task 52-10-00-410-001	
<b>ELECTRICAL STANDARD PRACTICES MANUAL (ESPM)</b>	
20-55-00	
<b>IN SERVICE INFORMATION (ISI)</b>	
51.48.00001	
<b>NON DESTRUCTIVE TEST MANUAL (NTM)</b>	
Task 51-10-01-250-801	
<b>SERVICE BULLETIN (SB)</b>	
A320-53-1373	
<b>STRUCTURAL REPAIR MANUAL (SRM)</b>	
51-24-00	51-40-00
51-42-00	51-43-00
51-44-00	51-46-00
51-48-00	51-75-12
<b>TECHNICAL FOLLOW UP (TFU)</b>	
53.11.00.022	

STANDARDS MANUAL (SM)  
CONSUMABLE MATERIAL LIST (CML)

**CONF 003**

**(1) Modification**

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

<b>AIRCRAFT MAINTENANCE MANUAL (AMM)</b>	
06-20-00, Page Block 001	06-31-53, Page Block 001
Task 12-34-24-869-002	Task 20-21-11-911-001
Task 25-23-45-000-002	25-31-00
Task 25-23-45-400-006	
25-41-00	Task 25-80-00-000-001
	Task 25-80-00-400-001
Task 52-10-00-010-001	
Task 52-10-00-410-001	
<b>ELECTRICAL STANDARD PRACTICES MANUAL (ESPM)</b>	
20-55-00	
<b>IN SERVICE INFORMATION (ISI)</b>	
51.48.00001	

<b>NON DESTRUCTIVE TEST MANUAL (NTM)</b>	
Task 51-10-01-250-801	
<b>SERVICE BULLETIN (SB)</b>	
A320-53-1373	
<b>STRUCTURAL REPAIR MANUAL (SRM)</b>	
51-24-00	51-40-00
51-42-00	51-43-00
51-44-00	51-46-00
51-48-00	51-75-12
<b>TECHNICAL FOLLOW UP (TFU)</b>	
53.11.00.022	

STANDARDS MANUAL (SM)

CONSUMABLE MATERIAL LIST (CML)

**CONF ALL****K. PUBLICATION AFFECTED**

STRUCTURAL REPAIR MANUAL (SRM)

**L. INDUSTRY SUPPORT INFORMATION**

AIRBUS will not provide industry support for accomplishment of this Service Bulletin.



### 2. MATERIAL INFORMATION

#### A. MATERIAL APPLICABILITY

##### CONF 001

#### Material for task set A320-A-53-XX-1381-01000-93AA-A Modification

MATERIAL	QTY	SEE NOTES
Aircraft standard tools	See SB	
Referenced tools	See SB	
Consumables	See SB	
Part kit 531381A01R01	1	
Referenced parts	See SB	

##### CONF 002

#### Material for task set A320-A-53-XX-1381-01000-93AA-A Modification

MATERIAL	QTY	SEE NOTES
Aircraft standard tools	See SB	
Referenced tools	See SB	
Consumables	See SB	
Part kit 531381A02R01	1	
Referenced parts	See SB	

##### CONF 003

#### Material for task set A320-A-53-XX-1381-01000-93AA-A Modification

MATERIAL	QTY	SEE NOTES
Aircraft standard tools	See SB	
Referenced tools	See SB	
Consumables	See SB	
Part kit 531381A03R01	1	
Referenced parts	See SB	

##### CONF ALL

#### B. TOOLING

##### CONF 001

#### Aircraft standard tools for task set A320-A-53-XX-1381-01000-93AA-A Modification

Procurement address	51439	Fatigue Technology Inc. 401 Andover Park East SEATTLE, WA 98188-7605 USA Phone: (206) 2462010 Fax: (206) 2449886 Internet: <a href="http://www.fatiguetech.com">http://www.fatiguetech.com</a>
	66136	West Coast Industries Inc. 14900 Whitman Ave. N Seattle, Washington 98133 Phone: (206) 365-7513 Fax: (206) 365-7483 E-mail: <a href="mailto:info@coldwork.com">info@coldwork.com</a>

NOTE(S)
Operators interested in obtaining the Fatigue Technology Incorporated (FTI) tool kit part numbers listed below should contact FTI at the address given above.
WCI contact for Europe, Middle-East, Africa, India and Russia: Phone: +33 5 61 92 04 91 (France) E-mail: customer@capaero.com
Operators interested in obtaining the West Coast Industries (WCI) tool kit part numbers listed below should contact WCI at the address given above.

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
	DKA3205313811 (51439) (66136)	2	TOOLKIT		(1) (2) (3) (4) (5)
	EKA3205313811 (51439) (66136)	2	TOOLKIT		(1) (2) (3) (4) (6)
	FTIA3205313811 (51439)	1	TOOLKIT		(1) (3) (7)
	WCIA3205313811 (66136)	1	TOOLKIT		(2) (4) (8)

NOTE(S)
(1): Procurement to be negotiated directly with Fatigue Technology Incorporated.
(2): Procurement to be negotiated directly with West Coast Industries.
(3): Fatigue Technology Incorporated (FTI) has allocated this tool kit part number for cold expansion: For the tooling definition, refer to Ref. ISI 51.48.00001.
(4): West Coast Industries (WCI) has allocated this tool kit part numbers for cold expansion: For the tooling definition, refer to Ref. ISI 51.48.00001.
(5): Durable tooling. Ref. DK-A320-53-1381-1 The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to Ref. ISI 51.48.00001.
(6): Expendable tooling. Ref. EK-A320-53-1381-1 The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.
(7): Capital tooling. Ref. FTI-A320-53-1381-1 The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from Fatigue Technology Incorporated (FTI).
(8): Capital tooling. Ref. WCI-A320-53-1381-1 The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from West Coast Industries (WCI).

**CONF 002**

**Aircraft standard tools for task set A320-A-53-XX-1381-01000-93AA-A  
Modification**

Procurement address	51439	Fatigue Technology Inc. 401 Andover Park East SEATTLE, WA 98188-7605 USA Phone: (206) 2462010 Fax: (206) 2449886 Internet: <a href="http://www.fatiguetech.com">http://www.fatiguetech.com</a>
	66136	West Coast Industries Inc. 14900 Whitman Ave. N Seattle, Washington 98133 Phone: (206) 365-7513 Fax: (206) 365-7483 E-mail: <a href="mailto:info@coldwork.com">info@coldwork.com</a>

**NOTE(S)**

Operators interested in obtaining the Fatigue Technology Incorporated (FTI) tool kit part numbers listed below should contact FTI at the address given above.

WCI contact for Europe, Middle-East, Africa, India and Russia:  
Phone: +33 5 61 92 04 91 (France)  
E-mail: [customer@capaero.com](mailto:customer@capaero.com)

Operators interested in obtaining the West Coast Industries (WCI) tool kit part numbers listed below should contact WCI at the address given above.

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
	DKA3205313811 (51439) (66136)	2	TOOLKIT		(1) (2) (3) (4) (5)
	EKA3205313811 (51439) (66136)	2	TOOLKIT		(1) (2) (3) (4) (6)
	FTIA3205313811 (51439)	1	TOOLKIT		(1) (3) (7)
	WCIA3205313811 (66136)	1	TOOLKIT		(2) (4) (8)

**NOTE(S)**

(1): Procurement to be negotiated directly with Fatigue Technology Incorporated.

(2): Procurement to be negotiated directly with West Coast Industries.

(3): Fatigue Technology Incorporated (FTI) has allocated this tool kit part number for cold expansion:  
For the tooling definition, refer to Ref. ISI 51.48.00001.

(4): West Coast Industries (WCI) has allocated this tool kit part numbers for cold expansion:  
For the tooling definition, refer to Ref. ISI 51.48.00001.

(5): Durable tooling. Ref. DK-A320-53-1381-1  
The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to Ref. ISI 51.48.00001.

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
(6):	Expendable tooling. Ref. EK-A320-53-1381-1 The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.				
(7):	Capital tooling. Ref. FTI-A320-53-1381-1 The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from Fatigue Technology Incorporated (FTI).				
(8):	Capital tooling. Ref. WCI-A320-53-1381-1 The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from West Coast Industries (WCI).				

**CONF 003**

**Aircraft standard tools for task set A320-A-53-XX-1381-01000-93AA-A Modification**

Procurement address	51439	Fatigue Technology Inc. 401 Andover Park East SEATTLE, WA 98188-7605 USA Phone: (206) 2462010 Fax: (206) 2449886 Internet: <a href="http://www.fatiguetech.com">http://www.fatiguetech.com</a>
	66136	West Coast Industries Inc. 14900 Whitman Ave. N Seattle, Washington 98133 Phone: (206) 365-7513 Fax: (206) 365-7483 E-mail: <a href="mailto:info@coldwork.com">info@coldwork.com</a>

**NOTE(S)**

Operators interested in obtaining the Fatigue Technology Incorporated (FTI) tool kit part numbers listed below should contact FTI at the address given above.
WCI contact for Europe, Middle-East, Africa, India and Russia: Phone: +33 5 61 92 04 91 (France) E-mail: <a href="mailto:customer@capaero.com">customer@capaero.com</a>
Operators interested in obtaining the West Coast Industries (WCI) tool kit part numbers listed below should contact WCI at the address given above.

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
	DKA3205313811 (51439) (66136)	2	TOOLKIT		(1) (2) (3) (4) (5)
	EKA3205313811 (51439) (66136)	2	TOOLKIT		(1) (2) (3) (4) (6)
	FTIA3205313811 (51439)	1	TOOLKIT		(1) (3) (7)

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
	WCIA3205313811 (66136)	1	TOOLKIT		(2) (4) (8)
<b>NOTE(S)</b>					
(1): Procurement to be negotiated directly with Fatigue Technology Incorporated.					
(2): Procurement to be negotiated directly with West Coast Industries.					
(3): Fatigue Technology Incorporated (FTI) has allocated this tool kit part number for cold expansion: For the tooling definition, refer to Ref. ISI 51.48.00001.					
(4): West Coast Industries (WCI) has allocated this tool kit part numbers for cold expansion: For the tooling definition, refer to Ref. ISI 51.48.00001.					
(5): Durable tooling. Ref. DK-A320-53-1381-1  The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to Ref. ISI 51.48.00001.					
(6): Expendable tooling. Ref. EK-A320-53-1381-1  The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.					
(7): Capital tooling. Ref. FTI-A320-53-1381-1  The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from Fatigue Technology Incorporated (FTI).					
(8): Capital tooling. Ref. WCI-A320-53-1381-1  The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from West Coast Industries (WCI).					

**CONF 001**

**Referenced tools for task set A320-A-53-XX-1381-01000-93AA-A Modification**

NOTE: To accomplish this Service Bulletin it is necessary to use the tools listed in the subsequent referenced task:

Ref. AMM Task 52-10-00-010-001

Ref. NTM Task 51-10-01-250-801

**CONF 002**

**Referenced tools for task set A320-A-53-XX-1381-01000-93AA-A Modification**

NOTE: To accomplish this Service Bulletin it is necessary to use the tools listed in the subsequent referenced task:

Ref. AMM Task 52-10-00-010-001

Ref. NTM Task 51-10-01-250-801

**CONF 003**

**Referenced tools for task set A320-A-53-XX-1381-01000-93AA-A Modification**

NOTE: To accomplish this Service Bulletin it is necessary to use the tools listed in the subsequent referenced task:

Ref. AMM Task 52-10-00-010-001

Ref. NTM Task 51-10-01-250-801

**CONF ALL**

**C. CONSUMABLES**

**CONF 001**

**Consumables for task set A320-A-53-XX-1381-01000-93AA-A Modification**

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JAA3	Top Coat Polyurethane - - - External Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06AAB1	Polysulfide Sealant - General Purpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ABD1	Corrosion Preventive Compound - Water Displacing Ultra-thin Film		
	14SBA1	Textile - Lint free Cotton		

**CONF 002**

**Consumables for task set A320-A-53-XX-1381-01000-93AA-A Modification**

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JAA3	Top Coat Polyurethane - - - External Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06AAB1	Polysulfide Sealant - General Purpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ABD1	Corrosion Preventive Compound - Water Displacing Ultra-thin Film		
	14SBA1	Textile - Lint free Cotton		

**CONF 003**

**Consumables for task set A320-A-53-XX-1381-01000-93AA-A Modification**

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JAA3	Top Coat Polyurethane - - - External Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06AAB1	Polysulfide Sealant - General Purpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ABD1	Corrosion Preventive Compound - Water Displacing Ultra-thin Film		
	14SBA1	Textile - Lint free Cotton		

**CONF ALL**

**D. LIST OF NEW PARTS**

**CONF 001**

**Part kit 531381A01R01**

Cost	420.00 USD	
Availability	320 d (calendar days from receipt of order)	
NOTE(S)		
<p>The sales terms (costs and availability) are estimated in relation to economic conditions. The latest valid price and lead time for ordering purposes shall be obtained through the AIRBUS Spares portal or through a request for quotation to <a href="mailto:airbus.kit@airbus.com">airbus.kit@airbus.com</a>.</p> <p>The availability given above is the standard lead time from the date of your purchase order. If items are required before this time, please include a retrofit planning schedule with your order so that we can try to comply with your requirements.</p>		
Procurement address	D4296	<p>AIRBUS Material, Logistics and Suppliers ATP II B, Hein-Sass-Weg 24 21129 HAMBURG GERMANY Phone: +49 40 743 51660 E-mail: <a href="mailto:airbus.kit@airbus.com">airbus.kit@airbus.com</a> Internet: <a href="http://spares.airbus.com">http://spares.airbus.com</a></p>
NOTE(S)		
<p>Customers with aircraft shown in the applicability of this Service Bulletin should send a purchase order to AIRBUS at the address given above and quote the number of this Service Bulletin.</p>		



ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	EN6114K4Y13	2	BOLT		
2	ASNA2531-4	12	NUT		
3	EN6114K4Y11	6	BOLT		
4	EN6114K3A8	4	BOLT		
5	ASNA2531-3A	4	NUT		
6	EN6114K5Y14	2	BOLT		
7	ASNA2531-5	7	NUT		
8	EN6114K5Y12	5	BOLT		
9	EN6114K4Y10	4	BOLT		

**NOTE(S)**

Refer to the AIRBUS Ref. SM if you find part numbers of hardware components which you cannot identify. The SM will give you the correct part number to part number relationship.

