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MANDATORY MANDATORY MANDATORY

ATA SYSTEM: 53

**TITLE: FUSELAGE - CENTER FUSELAGE - CIRCUMFERENTIAL JOINTS AT
FRAME 45 AND 54 FATIGUE LIFE IMPROVEMENT.**

MODIFICATION No.: 52911S16337

This page transmits Revision No.04 of Service Bulletin No.A330-53-3144

ADDITIONAL WORK

****CONF ALL**

No additional work is required by this revision for aircraft modified by any previous issue.

REASON

Revision No. 04 issued to inform the operators that this Service Bulletin is rendered mandatory.

Further to the issuance in 2015 of Modification Service Bulletins related to Widespread Fatigue Damage (WFD), compliance thresholds have been adjusted or refined per A/C Weight Variants (WV) Group in order not to penalize all the fleet with the lowest global modification embodiment threshold.

CHANGES

The main changes of this revision are:

- effectivity updated,
- compliance classification becomes mandatory and accomplishment timescale updated,
- kits 533144A01 and 533144A02 updated,
- kits procurement address updated,
- minor changes applied.

SUMMARY		
GENERAL EVALUATION	GENERAL EVALUATION TABLE UPDATED	R
MATERIAL PRICE INFORMATION	MATERIAL PRICE INFORMATION TABLE UPDATED	R

SERVICE BULLETIN
REVISION TRANSMITTAL SHEET

	MATERIAL PRICE INFORMATION TABLE UPDATED	R
EFFECTIVITY	OPERATOR LIST UPDATED	R
REFERENCES / REPERCUSSIONS	REFERENCES/REPERCUSSIONS TABLE UPDATED	R
PLANNING INFORMATION		
EFFECTIVITY	EFFECTIVITY RELATED INFORMATION UPDATED	R
Configuration definition		
CONF 001	CONFIGURATION DEFINITION UPDATED	R
CONF 002	CONFIGURATION DEFINITION UPDATED	R
Material Effectivity	MATERIAL EFFECTIVITY UPDATED MATERIAL SET UPDATED MATERIAL SET QUANTITY UPDATED	R
	MATERIAL EFFECTIVITY UPDATED MATERIAL SET UPDATED MATERIAL SET QUANTITY UPDATED	R
COMPLIANCE		
Classification	CLASSIFICATION UPDATED	R
Accomplishment Timescale	ACCOMPLISHMENT TIMESCALE UPDATED	R
REFERENCES	REFERENCED DOCUMENTATION UPDATED	R
	REFERENCED DOCUMENTATION UPDATED	R
MATERIAL INFORMATION		
MATERIAL - PRICE AND AVAILABILITY		
Procurement Addresses	PROCUREMENT ADDRESSES UPDATED MATERIAL SET UPDATED	R
Price and Availability	PRICE AND AVAILABILITY UPDATED MATERIAL AVAILABILITY UPDATED MATERIAL PRICE UPDATED MATERIAL SET UPDATED	R
INDUSTRY SUPPORT INFORMATION	INDUSTRY SUPPORT INFORMATION UPDATED	R
LIST OF COMPONENTS		
Kit 533144A01R04	PART MATERIAL SET UPDATED MATERIAL SET LABEL UPDATED PART NUMBER UPDATED KEYWORD UPDATED	R
Kit 533144A02R03	PART MATERIAL SET UPDATED MATERIAL SET LABEL UPDATED PART NUMBER UPDATED KEYWORD UPDATED	R
ACCOMPLISHMENT INSTRUCTIONS		
TASK 533144- 831-801-001-MODIFICATION	TASK SOLUTION UPDATED NOTE UPDATED	R
Subtask 533144-831-005-002	SUBTASK SOLUTION UPDATED PART NUMBER UPDATED KEYWORD UPDATED MATERIAL LIST UPDATED	R