**CONF 002**

**Part kit 531381A02R01**

Cost	420.00 USD
Availability	320 d (calendar days from receipt of order)

**NOTE(S)**

The sales terms (costs and availability) are estimated in relation to economic conditions. The latest valid price and lead time for ordering purposes shall be obtained through the AIRBUS Spares portal or through a request for quotation to [airbus.kit@airbus.com](mailto:airbus.kit@airbus.com).

The availability given above is the standard lead time from the date of your purchase order. If items are required before this time, please include a retrofit planning schedule with your order so that we can try to comply with your requirements.

Procurement address	D4296	AIRBUS Material, Logistics and Suppliers ATP II B, Hein-Sass-Weg 24 21129 HAMBURG GERMANY Phone: +49 40 743 51660 E-mail: <a href="mailto:airbus.kit@airbus.com">airbus.kit@airbus.com</a> Internet: <a href="http://spares.airbus.com">http://spares.airbus.com</a>
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**NOTE(S)**

Customers with aircraft shown in the applicability of this Service Bulletin should send a purchase order to AIRBUS at the address given above and quote the number of this Service Bulletin.

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	EN6114K4Y13	2	BOLT		
2	ASNA2531-4	12	NUT		
3	EN6114K4Y11	6	BOLT		
4	EN6114K3A8	4	BOLT		
5	ASNA2531-3A	4	NUT		
6	EN6114K5Y14	2	BOLT		

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
7	ASNA2531-5	7	NUT		
8	EN6114K5Y12	5	BOLT		
9	EN6114K4Y10	1	BOLT		
12	EN6114K4Y9	3	BOLT		
NOTE(S)					
Refer to the AIRBUS Ref. SM if you find part numbers of hardware components which you cannot identify. The SM will give you the correct part number to part number relationship.					

**CONF 003**

**Part kit 531381A03R01**

Cost	420.00 USD	
Availability	320 d (calendar days from receipt of order)	
NOTE(S)		
<p>The sales terms (costs and availability) are estimated in relation to economic conditions. The latest valid price and lead time for ordering purposes shall be obtained through the AIRBUS Spares portal or through a request for quotation to <a href="mailto:airbus.kit@airbus.com">airbus.kit@airbus.com</a>.</p> <p>The availability given above is the standard lead time from the date of your purchase order. If items are required before this time, please include a retrofit planning schedule with your order so that we can try to comply with your requirements.</p>		
Procurement address	D4296	<p>AIRBUS Material, Logistics and Suppliers ATP II B, Hein-Sass-Weg 24 21129 HAMBURG GERMANY Phone: +49 40 743 51660 E-mail: <a href="mailto:airbus.kit@airbus.com">airbus.kit@airbus.com</a> Internet: <a href="http://spares.airbus.com">http://spares.airbus.com</a></p>
NOTE(S)		
Customers with aircraft shown in the applicability of this Service Bulletin should send a purchase order to AIRBUS at the address given above and quote the number of this Service Bulletin.		

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	EN6114K4Y13	2	BOLT		
2	ASNA2531-4	12	NUT		
3	EN6114K4Y11	6	BOLT		
4	EN6114K3A8	4	BOLT		
5	ASNA2531-3A	4	NUT		
6	EN6114K5Y14	2	BOLT		
7	ASNA2531-5	7	NUT		
8	EN6114K5Y12	5	BOLT		

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
12	EN6114K4Y9	4	BOLT		
NOTE(S)					
Refer to the AIRBUS Ref. SM if you find part numbers of hardware components which you cannot identify. The SM will give you the correct part number to part number relationship.					

**CONF 001**

**Referenced parts for task set A320-A-53-XX-1381-01000-93AA-A Modification**

NOTE: To accomplish this Service Bulletin it is necessary to use the expendable parts listed in the subsequent referenced tasks:

Ref. AMM 25-31-00

Ref. AMM 25-41-00

NOTE: The expendable parts mentioned above are only necessary if galleys or closets/stowages or lavatories are removed/installed for access, refer to paragraph "Component Location" in the applicable ATA 25 "Description/Operation": for the galleys, closets/stowages, refer to AMM 25-31-00; for the lavatories, refer to AMM 25-41-00. In this paragraph, you will find the cross references of the removal/installation task.

**CONF 002**

**Referenced parts for task set A320-A-53-XX-1381-01000-93AA-A Modification**

NOTE: To accomplish this Service Bulletin it is necessary to use the expendable parts listed in the subsequent referenced tasks:

Ref. AMM 25-31-00

Ref. AMM 25-41-00

NOTE: The expendable parts mentioned above are only necessary if galleys or closets/stowages or lavatories are removed/installed for access, refer to paragraph "Component Location" in the applicable ATA 25 "Description/Operation": for the galleys, closets/stowages, refer to AMM 25-31-00; for the lavatories, refer to AMM 25-41-00. In this paragraph, you will find the cross references of the removal/installation task.

**CONF 003**

**Referenced parts for task set A320-A-53-XX-1381-01000-93AA-A Modification**

NOTE: To accomplish this Service Bulletin it is necessary to use the expendable parts listed in the subsequent referenced tasks:

Ref. AMM 25-31-00

Ref. AMM 25-41-00

NOTE: The expendable parts mentioned above are only necessary if galleys or closets/stowages or lavatories are removed/installed for access, refer to paragraph "Component Location" in the applicable ATA 25 "Description/Operation": for the galleys, closets/stowages, refer to AMM 25-31-00; for the lavatories, refer to AMM 25-41-00. In this paragraph, you will find the cross references of the removal/installation task.

**CONF ALL**

**E. LIST OF EXISTING PARTS**

No parts

**3. ACCOMPLISHMENT INSTRUCTIONS**  
**Task set A320-A-53-XX-1381-01000-93AA-A**  
Modification

**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 Ref. ESPM 20-55-00.**

**NOTE:** The accomplishment instructions of this Service Bulletin include procedures given in other documents or in other sections of the Service Bulletin. When the words “refer to” are used and the operator has a procedure accepted by the local authority he belongs to, the accepted alternative procedure can be used. When the words “in accordance with” are used then the given procedure must be followed.

**NOTE:** The access and close-up instructions, not comprising return to service tests, in this Service Bulletin do not constitute or affect the technical intent of the Service Bulletin. Operators can therefore, as deemed necessary, omit or add access and/or close-up steps to add flexibility to their maintenance operations as long as the technical intent of the Service Bulletin is met within the set parameters.

**NOTE:** Manual titles given in the accomplishment instructions are referred to by acronyms. Refer to paragraph 1.J., References, for the definition of acronyms.

**NOTE:** This Service Bulletin contains the instructions for the on-aircraft maintenance necessary to ensure the continued airworthiness of the aircraft. For any deviations to the instructions, contact AIRBUS for further instructions and approval.

**NOTE:** Discarded parts must be managed at the operator's discretion.

**A. TASK SET ASSOCIATED INFORMATION**

**Task Manpower**

<b>CONF 001</b>	TOTAL MAN-HOURS	22.35 h
<b>CONF 002</b>	TOTAL MAN-HOURS	22.35 h
<b>CONF 003</b>	TOTAL MAN-HOURS	22.35 h
<b>CONF 001</b>	ELAPSED TIME (HOURS)	22.35 h
<b>CONF 002</b>	ELAPSED TIME (HOURS)	22.35 h
<b>CONF 003</b>	ELAPSED TIME (HOURS)	22.35 h

**CONF ALL**

**B. PREPARATION**

**(1) Task A320-A-53-XX-1381-01001-540A-A - Job Set-up**

**Job Set-Up Information**

**Manpower/Resources/Skills**

<b>Man-hours</b>	1.50 h
<b>Minimum Number of person</b>	1
<b>Elapsed Time</b>	1.50 h

**Referenced Information**

<b>Manuals/Drawings</b>	<b>References/Sheets</b>
AMM	Task 12-34-24-869-002 Task 25-23-45-000-002 25-31-00 25-41-00 Task 25-80-00-000-001 Task 52-10-00-010-001

**Procedure**

**NOTE:** For the basic Aircraft configuration, refer to AMM Chapter "Introduction - Aircraft status for maintenance" in Manual Front Matter section.

**NOTE:** This Service Bulletin is based on the aircraft configuration as known by AIRBUS (first aircraft delivery configuration and modified by the reported incorporation of AIRBUS Service Bulletins).  
Prior to Service Bulletin accomplishment, specific attention must be paid to structural damage which may exist and to repairs which were performed on the area defined, refer to Ref. Fig. General Overview, because they may be affected by the Service Bulletin. If any repairs were performed and prevent accomplishment of this Service Bulletin, contact AIRBUS Customer Services Repair Engineering Support department for instructions on how to proceed. AIRBUS disclaims any liability for the effect which the Service Bulletin may have on repairs performed on the aircraft before accomplishment of the Service Bulletin.  
If the post Service Bulletin repair status is not covered by the SRM and for repairs outside of the SRM covered by an RDAS issued by AIRBUS, AIRBUS Customer Services Repair, Engineering Support department should be contacted. Repair review will be done by AIRBUS at conditions of the Customer Services Catalogue.

- (a) Make sure that the aircraft is electrically grounded, refer to Ref. AMM Task 12-34-24-869-002.
- (b) Put an access platform in position at Door 831.
- (c) Open the passenger/crew Door 831, refer to Ref. AMM Task 52-10-00-010-001.
- (d) If installed, remove or displace the Forward (FWD) galleys and lavatories between Frame 15 and Frame 16. To do this, refer to the paragraph 'Component Location' in the applicable Air Transport Association (ATA) 25 'Description/ Operation': for the galleys, refer to Ref. AMM 25-31-00; for the lavatories, refer to Ref. AMM 25-41-00. In this paragraph you will find the cross-references of the removal task.

- (e) Remove the necessary lining panels at Frame 16 to get access to the modification areas, refer to Ref. AMM Task 25-23-45-000-002.
- (f) Remove the necessary insulation blankets at Frame 16 to get access to the modification areas, refer to Ref. AMM Task 25-80-00-000-001.
- (g) Remove or displace the necessary electrical wire harnesses at Frame 16 without unplugging the connections.

**C. PROCEDURE**

**CONF 001**

**(1) Task A320-A-53-XX-1381-01001-520A-A - Remove the Fasteners from the Frame 16 Double Joggle Area, on the LH Side**

**Job Set-Up Information**

**Working Area**

Impacted Zone	Access / Work Location	
220	Access	Door 831
	Work location	Frame 16

**Manpower/Resources/Skills**

<b>Man-hours</b>	4.00 h
<b>Minimum Number of person</b>	1
<b>Elapsed Time</b>	4.00 h
<b>Skills</b>	Airframe

**Material necessary to do the job**

Consumables				
ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

**Referenced Information**

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00

**Procedure**

- (a) Standard practices given in this procedure:
  - 1 For the Frame (FR) identification, refer to Ref. AMM 06-31-53, Page Block 001.
  - 2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.
  - 3 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.
  - 4 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

(b) Remove the fasteners from the Frame 16 double joggle area:  
Refer to Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side

2	Bolt	Item (1)	Discard
6	Bolt	Item (3)	Discard
4	Bolt	Item (4)	Discard
2	Bolt	Item (6)	Discard
5	Bolt	Item (8)	Discard
4	Bolt	Item (9)	Discard
12	Nut	Item (2)	Discard
7	Nut	Item (7)	Discard
4	Nut	Item (5)	Discard

(c) Remove the old sealant with a non metallic spatula.

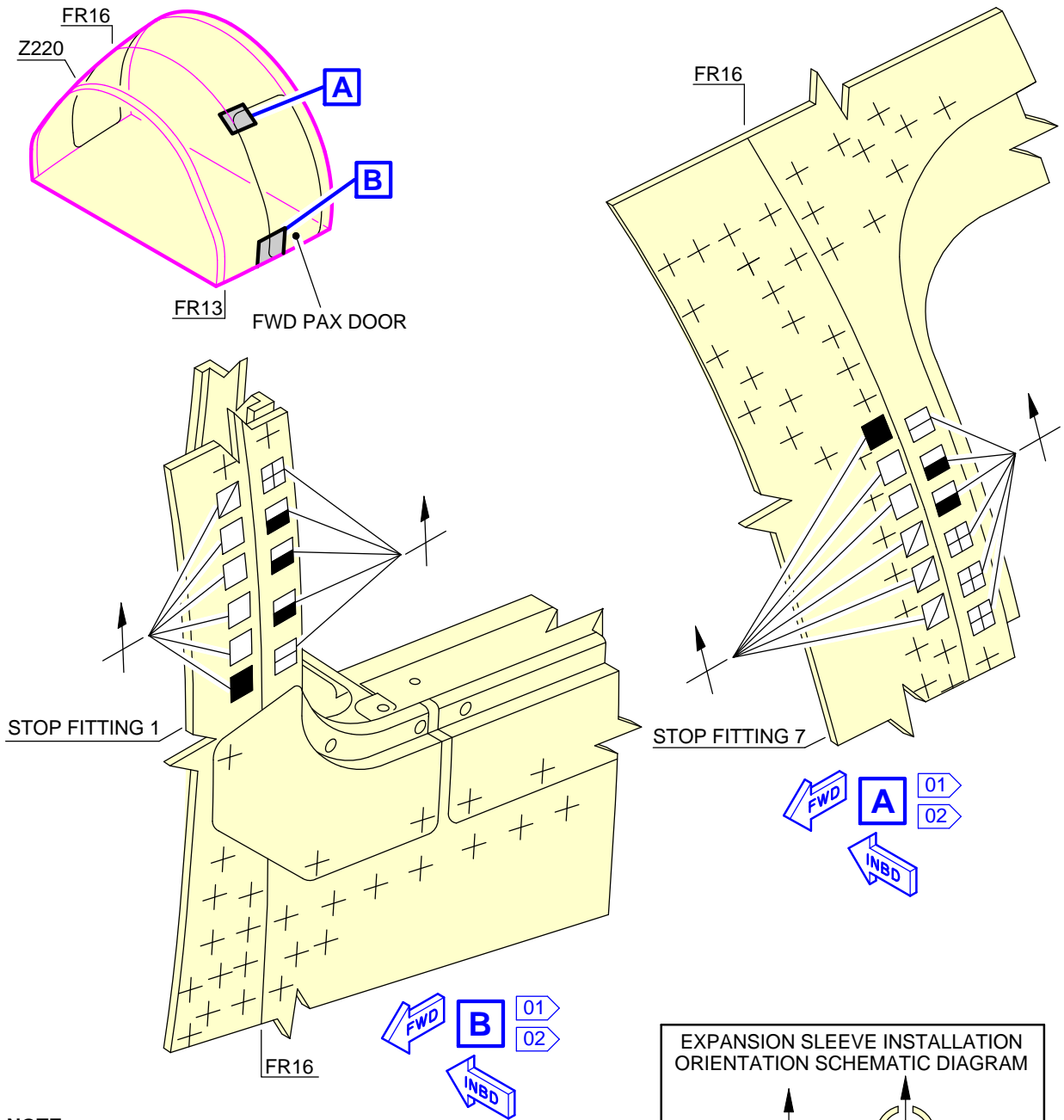
(d) Clean the holes and area with:

Textile - Lint free Cotton 14SBA1  
and

Non Aqueous Cleaner - 08BAA9  
General



**CONF 001**



**NOTE:**  
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS.

+ FASTENERS NOT AFFECTED.