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Subtask 533144-831-006-001	SUBTASK SOLUTION UPDATED PART NUMBER UPDATED KEYWORD UPDATED MATERIAL LIST UPDATED	R
Subtask 533144-831-007-001	SUBTASK SOLUTION UPDATED PART NUMBER UPDATED KEYWORD UPDATED MATERIAL LIST UPDATED	R
Subtask 533144-831-008-001	SUBTASK SOLUTION UPDATED PART NUMBER UPDATED KEYWORD UPDATED MATERIAL LIST UPDATED	R
Subtask 533144-831-009-001	SUBTASK SOLUTION UPDATED PART NUMBER UPDATED KEYWORD UPDATED MATERIAL LIST UPDATED	R
Subtask 533144-831-010-001	SUBTASK SOLUTION UPDATED PART NUMBER UPDATED KEYWORD UPDATED MATERIAL LIST UPDATED	R
Subtask 533144-831-005-002	SUBTASK SOLUTION UPDATED PART NUMBER UPDATED KEYWORD UPDATED MATERIAL LIST UPDATED	R
Subtask 533144-831-006-001	SUBTASK SOLUTION UPDATED PART NUMBER UPDATED KEYWORD UPDATED MATERIAL LIST UPDATED	R
Subtask 533144-831-007-001	SUBTASK SOLUTION UPDATED PART NUMBER UPDATED KEYWORD UPDATED MATERIAL LIST UPDATED	R
Subtask 533144-831-008-001	SUBTASK SOLUTION UPDATED PART NUMBER UPDATED KEYWORD UPDATED MATERIAL LIST UPDATED	R
Fig. A-FBAAA		
Fig. A-FBAAA Sheet 04	SHEET UPDATED	R
Fig. A-FBAAA Sheet 07	SHEET UPDATED	R
Fig. A-FBBAA		
Fig. A-FBBAA Sheet 03	SHEET UPDATED	R
Fig. A-FBBAA Sheet 06	SHEET UPDATED	R

FILLING 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.

5 DATE: Aug 23/05

SERVICE BULLETIN No.: A330-53-3144

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HISTORY OF PREVIOUS REVISIONS

Revision No. 01 issued to integrate the increase of the number of holes to be oversized and cold worked on each circumferential joints.

Revision 02 of this Service Bulletin issued to correct the part number of some bolts.

Revision No. 03 of this Service Bulletin is issued to update the Accomplishment Timescale.

REVISION SEQUENCE

ORIGINAL: Aug 23/05

REVISION No. : 02 - Apr 20/11

REVISION No. : 03 - Jan 15/15

REVISION No. : 04 - Nov 23/15

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

MANDATORY MANDATORY MANDATORY

ATA SYSTEM: 53

**TITLE: FUSELAGE - CENTER FUSELAGE - CIRCUMFERENTIAL JOINTS AT
FRAME 45 AND 54 FATIGUE LIFE IMPROVEMENT.**

****CONF ALL**

MODIFICATIONS

MODIFICATION CLASSIFICATION					
MAJOR	52911S16337				
MINOR	None				

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.

REASON/DESCRIPTION/OPERATIONAL CONSEQUENCES

Several damages occurred at FR45, FR53.3 and FR54 circumferential junctions on A330/A340 aircraft fatigue test specimen. Several modifications have been introduced in production line to increase the lateral and upper circumferential straps thickness. A further production modification No. 49202 adds external circumferential straps at FR45, FR53.3 and FR54 for A330 and A340 aircraft. A retrofit modification No. 49403 has also been defined for A330 aircraft pre-mod. No. 49202, consisting in adding external circumferential straps at FR53.3 with fasteners oversizing, through mandatory Service bulletin No. A330-53-3127 and A330-53-3143. Inspection by rototest of circumferential junctions lapping areas is too penalizing (removal of fasteners at each inspection and re-installation with possible hole oversizing) and alternative method by X-ray is also a heavy task with much lower intervals in the Maintenance Review Board (MRB). Therefore operators have asked for a terminative action when removing the fasteners for rototest inspection. In order to cancel this task, new retrofit modification No. 52911 has been defined for A330-200/-300 aircraft premod No. 49202 (at FR45) and A330-301/321/322/341/342 aircraft premod No. 41652 (at FR54). This modification consists in oversizing fastener holes to next nominal diameter and fastening with cold working and high interference fit.

This Service Bulletin recommends oversizing to next nominal diameter and fastening with cold working and high interference fit of four fasteners rows holes between STGR3 and 5 and between STGR11 and 13 for FR45, and between STGR 4 and 5 for FR54.



SERVICE BULLETIN SUMMARY

Accomplishment of this Service Bulletin improves the fatigue life in this area and cancels the inspection requirements of MRB - Airworthiness Limitation Items (ALI) 53-30-09 and Airworthiness Limitation Items (ALI) 53-30-41 (previously Airworthiness Limitation Items (ALI) 53-30-12) for A330 aircraft premod No. 41652 (at FR54) and premod No. 49202 (at FR45) when applicable.

Accomplishment of this Service Bulletin will reduce the maintenance tasks.

GENERAL EVALUATION

EVALUATION TABLE			
COMPLIANCE	MANDATORY (1)	CANCELS INSPECTION SB	NO
POTENTIAL AD	YES	A/C OPERATION AFFECTED	NO
RELIABILITY AFFECTED	NO	PAX COMFORT AFFECTED	NO
COST SAVING	NO	ETOPS AFFECTED	NO
STRUCTURAL LIFE EXTN	YES	VENDOR SB INVOLVED	NO

NOTE (1): Service Bulletin must be accomplished.

MATERIAL PRICE INFORMATION

****CONF 001**

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	QTY PER A/C	PRICE PER A/C (USD)	MAIN PARTS
Kit 533144A02R03	1	2,250.00	Bolts, nuts
Kit 533144A01R04	1	5,100.00	Bolts, nuts
TOTAL		7,350.00	
Standard tool TOOLA01	1	See SB	

****CONF 002**

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	QTY PER A/C	PRICE PER A/C (USD)	MAIN PARTS
Kit 533144A01R04	1	5,100.00	Bolts, nuts
Standard tool TOOLA01	1	See SB	

EFFECTIVITY

****CONF ALL**

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

38W	ABD	ACA	ACI	AEA	AFR	AIB	ALK	ARG	AZA	AZU	BEL	BER
BGH	CPA	CRL	CSA	DGA	EDW	EIN	EZX	FWI	G8E	GFA	GIA	GRL
HDA	HFY	HVN	KAL	MAS	MLM	MON	OHY	PAL	QAF	QFA	QTR	RSY
SAI	SAS	TAE	TAM	TAP	TCX	THA	THY	TSC	UAE	USA	VKG	WRC
XAX	XLF											

CONCURRENT REQUIREMENTS

None

REFERENCES / REPERCUSSIONS

TFU	None
OEB	None
AOT	None
SIL	None
ISI	None
LINE MAINTENANCE AFFECTED	No
LIFE LIMIT	None