- 01** APPLY A NEW INTERNAL PROTECTIVE FINISH WITH MATERIAL No 04EAC2 AND MATERIAL No 04JME4. ON THE TOP OF THE INTERNAL PROTECTIVE FINISH, APPLY MATERIAL No 12ABD1.
- 02** APPLY A NEW EXTERNAL PROTECTIVE FINISH WITH MATERIAL No 04CMA2, MATERIAL No 04EAC2 AND MATERIAL No 04JAA3.

ICN-A320-A-53XX1381-A-FAPE3-00A32-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A32-A-001-01 SHEET 1/2

CONF 001

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE/FIT TYPE	NOTE
						MIN	MAX	MIN	MAX		
■ <sub>N</sub>	(1)	1	EN6114K4Y13	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
□ <sub>N</sub>	(3)	3	EN6114K4Y11	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
▧ <sub>N</sub>	(4)	4	EN6114K3A8	BOLT	6-1-N	4.920 mm (0.1937 in)	4.960 mm (0.1952 in)	5.467 mm (0.2153 in)	5.507 mm (0.2168 in)	NOMINAL SIZE INTERFERENCE FIT	03
	(5)	5	ASNA2531-3A	NUT							
▩ <sub>N</sub>	(6)	6	EN6114K5Y14	BOLT	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(7)	7	ASNA2531-5	NUT							
■ <sub>N</sub>	(8)	8	EN6114K5Y12	BOLT	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(7)	7	ASNA2531-5	NUT							
▩ <sub>N</sub>	(9)	9	EN6114K4Y10	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							

NOTE:

▩<sub>N</sub> HEAD ON NEAR SIDE.

03 WET-INSTALL THE FASTENERS WITH MATERIAL No 06AAB1.

ICN-A320-A-53XX1381-A-FAPE3-00A33-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A33-A-001-01 SHEET 2/2

Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side

**CONF 002**

**(1) Task A320-A-53-XX-1381-01002-520A-A - Remove the Fasteners from the Frame 16 Double Joggle Area, on the LH Side**

**Job Set-Up Information**

**Working Area**

Impacted Zone	Access / Work Location	
220	Access	Door 831
	Work location	Frame 16

**Manpower/Resources/Skills**

<b>Man-hours</b>	4.00 h
<b>Minimum Number of person</b>	1
<b>Elapsed Time</b>	4.00 h
<b>Skills</b>	Airframe

**Material necessary to do the job**

Consumables				
ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

**Referenced Information**

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00

**Procedure**

- (a) Standard practices given in this procedure:
- 1 For the FR identification, refer to Ref. AMM 06-31-53, Page Block 001.
  - 2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.
  - 3 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.
  - 4 Remove and install fasteners in accordance with Ref. SRM 51-42-00.
- (b) Remove the fasteners from the Frame 16 double joggle area:  
Refer to Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side

2	Bolt	Item (1)	Discard
6	Bolt	Item (3)	Discard
4	Bolt	Item (4)	Discard
2	Bolt	Item (6)	Discard
5	Bolt	Item (8)	Discard

1	Bolt	Item (9)	Discard
3	Bolt	Item (12)	Discard
12	Nut	Item (2)	Discard
4	Nut	Item (5)	Discard
7	Nut	Item (7)	Discard

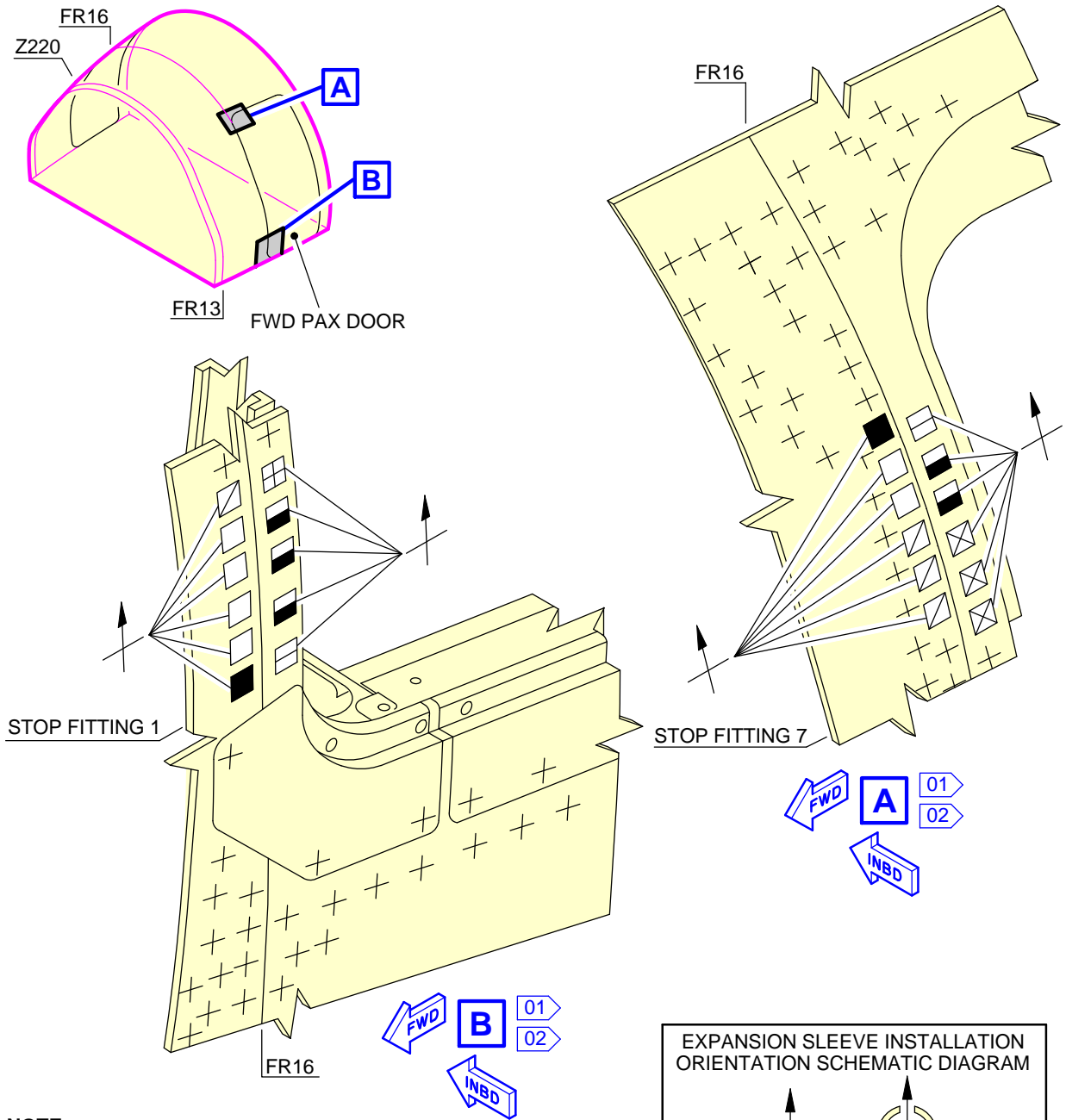
(c) Remove the old sealant with a non metallic spatula.

(d) Clean the holes and area with:

Textile - Lint free Cotton 14SBA1  
and

Non Aqueous Cleaner - 08BAA9  
General

**CONF 002**



**NOTE:**  
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS.

+ FASTENERS NOT AFFECTED.

**01** APPLY A NEW INTERNAL PROTECTIVE FINISH WITH MATERIAL No 04EAC2 AND MATERIAL No 04JME4. ON THE TOP OF THE INTERNAL PROTECTIVE FINISH, APPLY MATERIAL No 12ABD1.

**02** APPLY A NEW EXTERNAL PROTECTIVE FINISH WITH MATERIAL No 04CMA2, MATERIAL No 04EAC2 AND MATERIAL No 04JAA3.

ICN-A320-A-53XX1381-A-FAPE3-00A34-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A34-A-001-01 SHEET 1/2

CONF 002

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE/FIT TYPE	NOTE
						MIN	MAX	MIN	MAX		
■ N	(1)	1	EN6114K4Y13	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
□ N	(3)	3	EN6114K4Y11	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
▧ N	(4)	4	EN6114K3A8	BOLT	6-1-N	4.920 mm (0.1937 in)	4.960 mm (0.1952 in)	5.467 mm (0.2153 in)	5.507 mm (0.2168 in)	NOMINAL SIZE INTERFERENCE FIT	03
	(5)	5	ASNA2531-3A	NUT							
▩ N	(6)	6	EN6114K5Y14	BOLT	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(7)	7	ASNA2531-5	NUT							
■ N	(8)	8	EN6114K5Y12	BOLT	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(7)	7	ASNA2531-5	NUT							
▩ N	(9)	9	EN6114K4Y10	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
⊠ N	(12)	12	EN6114K4Y9	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							

NOTE:

⊠ HEAD ON NEAR SIDE.

03 WET-INSTALL THE FASTENERS WITH MATERIAL No 06AAB1.

ICN-A320-A-53XX1381-A-FAPE3-00A35-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A35-A-001-01 SHEET 2/2

**CONF 003**

**(1) Task A320-A-53-XX-1381-01003-520A-A - Remove the Fasteners from the Frame 16 Double Joggle Area, on the LH Side**

**Job Set-Up Information**

**Working Area**

Impacted Zone	Access / Work Location	
220	Access	Door 831
	Work location	Frame 16

**Manpower/Resources/Skills**

<b>Man-hours</b>	4.00 h
<b>Minimum Number of person</b>	1
<b>Elapsed Time</b>	4.00 h
<b>Skills</b>	Airframe

**Material necessary to do the job**

Consumables				
ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

**Referenced Information**

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00

**Procedure**

- (a) Standard practices given in this procedure:
  - 1 For the FR identification, refer to Ref. AMM 06-31-53, Page Block 001.
  - 2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.
  - 3 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.
  - 4 Remove and install fasteners in accordance with Ref. SRM 51-42-00.
- (b) Remove the fasteners from the Frame 16 double joggle area:  
Refer to Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side

2	Bolt	Item (1)	Discard
6	Bolt	Item (3)	Discard
4	Bolt	Item (4)	Discard
2	Bolt	Item (6)	Discard
5	Bolt	Item (8)	Discard



4	Bolt	Item (12)	Discard
12	Nut	Item (2)	Discard
4	Nut	Item (5)	Discard
7	Nut	Item (7)	Discard

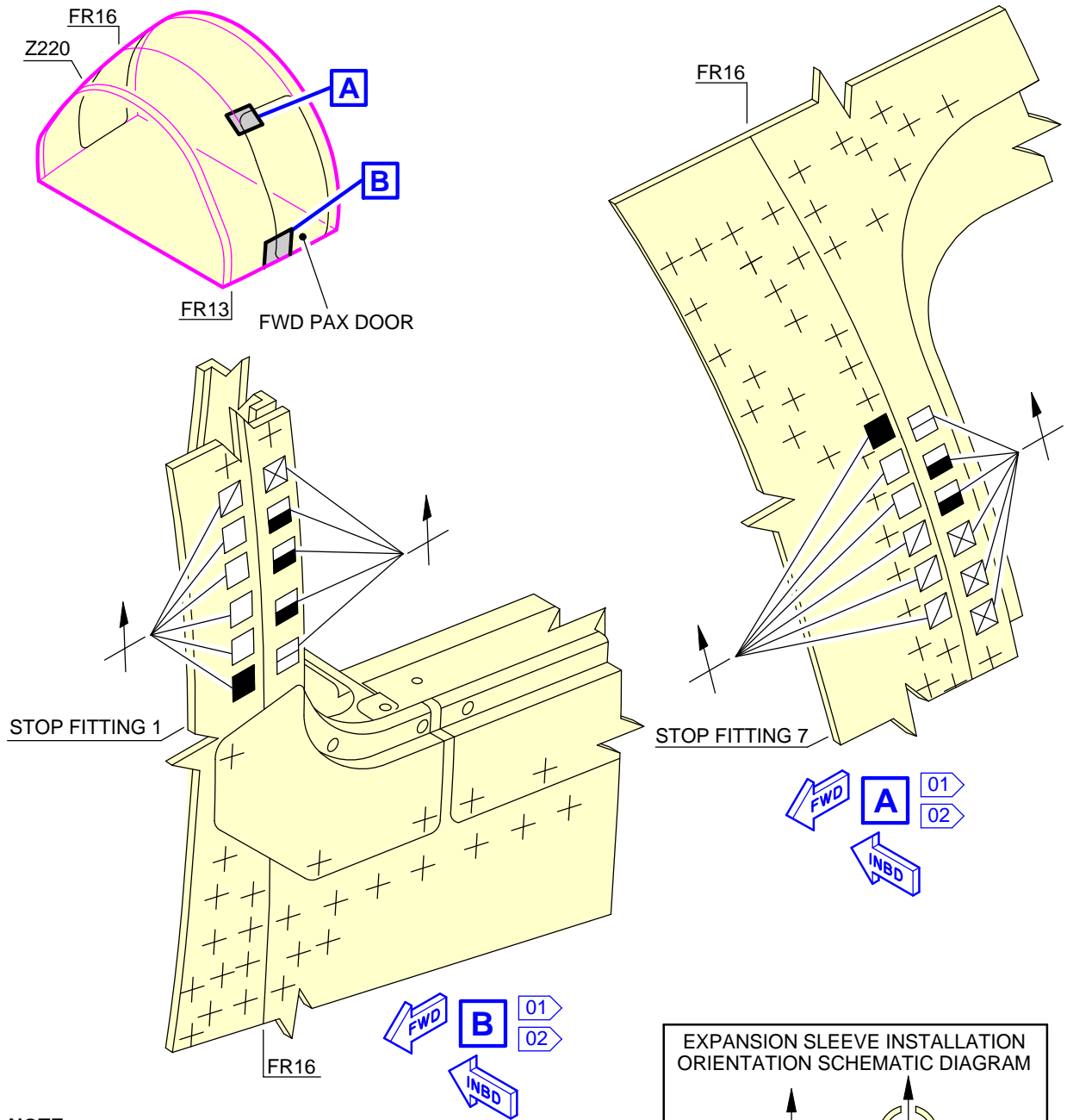
(c) Remove the old sealant with a non metallic spatula.