NATURE OF THE WORK

AIRCRAFT	YES
EQUIPMENT	NO
HARD	NO
SOFT	NO
OBRM	NO

MANPOWER****CONF 001**

Task 533144-831-801-001: MODIFICATION	
TOTAL MANHOURS	162.00
ELAPSED TIME (HOURS)	66.00

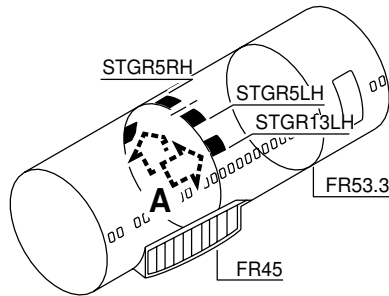
****CONF 002**

Task 533144-831-801-001: MODIFICATION	
TOTAL MANHOURS	114.00
ELAPSED TIME (HOURS)	66.00

APPENDICES****CONF ALL**

Appendix 01 - Elapsed Time Assumption

****CONF ALL**

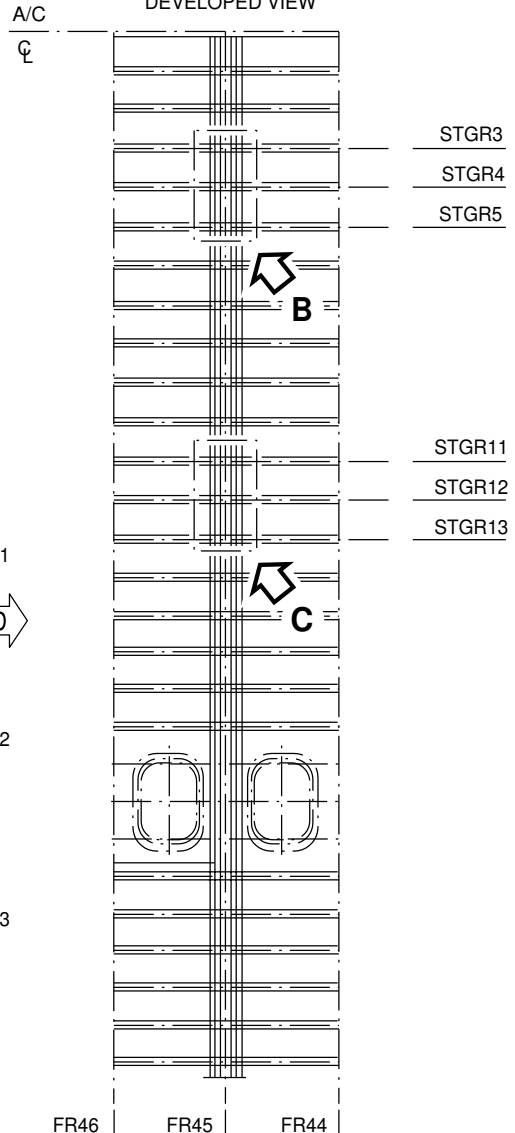


A

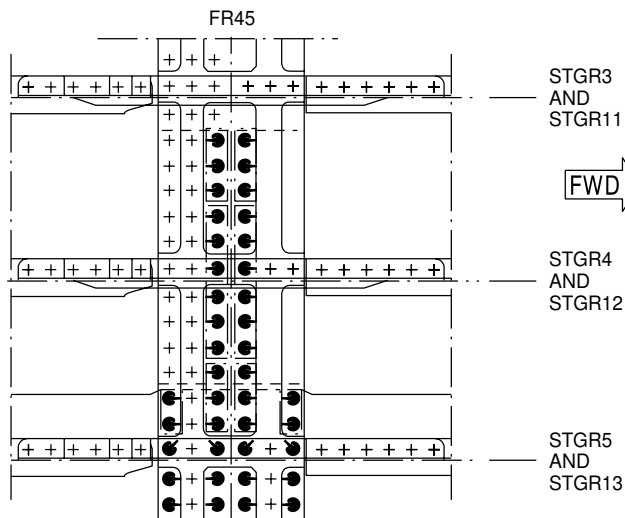
BEFORE/AFTER

LH SIDE SHOWN
RH SIDE SYMMETRICAL

DEVELOPED VIEW



B AND C

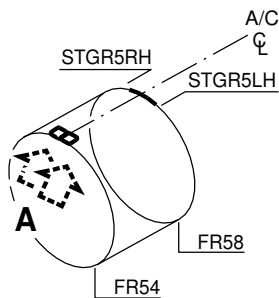


REPLACEMENT OF THE FASTENERS BETWEEN
STGR3 AND STGR5 AND BETWEEN STGR11
AND STGR13 WITH COLD EXPANSION
OF THE HOLES.