(d) Clean the holes and area with:

Textile - Lint free Cotton 14SBA1  
and

Non Aqueous Cleaner - 08BAA9  
General

**CONF 003**



**NOTE:**

REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS.

+ FASTENERS NOT AFFECTED.

**01** APPLY A NEW INTERNAL PROTECTIVE FINISH WITH MATERIAL No 04EAC2 AND MATERIAL No 04JME4. ON THE TOP OF THE INTERNAL PROTECTIVE FINISH, APPLY MATERIAL No 12ABD1.

**02** APPLY A NEW EXTERNAL PROTECTIVE FINISH WITH MATERIAL No 04CMA2, MATERIAL No 04EAC2 AND MATERIAL No 04JAA3.

ICN-A320-A-53XX1381-A-FAPE3-00A36-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A36-A-001-01 SHEET 1/2

**CONF 003**

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE/FIT TYPE	NOTE
						MIN	MAX	MIN	MAX		
■ <sub>N</sub>	(1)	1	EN6114K4Y13	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
□ <sub>N</sub>	(3)	3	EN6114K4Y11	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
▣ <sub>N</sub>	(4)	4	EN6114K3A8	BOLT	6-1-N	4.920 mm (0.1937 in)	4.960 mm (0.1952 in)	5.467 mm (0.2153 in)	5.507 mm (0.2168 in)	NOMINAL SIZE INTERFERENCE FIT	03
	(5)	5	ASNA2531-3A	NUT							
▢ <sub>N</sub>	(6)	6	EN6114K5Y14	BOLT	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(7)	7	ASNA2531-5	NUT							
■ <sub>N</sub>	(8)	8	EN6114K5Y12	BOLT	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(7)	7	ASNA2531-5	NUT							
▣ <sub>N</sub>	(12)	12	EN6114K4Y9	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							

**NOTE:**

⊥<sub>N</sub> HEAD ON NEAR SIDE.

03 WET-INSTALL THE FASTENERS WITH MATERIAL No 06AAB1.

ICN-A320-A-53XX1381-A-FAPE3-00A37-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A37-A-001-01 SHEET 2/2

Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side

**CONF ALL**

- (2) **Task A320-A-53-XX-1381-01001-353A-A - Do a Rotating Probe Inspection of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side**

**Job Set-Up Information**

**Working Area**

Impacted Zone	Access / Work Location	
220	Access	Door 831
	Work location	Frame 16

**Manpower/Resources/Skills**

<b>Man-hours</b>	1.00 h
<b>Minimum Number of person</b>	1
<b>Elapsed Time</b>	1.00 h
<b>Skills</b>	Non-Destructive Testing

**Referenced Information**

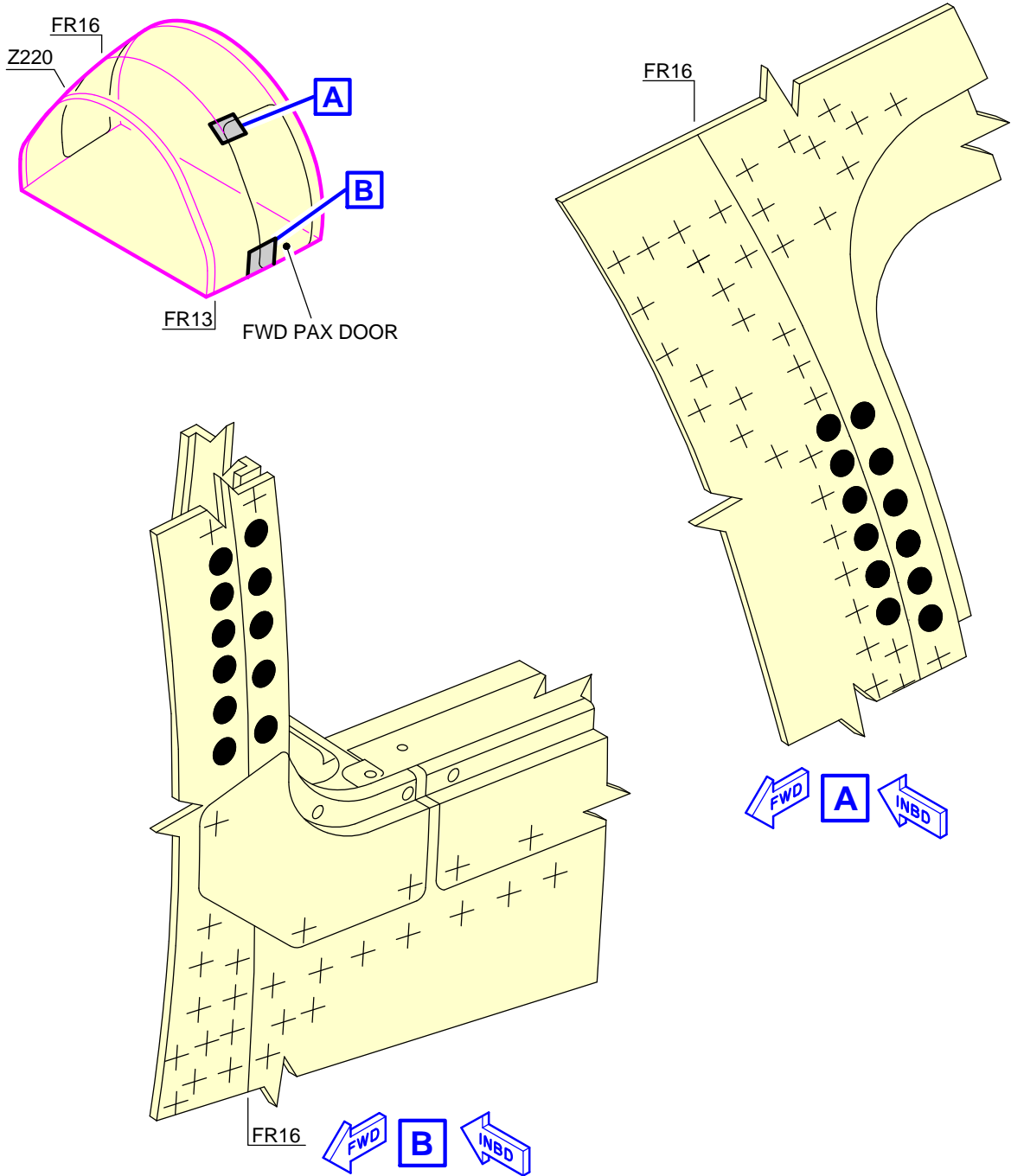
Manuals/Drawings	References/Sheets
SB	A320-53-1373
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
NTM	Task 51-10-01-250-801

**Procedure**

**NOTE:** If Service Bulletin No. Ref. SB A320-53-1373 has been performed in the same layover period, it is not necessary to do the following workstep.

- (a) Standard practices given in this procedure:
  - 1 For the FR identification, refer to Ref. AMM 06-31-53, Page Block 001.
  - 2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.
- (b) Do a rotating probe inspection of the fastener holes of the Frame 16 double joggle area:  
Refer to Ref. Fig. Rotating Probe Inspection of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side  
Refer to Ref. NTM Task 51-10-01-250-801
  - 1 If cracks are detected, contact AIRBUS before next flight and follow their instructions.
  - 2 If no cracks are detected, do the cold working of the fastener holes, refer to Ref. Task A320-A-53-XX-1381-01ZZZ-900Z-A.

**CONF ALL**



**NOTE:**

+ FASTENERS NOT AFFECTED.

● DO A ROTATING PROBE INSPECTION OF THE FASTENER HOLES AS PER NTM 51-10-01-250-801.

ICN-A320-A-53XX1381-A-FAPE3-00A38-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A38-A-001-01 SHEET 1/1

**CONF 001**

**(3) Task A320-A-53-XX-1381-01001-900A-A - Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side**

**Job Set-Up Information**

**Working Area**

Impacted Zone	Access / Work Location	
220	Access	Door 831
	Work location	Frame 16

**Manpower/Resources/Skills**

<b>Man-hours</b>	4.00 h
<b>Minimum Number of person</b>	1
<b>Elapsed Time</b>	4.00 h
<b>Skills</b>	Airframe

**Material necessary to do the job**

Aircraft standard tools					
ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
	DKA3205313811	1	TOOLKIT		(1)
	EKA3205313811	1	TOOLKIT		(2)
	FTIA3205313811	1	TOOLKIT		(3)
	WCIA3205313811	1	TOOLKIT		(4)
NOTE(S)					
(1): Durable tooling. Ref. DK-A320-53-1381-1 The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to Ref. ISI 51.48.00001.					
(2): Expendable tooling. Ref. EK-A320-53-1381-1 The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.					
(3): Capital tooling. Ref. FTI-A320-53-1381-1 The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from Fatigue Technology Incorporated (FTI).					
(4): Capital tooling. Ref. WCI-A320-53-1381-1 The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from West Coast Industries (WCI).					

Consumables				
ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

**Referenced Information**

<b>Manuals/Drawings</b>	<b>References/Sheets</b>
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-00 51-48-00

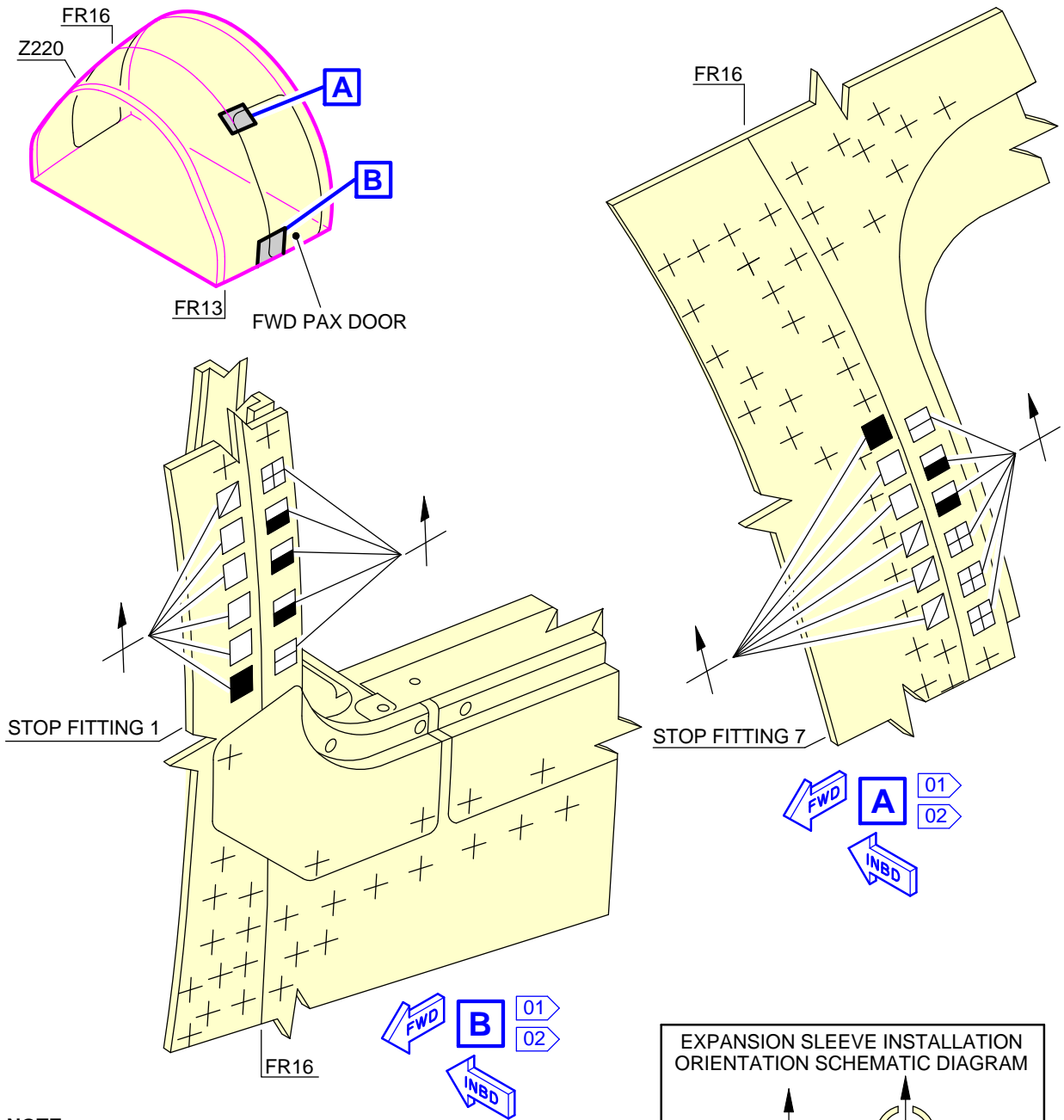
**Procedure**

- (a) Standard practices given in this procedure:
  - 1 For the FR identification, refer to Ref. AMM 06-31-53, Page Block 001.
  - 2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.
  - 3 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.
  - 4 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.
  - 5 Do the cold working of the fastener holes in accordance with Ref. SRM 51-48-00.
  - 6 Get the fasteners holes countersink data in accordance with Ref. SRM 51-46-00.
- (b) Do a check of the existing hole diameters and compare with the values of the starting hole diameters as shown in Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side SHEET 2:
  - 1 In case the existing hole diameter is more than or equal to the minimum starting hole diameter, please contact AIRBUS for further instructions before next flight.
  - 2 In case the existing hole diameter is less than the minimum starting hole diameter, do the next step.
- (c) Oversize the fastener holes to the correct starting hole diameters given in Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side SHEET 2.  
 Use FTI tools list No:
  - 1 DURABLE TOOLING DKA3205313811
  - or
  - Use WCI tools list No:
  - 1 DURABLE TOOLING DKA3205313811
- (d) Clean the drilled areas with:
  - Textile - Lint free Cotton 14SBA1
  - and
  - Non Aqueous Cleaner - 08BAA9
  - General
- (e) Do a cold working of the fastener holes:

- 1 Install the sleeves in accordance with the orientation given in Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side SHEET 1.  
Use FTI tools list No:
- 1 EXPENDABLE TOOLING EKA3205313811  
or  
Use WCI tools list No:
- 1 EXPENDABLE TOOLING EKA3205313811
- 2 Do the cold expansion of the fastener holes.  
Use FTI tools list No:
- 1 CAPITAL TOOLING FTIA3205313811  
or  
Use WCI tools list No:
- 1 CAPITAL TOOLING WCIA3205313811
- 3 Remove the sleeves.
- (f) Ream the fastener holes to the final hole diameters given in Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side SHEET 2.  
Use FTI tools list No:
- 1 DURABLE TOOLING DKA3205313811  
or  
Use WCI tools list No:
- 1 DURABLE TOOLING DKA3205313811
- (g) Clean the drilled areas with:
- Textile - Lint free Cotton 14SBA1  
and  
Non Aqueous Cleaner - 08BAA9  
General
- (h) Do a countersink to the related fastener head depth.



**CONF 001**



**NOTE:**  
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS.

+ FASTENERS NOT AFFECTED.

**01** APPLY A NEW INTERNAL PROTECTIVE FINISH WITH MATERIAL No 04EAC2 AND MATERIAL No 04JME4. ON THE TOP OF THE INTERNAL PROTECTIVE FINISH, APPLY MATERIAL No 12ABD1.

**02** APPLY A NEW EXTERNAL PROTECTIVE FINISH WITH MATERIAL No 04CMA2, MATERIAL No 04EAC2 AND MATERIAL No 04JAA3.

ICN-A320-A-53XX1381-A-FAPE3-00A32-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A32-A-001-01 SHEET 1/2

CONF 001

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE/FIT TYPE	NOTE
						MIN	MAX	MIN	MAX		
■ <sub>N</sub>	(1)	1	EN6114K4Y13	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
□ <sub>N</sub>	(3)	3	EN6114K4Y11	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
▧ <sub>N</sub>	(4)	4	EN6114K3A8	BOLT	6-1-N	4.920 mm (0.1937 in)	4.960 mm (0.1952 in)	5.467 mm (0.2153 in)	5.507 mm (0.2168 in)	NOMINAL SIZE INTERFERENCE FIT	03
	(5)	5	ASNA2531-3A	NUT							
▨ <sub>N</sub>	(6)	6	EN6114K5Y14	BOLT	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(7)	7	ASNA2531-5	NUT							
■ <sub>N</sub>	(8)	8	EN6114K5Y12	BOLT	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(7)	7	ASNA2531-5	NUT							
▨ <sub>N</sub>	(9)	9	EN6114K4Y10	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							

NOTE:

▨<sub>N</sub> HEAD ON NEAR SIDE.

03 WET-INSTALL THE FASTENERS WITH MATERIAL No 06AAB1.

ICN-A320-A-53XX1381-A-FAPE3-00A33-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A33-A-001-01 SHEET 2/2

Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side

**CONF 002**

**(3) Task A320-A-53-XX-1381-01002-900A-A - Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side**

**Job Set-Up Information**

**Working Area**

Impacted Zone	Access / Work Location	
220	Access	Door 831
	Work location	Frame 16

**Manpower/Resources/Skills**

<b>Man-hours</b>	4.00 h
<b>Minimum Number of person</b>	1
<b>Elapsed Time</b>	4.00 h
<b>Skills</b>	Airframe

**Material necessary to do the job**

Aircraft standard tools					
ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
	DKA3205313811	1	TOOLKIT		(1)
	EKA3205313811	1	TOOLKIT		(2)
	FTIA3205313811	1	TOOLKIT		(3)
	WCIA3205313811	1	TOOLKIT		(4)
<b>NOTE(S)</b>					
(1): Durable tooling. Ref. DK-A320-53-1381-1 The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to Ref. ISI 51.48.00001.					
(2): Expendable tooling. Ref. EK-A320-53-1381-1 The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.					
(3): Capital tooling. Ref. FTI-A320-53-1381-1 The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from Fatigue Technology Incorporated (FTI).					
(4): Capital tooling. Ref. WCI-A320-53-1381-1 The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from West Coast Industries (WCI).					

Consumables				
ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

**Referenced Information**

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-00 51-48-00

**Procedure**

- (a) Standard practices given in this procedure:
  - 1 For the FR identification, refer to Ref. AMM 06-31-53, Page Block 001.
  - 2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.
  - 3 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.
  - 4 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.
  - 5 Do the cold working of the fastener holes in accordance with Ref. SRM 51-48-00.
  - 6 Get the fasteners holes countersink data in accordance with Ref. SRM 51-46-00.
- (b) Do a check of the existing hole diameters and compare with the values of the starting hole diameters as shown in Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side SHEET 2:
  - 1 In case the existing hole diameter is more than or equal to the minimum starting hole diameter, please contact AIRBUS for further instructions before next flight.
  - 2 In case the existing hole diameter is less than the minimum starting hole diameter, do the next step.
- (c) Oversize the fastener holes to the correct starting hole diameters given in Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side SHEET 2.  
Use FTI tools list No:
  - 1 DURABLE TOOLING DKA3205313811
  - or
  - Use WCI tools list No:
  - 1 DURABLE TOOLING DKA3205313811
- (d) Clean the drilled areas with:
  - Textile - Lint free Cotton 14SBA1
  - and
  - Non Aqueous Cleaner - 08BAA9
  - General
- (e) Do a cold working of the fastener holes:

1 Install the sleeves in accordance with the orientation given in Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side SHEET 1.  
 Use FTI tools list No:

1 EXPENDABLE TOOLING EKA3205313811  
 or  
 Use WCI tools list No:

1 EXPENDABLE TOOLING EKA3205313811

2 Do the cold expansion of the fastener holes.  
 Use FTI tools list No:

1 CAPITAL TOOLING FTIA3205313811  
 or  
 Use WCI tools list No:

1 CAPITAL TOOLING WCIA3205313811

3 Remove the sleeves.

(f) Ream the fastener holes to the final hole diameters given in Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side SHEET 2.  
 Use FTI tools list No:

1 DURABLE TOOLING DKA3205313811  
 or  
 Use WCI tools list No:

1 DURABLE TOOLING DKA3205313811

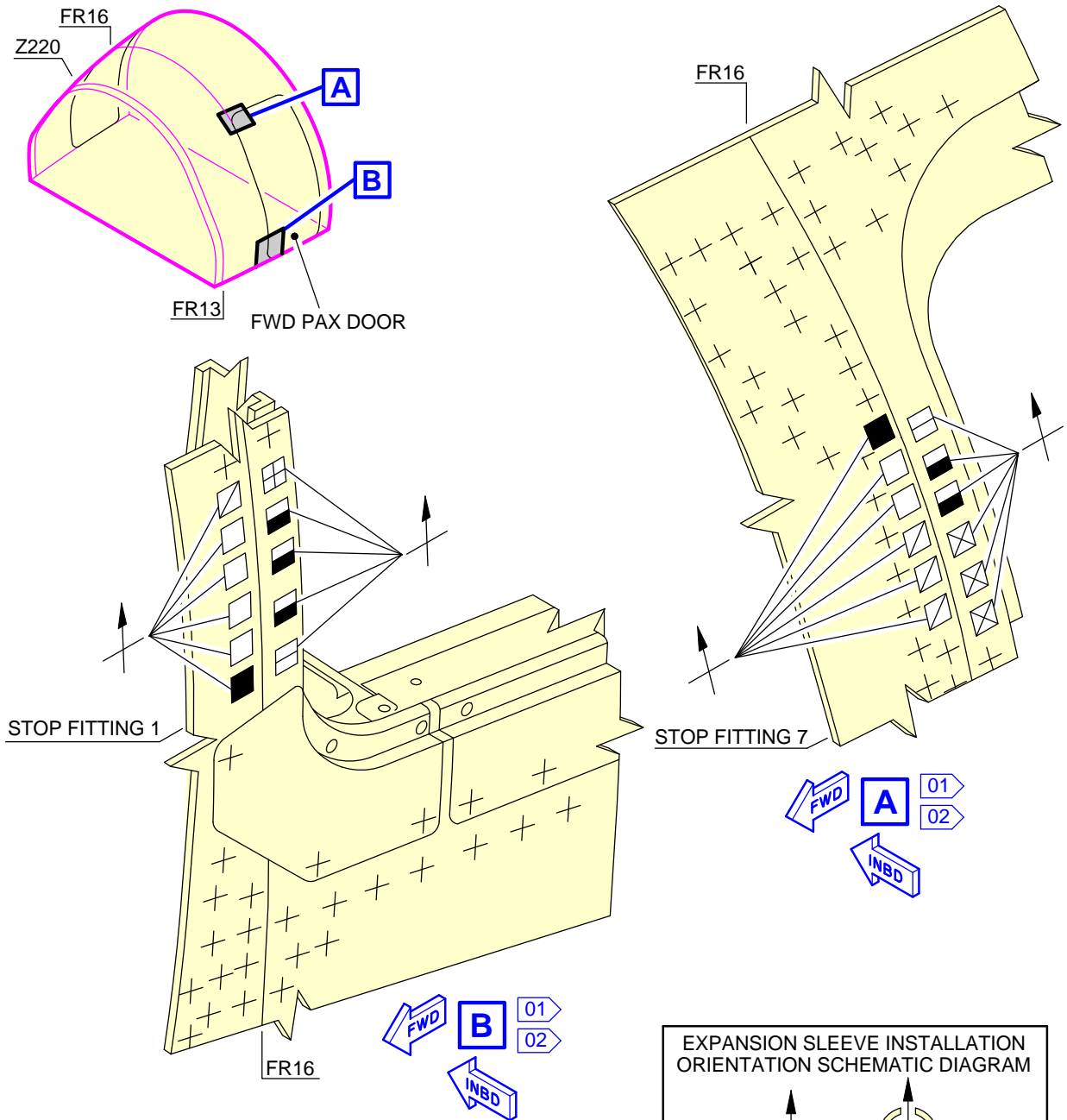
(g) Clean the drilled areas with:

Textile - Lint free Cotton 14SBA1  
 and

Non Aqueous Cleaner - 08BAA9  
 General

(h) Do a countersink to the related fastener head depth.

**CONF 002**



**NOTE:**  
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS.

+ FASTENERS NOT AFFECTED.

**01** APPLY A NEW INTERNAL PROTECTIVE FINISH WITH MATERIAL No 04EAC2 AND MATERIAL No 04JME4. ON THE TOP OF THE INTERNAL PROTECTIVE FINISH, APPLY MATERIAL No 12ABD1.

**02** APPLY A NEW EXTERNAL PROTECTIVE FINISH WITH MATERIAL No 04CMA2, MATERIAL No 04EAC2 AND MATERIAL No 04JAA3.

ICN-A320-A-53XX1381-A-FAPE3-00A34-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A34-A-001-01 SHEET 1/2

CONF 002

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE/FIT TYPE	NOTE
						MIN	MAX	MIN	MAX		
■ N	(1)	1	EN6114K4Y13	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
□ N	(3)	3	EN6114K4Y11	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
▧ N	(4)	4	EN6114K3A8	BOLT	6-1-N	4.920 mm (0.1937 in)	4.960 mm (0.1952 in)	5.467 mm (0.2153 in)	5.507 mm (0.2168 in)	NOMINAL SIZE INTERFERENCE FIT	03
	(5)	5	ASNA2531-3A	NUT							
▩ N	(6)	6	EN6114K5Y14	BOLT	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(7)	7	ASNA2531-5	NUT							
■ N	(8)	8	EN6114K5Y12	BOLT	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(7)	7	ASNA2531-5	NUT							
▩ N	(9)	9	EN6114K4Y10	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
⊠ N	(12)	12	EN6114K4Y9	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							

NOTE:

⊠<sub>N</sub> HEAD ON NEAR SIDE.