G_SB_533144_5_SUAA_01_01

Figure A-FSUAA - Sheet 01

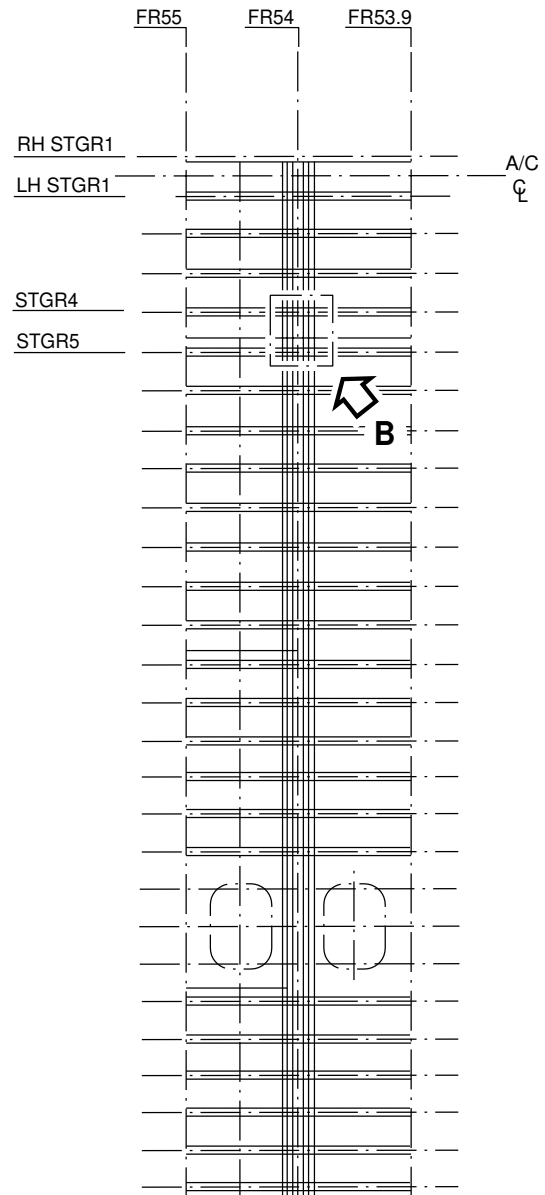
****CONF 001**



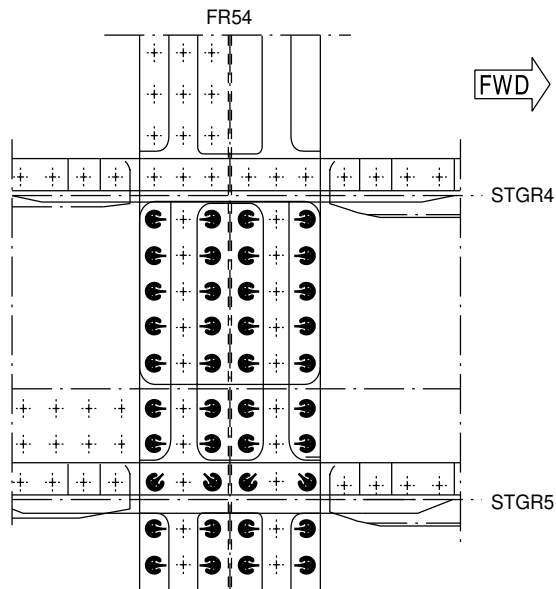
A

BEFORE/AFTER

LH SIDE SHOWN
RH SIDE SYMMETRICAL
DEVELOPED VIEW



B



REPLACEMENT OF THE FASTENERS WITH
COLD EXPANSION OF THE HOLES.

G_SB_533144_5_SVAA_01_01

Figure A-FSVAA - Sheet 01



SERVICE BULLETIN
SUMMARY

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MANDATORY MANDATORY MANDATORY

ATA SYSTEM: 53

**TITLE: FUSELAGE - CENTER FUSELAGE - CIRCUMFERENTIAL JOINTS AT
FRAME 45 AND 54 FATIGUE LIFE IMPROVEMENT.**

MODIFICATION No.: 52911S16337

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1. PLANNING INFORMATION

****CONF ALL**

A. EFFECTIVITY

NOTE: This modification is applicable by Service Bulletin only.

NOTE: Modification. No. 49202S16307 (FUSELAGE - CENTER FUSELAGE - REINFORCE SECTION 15/21) is embodied before delivery on aircraft with Manufacturer Serial Number (MSN) 0511 , 0513 , 0515 , 0516 , 0518 , 0519 , 0521 , 0524 and subsequent.

NOTE: Modification. No. 41652S11927 (FUSELAGE - SECTION 15 - PROVIDE COMMON STRUCTURAL REINFORCEMENTS AND DEFINE REPERCUSSIONS ON SYSTEMS) is embodied before delivery on aircraft with Manufacturer Serial Number (MSN) 0113 and subsequent.