03 WET-INSTALL THE FASTENERS WITH MATERIAL No 06AAB1.

ICN-A320-A-53XX1381-A-FAPE3-00A35-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A35-A-001-01 SHEET 2/2

**CONF 003**

**(3) Task A320-A-53-XX-1381-01003-900A-A - Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side**

**Job Set-Up Information**

**Working Area**

Impacted Zone	Access / Work Location	
220	Access	Door 831
	Work location	Frame 16

**Manpower/Resources/Skills**

<b>Man-hours</b>	4.00 h
<b>Minimum Number of person</b>	1
<b>Elapsed Time</b>	4.00 h
<b>Skills</b>	Airframe

**Material necessary to do the job**

Aircraft standard tools					
ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
	DKA3205313811	1	TOOLKIT		(1)
	EKA3205313811	1	TOOLKIT		(2)
	FTIA3205313811	1	TOOLKIT		(3)
	WCIA3205313811	1	TOOLKIT		(4)
NOTE(S)					
(1): Durable tooling. Ref. DK-A320-53-1381-1 The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to Ref. ISI 51.48.00001.					
(2): Expendable tooling. Ref. EK-A320-53-1381-1 The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.					
(3): Capital tooling. Ref. FTI-A320-53-1381-1 The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from Fatigue Technology Incorporated (FTI).					
(4): Capital tooling. Ref. WCI-A320-53-1381-1 The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from West Coast Industries (WCI).					

Consumables				
ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		



**Referenced Information**

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-00 51-48-00

**Procedure**

- (a) Standard practices given in this procedure:
  - 1 For the FR identification, refer to Ref. AMM 06-31-53, Page Block 001.
  - 2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.
  - 3 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.
  - 4 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.
  - 5 Do the cold working of the fastener holes in accordance with Ref. SRM 51-48-00.
  - 6 Get the fasteners holes countersink data in accordance with Ref. SRM 51-46-00.
- (b) Do a check of the existing hole diameters and compare with the values of the starting hole diameters as shown in Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side SHEET 2:
  - 1 In case the existing hole diameter is more than or equal to the minimum starting hole diameter, please contact AIRBUS for further instructions before next flight.
  - 2 In case the existing hole diameter is less than the minimum starting hole diameter, do the next step.
- (c) Oversize the fastener holes to the correct starting hole diameters given in Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side SHEET 2.  
Use FTI tools list No:
  - 1 DURABLE TOOLING DKA3205313811
  - or
  - Use WCI tools list No:
  - 1 DURABLE TOOLING DKA3205313811
- (d) Clean the drilled areas with:
  - Textile - Lint free Cotton 14SBA1
  - and
  - Non Aqueous Cleaner - 08BAA9
  - General
- (e) Do a cold working of the fastener holes:

1 Install the sleeves in accordance with the orientation given in Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side SHEET 1.

Use FTI tools list No:

1 EXPENDABLE TOOLING EKA3205313811

or

Use WCI tools list No:

1 EXPENDABLE TOOLING EKA3205313811

2 Do the cold expansion of the fastener holes.

Use FTI tools list No:

1 CAPITAL TOOLING FTIA3205313811

or

Use WCI tools list No:

1 CAPITAL TOOLING WCIA3205313811

3 Remove the sleeves.

(f) Ream the fastener holes to the final hole diameters given in Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side SHEET 2.

Use FTI tools list No:

1 DURABLE TOOLING DKA3205313811

or

Use WCI tools list No:

1 DURABLE TOOLING DKA3205313811

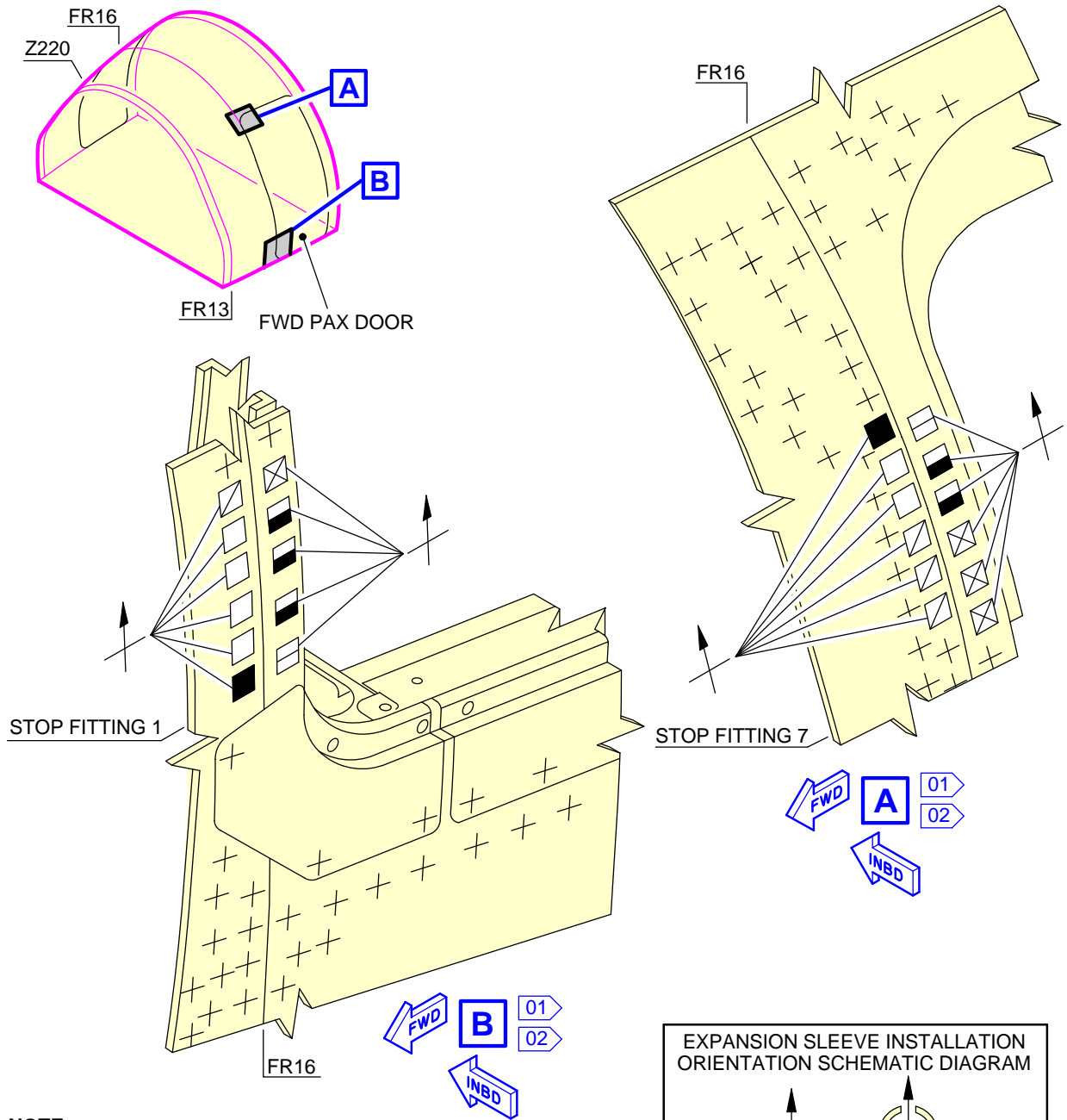
(g) Clean the drilled areas with:

Textile - Lint free Cotton 14SBA1  
and

Non Aqueous Cleaner - 08BAA9  
General

(h) Do a countersink to the related fastener head depth.

**CONF 003**



**NOTE:**  
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS.

+ FASTENERS NOT AFFECTED.

- 01** APPLY A NEW INTERNAL PROTECTIVE FINISH WITH MATERIAL No 04EAC2 AND MATERIAL No 04JME4. ON THE TOP OF THE INTERNAL PROTECTIVE FINISH, APPLY MATERIAL No 12ABD1.
- 02** APPLY A NEW EXTERNAL PROTECTIVE FINISH WITH MATERIAL No 04CMA2, MATERIAL No 04EAC2 AND MATERIAL No 04JAA3.

ICN-A320-A-53XX1381-A-FAPE3-00A36-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A36-A-001-01 SHEET 1/2

**CONF 003**

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE/FIT TYPE	NOTE
						MIN	MAX	MIN	MAX		
■ <sub>N</sub>	(1)	1	EN6114K4Y13	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
□ <sub>N</sub>	(3)	3	EN6114K4Y11	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
▣ <sub>N</sub>	(4)	4	EN6114K3A8	BOLT	6-1-N	4.920 mm (0.1937 in)	4.960 mm (0.1952 in)	5.467 mm (0.2153 in)	5.507 mm (0.2168 in)	NOMINAL SIZE INTERFERENCE FIT	03
	(5)	5	ASNA2531-3A	NUT							
▢ <sub>N</sub>	(6)	6	EN6114K5Y14	BOLT	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(7)	7	ASNA2531-5	NUT							
■ <sub>N</sub>	(8)	8	EN6114K5Y12	BOLT	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(7)	7	ASNA2531-5	NUT							
▣ <sub>N</sub>	(12)	12	EN6114K4Y9	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							

**NOTE:**

⊥<sub>N</sub> HEAD ON NEAR SIDE.

03 WET-INSTALL THE FASTENERS WITH MATERIAL No 06AAB1.

ICN-A320-A-53XX1381-A-FAPE3-00A37-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A37-A-001-01 SHEET 2/2

Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side

**CONF 001**

**(4) Task A320-A-53-XX-1381-01001-720A-A - Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side**

**Job Set-Up Information**

**Working Area**

Impacted Zone	Access / Work Location	
220	Access	Door 831
	Work location	Frame 16

**Manpower/Resources/Skills**

<b>Man-hours</b>	7.75 h
<b>Minimum Number of person</b>	1
<b>Elapsed Time</b>	7.75 h
<b>Skills</b>	Airframe

**Material necessary to do the job**

Consumables				
ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JAA3	Top Coat Polyurethane - - - External Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06AAB1	Polysulfide Sealant - General Purpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ABD1	Corrosion Preventive Compound - Water Displacing Ultra-thin Film		
	14SBA1	Textile - Lint free Cotton		

Part kit 531381A01R01					
ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	EN6114K4Y13	2	BOLT		
2	ASNA2531-4	12	NUT		
3	EN6114K4Y11	6	BOLT		
4	EN6114K3A8	4	BOLT		
5	ASNA2531-3A	4	NUT		
6	EN6114K5Y14	2	BOLT		
7	ASNA2531-5	7	NUT		
8	EN6114K5Y12	5	BOLT		
9	EN6114K4Y10	4	BOLT		

**Referenced Information**

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 Task 20-21-11-911-001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-75-12

**Procedure**

- (a) Standard practices given in this procedure:
  - 1 For the FR identification, refer to Ref. AMM 06-31-53, Page Block 001.
  - 2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.
  - 3 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.
  - 4 Remove and install fasteners in accordance with Ref. SRM 51-42-00.
  - 5 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.
  - 6 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 'Mating Part' column.
  - 7 If the length of any fastener specified in this Service Bulletin 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.
  - 8 Apply sealant in accordance with Ref. SRM 51-24-00.
  - 9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.
  - 10 Renew the protective finish in accordance with Ref. SRM 51-75-12.
- (b) Install the fasteners on the Frame 16 double joggle area:
  - 1 Wet install the fasteners:  
Refer to Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side
  - 2 BOLT EN6114K4Y13 Item 1
  - 6 BOLT EN6114K4Y11 Item 3
  - 4 BOLT EN6114K3A8 Item 4
  - 2 BOLT EN6114K5Y14 Item 6
  - 5 BOLT EN6114K5Y12 Item 8
  - 4 BOLT EN6114K4Y10 Item 9

12	NUT	ASNA2531-4	Item 2
7	NUT	ASNA2531-5	Item 7
4	NUT-HEXAGONAL with:	ASNA2531-3A	Item 5

Polysulfide Sealant - 06AAB1  
General Purpose Fillet

2 Clean the work areas with:

Textile - Lint free Cotton 14SBA1  
and

Non Aqueous Cleaner - 08BAA9  
General

(c) Apply protective finish on the new fasteners:  
Refer to Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double  
Joggle Area, on the LH Side

1 For the internal protective finish, apply:

Primer Polyurethane 04EAC2  
Paint - -  
CorrosionInhibiting  
Structure  
and

Top Coat Polyurethane - 04JME4  
- Grey InternalStructure  
and

Corrosion Preventive 12ABD1  
Compound - Water  
Displacing Ultra-thin  
Film

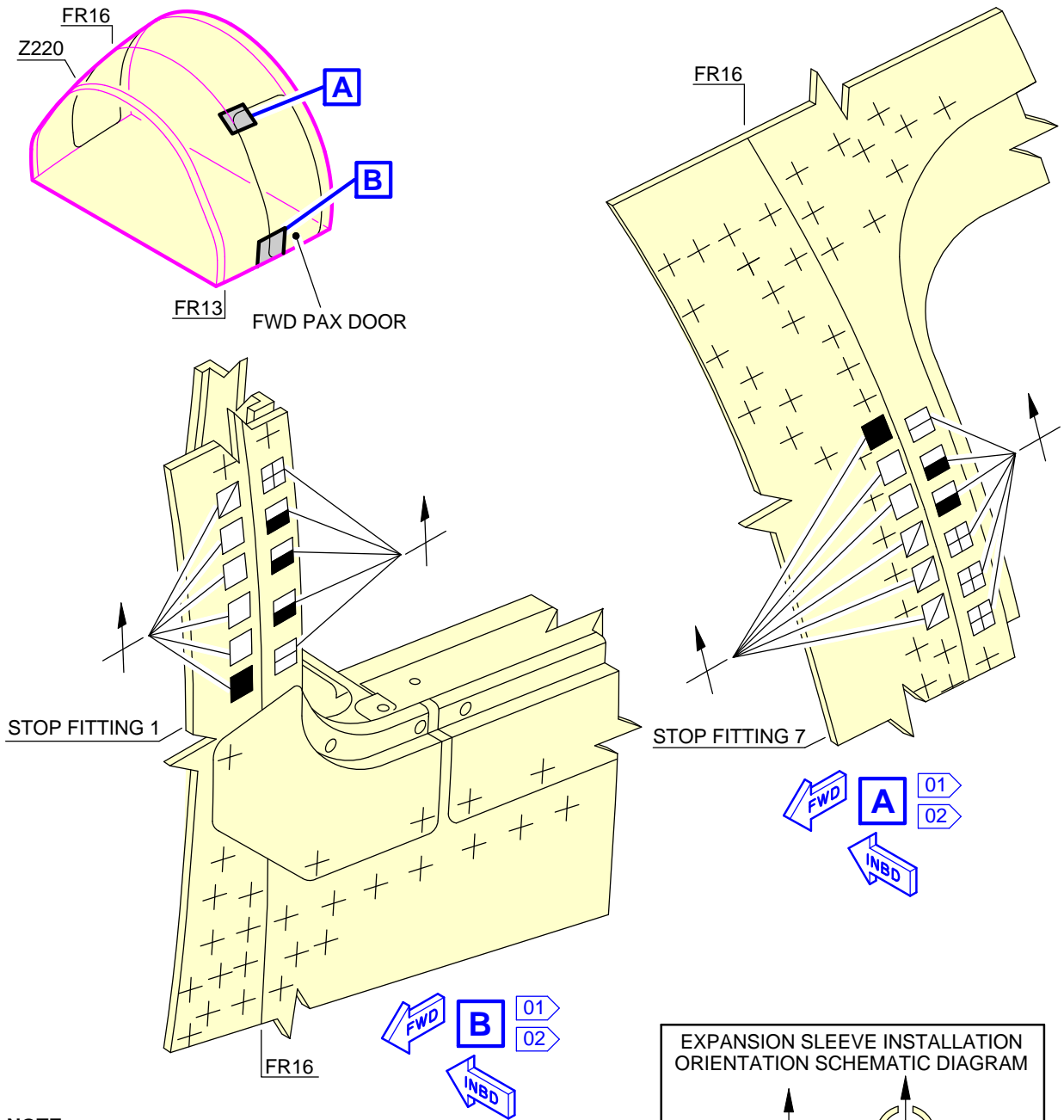
2 For the external protective finish, apply:

Wash Primer - - - 04CMA2  
Structure  
and

Primer Polyurethane 04EAC2  
Paint - -  
CorrosionInhibiting  
Structure  
and

Top Coat Polyurethane - 04JAA3  
- - External Structure

**CONF 001**



**NOTE:**  
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS.

+ FASTENERS NOT AFFECTED.

- 01** APPLY A NEW INTERNAL PROTECTIVE FINISH WITH MATERIAL No 04EAC2 AND MATERIAL No 04JME4. ON THE TOP OF THE INTERNAL PROTECTIVE FINISH, APPLY MATERIAL No 12ABD1.
- 02** APPLY A NEW EXTERNAL PROTECTIVE FINISH WITH MATERIAL No 04CMA2, MATERIAL No 04EAC2 AND MATERIAL No 04JAA3.

ICN-A320-A-53XX1381-A-FAPE3-00A32-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A32-A-001-01 SHEET 1/2



CONF 001

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE/FIT TYPE	NOTE
						MIN	MAX	MIN	MAX		
■ <sub>N</sub>	(1)	1	EN6114K4Y13	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
□ <sub>N</sub>	(3)	3	EN6114K4Y11	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
▧ <sub>N</sub>	(4)	4	EN6114K3A8	BOLT	6-1-N	4.920 mm (0.1937 in)	4.960 mm (0.1952 in)	5.467 mm (0.2153 in)	5.507 mm (0.2168 in)	NOMINAL SIZE INTERFERENCE FIT	03
	(5)	5	ASNA2531-3A	NUT							
▩ <sub>N</sub>	(6)	6	EN6114K5Y14	BOLT	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(7)	7	ASNA2531-5	NUT							
■ <sub>N</sub>	(8)	8	EN6114K5Y12	BOLT	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(7)	7	ASNA2531-5	NUT							
▩ <sub>N</sub>	(9)	9	EN6114K4Y10	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							

NOTE:

▩<sub>N</sub> HEAD ON NEAR SIDE.

03 WET-INSTALL THE FASTENERS WITH MATERIAL No 06AAB1.

ICN-A320-A-53XX1381-A-FAPE3-00A33-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A33-A-001-01 SHEET 2/2

**CONF 002**

**(4) Task A320-A-53-XX-1381-01002-720A-A - Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side**

**Job Set-Up Information**

**Working Area**

Impacted Zone	Access / Work Location	
220	Access	Door 831
	Work location	Frame 16

**Manpower/Resources/Skills**

<b>Man-hours</b>	7.75 h
<b>Minimum Number of person</b>	1
<b>Elapsed Time</b>	7.75 h
<b>Skills</b>	Airframe

**Material necessary to do the job**

Consumables				
ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JAA3	Top Coat Polyurethane - - - External Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06AAB1	Polysulfide Sealant - General Purpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ABD1	Corrosion Preventive Compound - Water Displacing Ultra-thin Film		
	14SBA1	Textile - Lint free Cotton		

Part kit 531381A02R01					
ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	EN6114K4Y13	2	BOLT		
2	ASNA2531-4	12	NUT		
3	EN6114K4Y11	6	BOLT		
4	EN6114K3A8	4	BOLT		
5	ASNA2531-3A	4	NUT		
6	EN6114K5Y14	2	BOLT		
7	ASNA2531-5	7	NUT		
8	EN6114K5Y12	5	BOLT		
9	EN6114K4Y10	1	BOLT		

Part kit 531381A02R01					
ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
12	EN6114K4Y9	3	BOLT		

**Referenced Information**

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 Task 20-21-11-911-001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-75-12

**Procedure**

(a) Standard practices given in this procedure:

- 1 For the FR identification, refer to Ref. AMM 06-31-53, Page Block 001.
- 2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.
- 3 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.
- 4 Remove and install fasteners in accordance with Ref. SRM 51-42-00.
- 5 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.
- 6 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 'Mating Part' column.
- 7 If the length of any fastener specified in this Service Bulletin 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.
- 8 Apply sealant in accordance with Ref. SRM 51-24-00.
- 9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.
- 10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Install the fasteners on the Frame 16 double joggle area:

- 1 Wet install the fasteners:  
Refer to Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side
- 2 BOLT EN6114K4Y13 Item 1
- 6 BOLT EN6114K4Y11 Item 3
- 4 BOLT EN6114K3A8 Item 4

2	BOLT	EN6114K5Y14	Item 6
5	BOLT	EN6114K5Y12	Item 8
1	BOLT	EN6114K4Y10	Item 9
3	BOLT	EN6114K4Y9	Item 12
12	NUT	ASNA2531-4	Item 2
4	NUT-HEXAGONAL	ASNA2531-3A	Item 5
7	NUT with:	ASNA2531-5	Item 7

Polysulfide Sealant - 06AAB1  
General Purpose Fillet

2 Clean the work areas with:

Textile - Lint free Cotton 14SBA1  
and

Non Aqueous Cleaner - 08BAA9  
General

(c) Apply protective finish on the new fasteners:  
Refer to Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double  
Joggle Area, on the LH Side

1 For the internal protective finish, apply:

Primer Polyurethane 04EAC2  
Paint - -  
CorrosionInhibiting  
Structure  
and

Top Coat Polyurethane - 04JME4  
- Grey InternalStructure  
and

Corrosion Preventive 12ABD1  
Compound - Water  
Displacing Ultra-thin  
Film

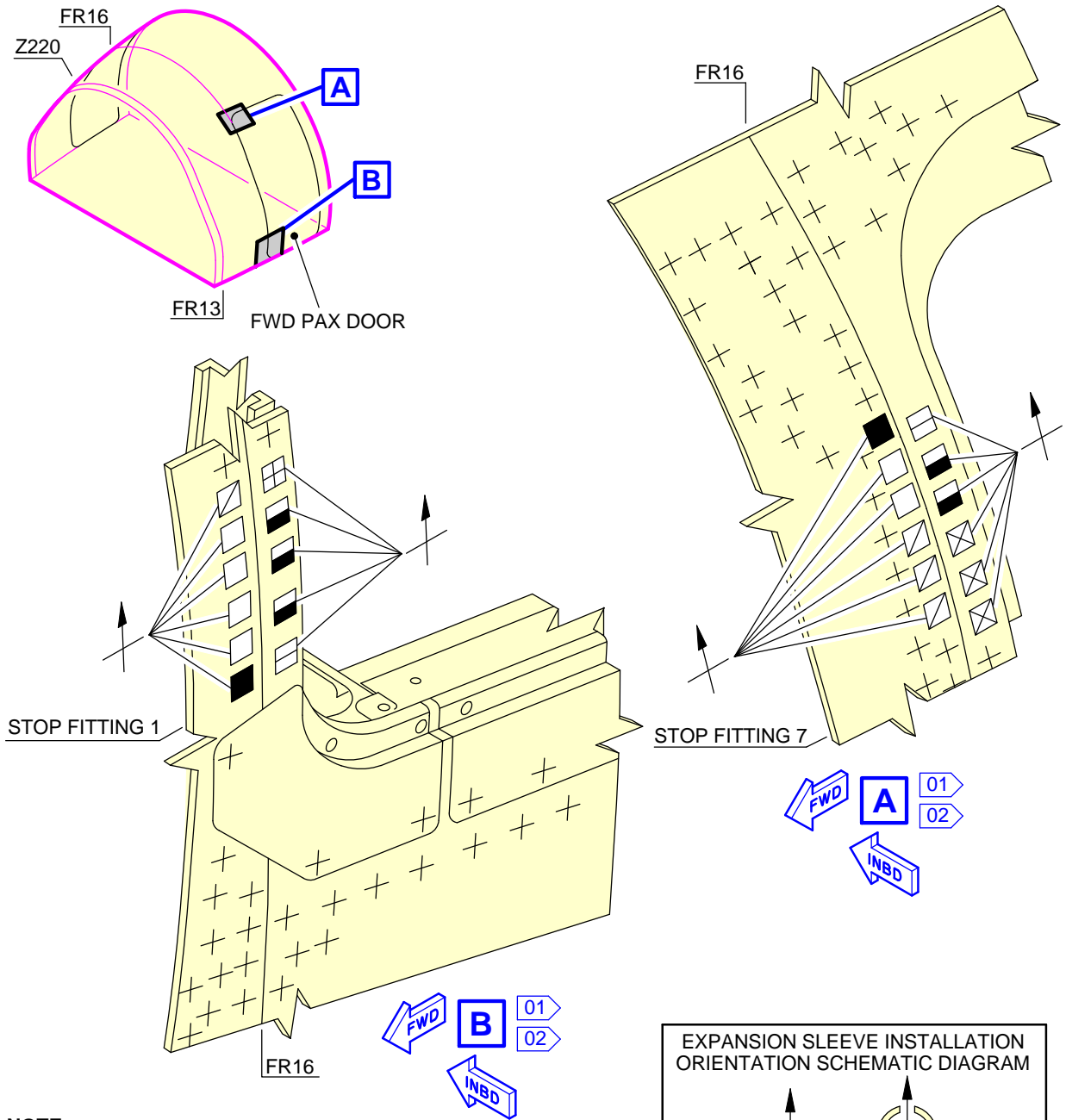
2 For the external protective finish, apply:

Wash Primer - - - 04CMA2  
Structure  
and

Primer Polyurethane 04EAC2  
Paint - -  
CorrosionInhibiting  
Structure  
and

Top Coat Polyurethane - 04JAA3  
- - External Structure

**CONF 002**



**NOTE:**  
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS.

+ FASTENERS NOT AFFECTED.

**01** APPLY A NEW INTERNAL PROTECTIVE FINISH WITH MATERIAL No 04EAC2 AND MATERIAL No 04JME4. ON THE TOP OF THE INTERNAL PROTECTIVE FINISH, APPLY MATERIAL No 12ABD1.

**02** APPLY A NEW EXTERNAL PROTECTIVE FINISH WITH MATERIAL No 04CMA2, MATERIAL No 04EAC2 AND MATERIAL No 04JAA3.

ICN-A320-A-53XX1381-A-FAPE3-00A34-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A34-A-001-01 SHEET 1/2

**CONF 002**

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE/FIT TYPE	NOTE
						MIN	MAX	MIN	MAX		
■ N	(1)	1	EN6114K4Y13	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
□ N	(3)	3	EN6114K4Y11	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
▧ N	(4)	4	EN6114K3A8	BOLT	6-1-N	4.920 mm (0.1937 in)	4.960 mm (0.1952 in)	5.467 mm (0.2153 in)	5.507 mm (0.2168 in)	NOMINAL SIZE INTERFERENCE FIT	03
	(5)	5	ASNA2531-3A	NUT							
▩ N	(6)	6	EN6114K5Y14	BOLT	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(7)	7	ASNA2531-5	NUT							
■ N	(8)	8	EN6114K5Y12	BOLT	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(7)	7	ASNA2531-5	NUT							
▩ N	(9)	9	EN6114K4Y10	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
▧ N	(12)	12	EN6114K4Y9	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							

**NOTE:**

⊥<sub>N</sub> HEAD ON NEAR SIDE.

03 WET-INSTALL THE FASTENERS WITH MATERIAL No 06AAB1.

ICN-A320-A-53XX1381-A-FAPE3-00A35-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A35-A-001-01 SHEET 2/2

**CONF 003**

**(4) Task A320-A-53-XX-1381-01003-720A-A - Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side**

**Job Set-Up Information**

**Working Area**

Impacted Zone	Access / Work Location	
220	Access	Door 831
	Work location	Frame 16

**Manpower/Resources/Skills**

<b>Man-hours</b>	7.75 h
<b>Minimum Number of person</b>	1
<b>Elapsed Time</b>	7.75 h
<b>Skills</b>	Airframe

**Material necessary to do the job**

Consumables				
ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JAA3	Top Coat Polyurethane - - - External Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06AAB1	Polysulfide Sealant - General Purpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ABD1	Corrosion Preventive Compound - Water Displacing Ultra-thin Film		
	14SBA1	Textile - Lint free Cotton		

Part kit 531381A03R01					
ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	EN6114K4Y13	2	BOLT		
2	ASNA2531-4	12	NUT		
3	EN6114K4Y11	6	BOLT		
4	EN6114K3A8	4	BOLT		
5	ASNA2531-3A	4	NUT		
6	EN6114K5Y14	2	BOLT		
7	ASNA2531-5	7	NUT		
8	EN6114K5Y12	5	BOLT		
12	EN6114K4Y9	4	BOLT		

**Referenced Information**

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 Task 20-21-11-911-001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-75-12

**Procedure**

- (a) Standard practices given in this procedure:
  - 1 For the FR identification, refer to Ref. AMM 06-31-53, Page Block 001.
  - 2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.
  - 3 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.
  - 4 Remove and install fasteners in accordance with Ref. SRM 51-42-00.
  - 5 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.
  - 6 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 'Mating Part' column.
  - 7 If the length of any fastener specified in this Service Bulletin 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.
  - 8 Apply sealant in accordance with Ref. SRM 51-24-00.
  - 9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.
  - 10 Renew the protective finish in accordance with Ref. SRM 51-75-12.
- (b) Install the fasteners on the Frame 16 double joggle area:
  - 1 Wet install the fasteners:  
Refer to Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side
  - 2 BOLT EN6114K4Y13 Item 1
  - 6 BOLT EN6114K4Y11 Item 3
  - 4 BOLT EN6114K3A8 Item 4
  - 2 BOLT EN6114K5Y14 Item 6
  - 5 BOLT EN6114K5Y12 Item 8
  - 4 BOLT EN6114K4Y9 Item 12



12	NUT	ASNA2531-4	Item 2
4	NUT-HEXAGONAL	ASNA2531-3A	Item 5
7	NUT with:	ASNA2531-5	Item 7

Polysulfide Sealant - 06AAB1  
General Purpose Fillet

2 Clean the work areas with:

Textile - Lint free Cotton 14SBA1  
and

Non Aqueous Cleaner - 08BAA9  
General

(c) Apply protective finish on the new fasteners:  
Refer to Ref. Fig. Cold Working of the Fastener Holes of the Frame 16 Double  
Joggle Area, on the LH Side

1 For the internal protective finish, apply:

Primer Polyurethane 04EAC2  
Paint - -  
CorrosionInhibiting  
Structure  
and

Top Coat Polyurethane - 04JME4  
- Grey InternalStructure  
and

Corrosion Preventive 12ABD1  
Compound - Water  
Displacing Ultra-thin  
Film

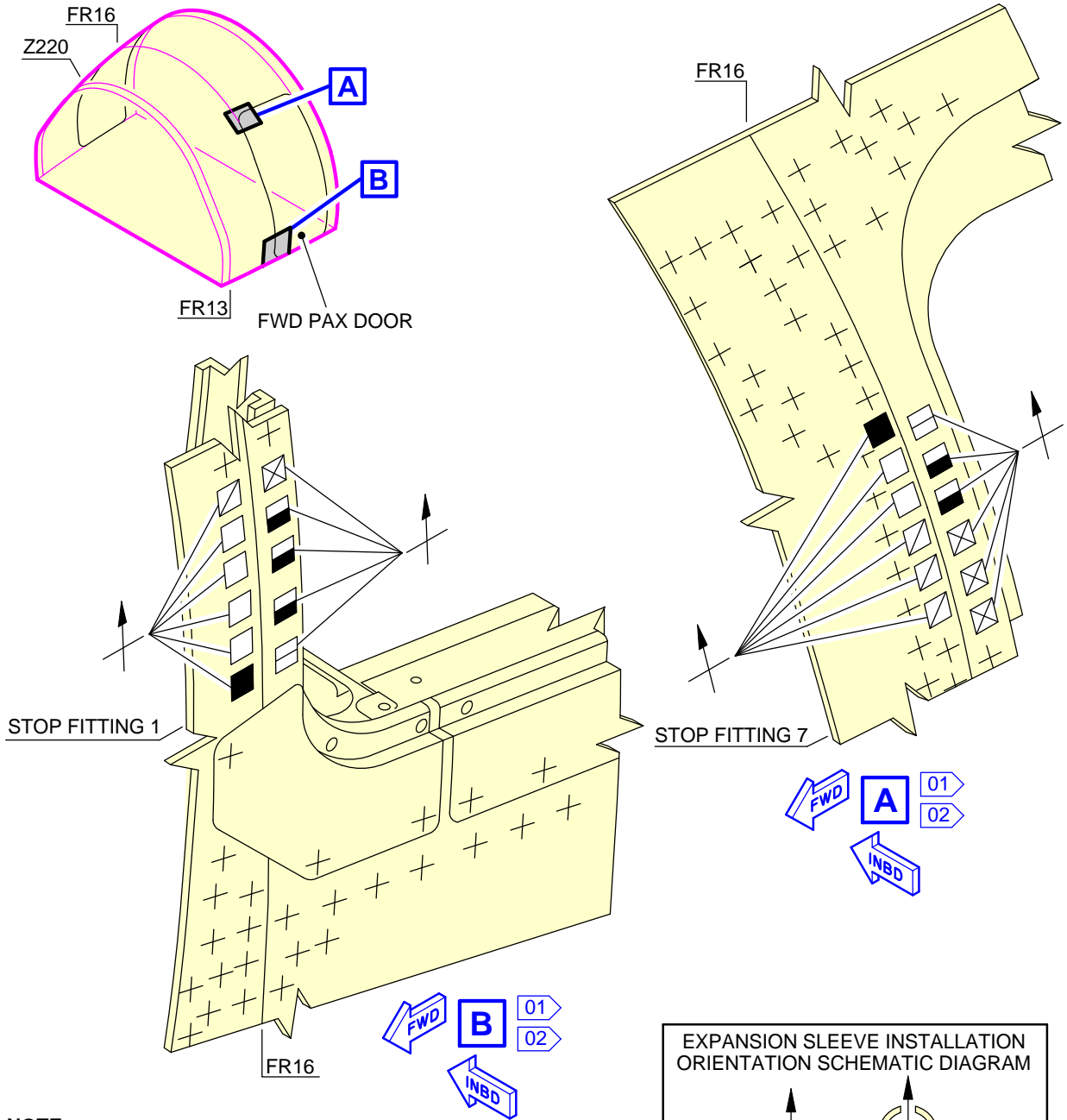
2 For the external protective finish, apply:

Wash Primer - - - 04CMA2  
Structure  
and

Primer Polyurethane 04EAC2  
Paint - -  
CorrosionInhibiting  
Structure  
and

Top Coat Polyurethane - 04JAA3  
- - External Structure

**CONF 003**



**NOTE:**  
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS.

+ FASTENERS NOT AFFECTED.

- 01** APPLY A NEW INTERNAL PROTECTIVE FINISH WITH MATERIAL No 04EAC2 AND MATERIAL No 04JME4. ON THE TOP OF THE INTERNAL PROTECTIVE FINISH, APPLY MATERIAL No 12ABD1.
- 02** APPLY A NEW EXTERNAL PROTECTIVE FINISH WITH MATERIAL No 04CMA2, MATERIAL No 04EAC2 AND MATERIAL No 04JAA3.

ICN-A320-A-53XX1381-A-FAPE3-00A36-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A36-A-001-01 SHEET 1/2

**CONF 003**

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE/FIT TYPE	NOTE
						MIN	MAX	MIN	MAX		
■ <sub>N</sub>	(1)	1	EN6114K4Y13	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
□ <sub>N</sub>	(3)	3	EN6114K4Y11	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							
▣ <sub>N</sub>	(4)	4	EN6114K3A8	BOLT	6-1-N	4.920 mm (0.1937 in)	4.960 mm (0.1952 in)	5.467 mm (0.2153 in)	5.507 mm (0.2168 in)	NOMINAL SIZE INTERFERENCE FIT	03
	(5)	5	ASNA2531-3A	NUT							
▢ <sub>N</sub>	(6)	6	EN6114K5Y14	BOLT	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(7)	7	ASNA2531-5	NUT							
■ <sub>N</sub>	(8)	8	EN6114K5Y12	BOLT	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(7)	7	ASNA2531-5	NUT							
▣ <sub>N</sub>	(12)	12	EN6114K4Y9	BOLT	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	03
	(2)	2	ASNA2531-4	NUT							

**NOTE:**

⊥<sub>N</sub> HEAD ON NEAR SIDE.

03 WET-INSTALL THE FASTENERS WITH MATERIAL No 06AAB1.

ICN-A320-A-53XX1381-A-FAPE3-00A37-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A37-A-001-01 SHEET 2/2

Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side

**CONF ALL**

**D. PREPARATION FOR TEST**

None

**E. TEST**

**(1) Task A320-A-53-XX-1381-01001-390A-A - Testing**

**Job Set-Up Information**

**Manpower/Resources/Skills**

<b>Man-hours</b>	0.10 h
<b>Minimum Number of person</b>	1
<b>Elapsed Time</b>	0.10 h

**Referenced Information**

<b>Manuals/Drawings</b>	<b>References/Sheets</b>
AMM	Task 25-23-45-400-006 25-31-00 25-41-00

**Procedure**

This Service Bulletin requires the accomplishment of Tests given in other topics which are referenced in the table below:

<b>Paragraph</b>	<b>Task</b>
Ref. Task A320-A-53-XX-1381-01ZZZ-740Z-A	Ref. AMM Task 25-23-45-400-006
	Ref. AMM 25-31-00  <b>NOTE:</b> If removed, do the test after the installation of the FWD galleys between Frame 15 and Frame 16. To do this, refer to Ref. AMM 25-31-00. In this paragraph, you will find the cross-references of the installation task.
	Ref. AMM 25-41-00  <b>NOTE:</b> If removed, do the test after the installation of the FWD lavatories between Frame 15 and Frame 16. To do this, refer to Ref. AMM 25-41-00. In this paragraph, you will find the cross-references of the installation task.

**F. CLOSE-UP**

**(1) Task A320-A-53-XX-1381-01001-740A-A - Close-up**

**Job Set-Up Information**

**Manpower/Resources/Skills**

<b>Man-hours</b>	4.00 h
<b>Minimum Number of person</b>	1
<b>Elapsed Time</b>	4.00 h

**Referenced Information**

Manuals/Drawings	References/Sheets
AMM	Task 25-23-45-400-006 25-31-00 25-41-00 Task 25-80-00-400-001 Task 52-10-00-410-001

**Procedure**

- (a) If removed, install the electrical wire harnesses at Frame 16.
- (b) Install the insulation blankets at Frame 16, refer to Ref. AMM Task 25-80-00-400-001.
- (c) Install the removed lining panels at Frame 16, refer to Ref. AMM Task 25-23-45-400-006.
- (d) If removed, install the FWD galleys and lavatories between Frame 15 and Frame 16. To do this, refer to the paragraph 'Component Location' in the applicable ATA 25 'Description/Operation': for the galleys, refer to Ref. AMM 25-31-00; for the lavatories, Ref. AMM 25-41-00. In this paragraph, you will find the cross-references of the installation task.
- (e) Make sure that the work areas are clean and clear of tools and other items of equipment.
- (f) Close the passenger/crew Door 831, refer to Ref. AMM Task 52-10-00-410-001.
- (g) Remove the access platform(s).
- (h) Put the aircraft back to its initial configuration.

**G. ADMINISTRATIVE**

**(1) Task A320-A-53-XX-1381-01001-90AA-A - Administrative**

**Procedure**

Confirm in the applicable aircraft records that you have completed all the work defined in this Service Bulletin task set as required.

#### **APPENDIX**

#### **A. REPORTING SHEET**

TITLE:	FUSELAGE - NOSE FORWARD FUSELAGE - REDESIGN OF THE DOUBLE JOGGLE AREA FRAME 16 LHS
MODIFICATION No.:	160876P15989

#### **(1) SB Reporting status**

This Service Bulletin will only be incorporated into affected customized Maintenance and Flight Operations Products if it is duly reported to Airbus.

#### **(2) GENERAL information**

The SB Reporting policy is published in ISI 00.00.00135. This document provides information regarding: the SB Reporting means and benefits, the update of customized Maintenance Products and customized Flight Operations Products.

If this Service Bulletin has an operational impact, refer to paragraph "Flight Operations Products" for further information on the update of affected Flight Operations Products.

#### **(3) SB Reporting procedure**

Standard practice to report SB is to use the online reporting application on AirbusWorld.

Refer to ISI 00.00.00179:

- For complete information on reporting means to Airbus, Question 2 "What are the standard practices for SB Reporting?"
- If this SB requires previous or simultaneous accomplishment of other SBs, Question 3 "What about the reporting of prerequisite Service Bulletins?"

**NOTE:** ISI 00.00.00179 covers all the frequently asked questions about SB Reporting. It is revised on a regular basis.

**B. QUALITY PERCEPTION FORM**

Use this form to tell us what is your perception of the quality of this Service Bulletin.

The reported data that you provide us will be used to analyse areas of difficulties and to take corrective action to further improve the quality of our Service Bulletin.

We thank you for the time you have taken in completing this form.

Quality rating of this SB	4	3	2	1
Quality rating of the Accomplishment Instructions	4	3	2	1
Quality rating of the Illustrations	4	3	2	1
Is this SB easy to understand ?	Y / N			

**NOTE:** Please rate on a scale of 1 to 4, with 4 being the highest score

If you have difficulties in the accomplishment of this SB please quote below the area(s) and give a short description of the issue.

	Planning		Material		Instructions
X	Applicability	X	Tooling	X	Preparation
X	Reason	X	List of Materials Operator Supplied	X	Mod/Inspection
X	Manpower	X	Kit content	X	Test
X	References	X	Re-identification	X	Close-up
X	Publication			X	Illustrations
X	Industry Support				

Comments :

Operator :  
Name/Title

Date :

Please return this form to :

AIRBUS  
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31700 BLAGNAC  
FRANCE

Or via your Resident Customer Support Office.