(1) Models

330-202	330-203	330-223	330-243	330-301	330-321	330-322	330-323
330-341	330-342	330-343					

(2) Effectivity by MSN

0012 0017 0030 0037 0045 0050 0054-0055 0060 0062 0064-0065 0070-0072
0082-0083 0086-0087 0095-0096 0098-0099 0102 0106 0109 0111-0113 0116 0118

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0120-0122 0127 0132 0138 0140 0143-0144 0148 0153 0155 0162 0165 0171-0172
 0177 0181 0189 0195 0198 0200 0206 0209 0211 0219 0222-0224 0226 0229-0232
 0234 0238 0240-0241 0244 0247-0251 0253-0256 0258-0259 0261-0262 0265-0267
 0269 0271-0272 0275-0277 0279 0281 0283-0288 0290-0291 0293-0296 0299-0301
 0303 0305-0306 0308-0309 0311-0317 0320 0322-0324 0326 0328 0330 0333-0334
 0337-0340 0342-0346 0348-0351 0353 0356-0358 0361-0362 0364-0366 0368-0370
 0372 0375 0380 0382 0384 0386 0388-0389 0392-0393 0396-0398 0400-0401
 0403-0405 0407-0409 0412 0418-0423 0425 0427-0428 0432 0437 0439 0441
 0443-0444 0448 0451-0452 0454-0456 0458 0461-0463 0465-0466 0469 0472-0473
 0476-0477 0479-0481 0484 0486-0487 0489-0491 0493-0494 0496-0498 0500-0510
 0512 0522

(3) Effectivity by Operator

The Operator/MSN relationship is provided for information only and is correct at the time of issue in accordance with the information available to AIRBUS. Any future changes resulting from transfer of an aircraft from one operator to another will not be reflected in this list unless the Service Bulletin is revised for another reason.

OPERATOR	MSN
38W	0401
ABD	0343
ACA	0277 0279 0284 0344 0400 0408 0412 0419
ACI	0507 0510
AEA	0461 0505
AFR	0422 0443 0448 0458 0465 0481 0498 0500 0502 0503
AIB	0345 0437
ALK	0303 0306 0311 0313 0404 0456
ARG	0290 0300 0358 0364
AZA	0272 0339
AZU	0365 0372 0462 0494
BEL	0030 0037 0045 0082 0095 0229 0249 0324
BER	0288 0322 0403 0432 0444 0454 0469 0476 0493
BGH	0255
CPA	0102 0113 0121 0386 0389 0393 0418 0420 0421 0423 0439
CRL	0285 0320
CSA	0425
DGA	0240
EDW	0291
EIN	0269 0330 0397
EZX	0261
FWI	0253
G8E	0189 0200
GFA	0276 0281 0286 0287 0334 0340
GIA	0138 0140 0144 0148 0153 0165
GRL	0230
HDA	0012 0017 0071 0083 0099 0106 0109 0118 0155 0234 0244 0405 0479 0512
HFY	0096 0127 0211 0262

OPERATOR	MSN
HVN	0275 0294 0299 0366
KAL	0162 0172 0206 0219 0222 0226 0241 0256 0258 0267 0338 0350 0351 0368 0428 0484 0490
MAS	0116
MLM	0451
MON	0265
OHY	0072 0087 0098 0143 0353 0362
PAL	0198
QAF	0487
QFA	0506 0508 0522
QTR	0441 0473 0489
RSY	0120 0171
SAI	0055 0070 0086
SAS	0496 0497
TAE	0348
TAM	0232 0238 0247 0259 0361 0466 0472
TAP	0181 0195 0223 0305 0308 0312 0317 0477 0486
TCX	0254 0266 0301 0398
THA	0050 0060 0062 0064 0065 0112 0122 0209 0224 0231 0346
THY	0463 0504
TSC	0111 0132 0177 0250 0271 0369 0407 0427 0480
UAE	0248 0251 0283 0293 0295 0314 0316 0326 0328 0382 0384 0392 0396 0409 0452 0455 0491 0509
USA	0315 0323 0333 0337 0342 0370 0375 0380 0388
VKG	0309 0349 0356 0357
WRC	0296
XAX	0054
XLF	0501

(4) Configuration by MSN

MSN	CONFIGURATION
0012 0017 0030 0037 0045 0050 0054 0055 0060 0062 0064 0065 0070 0071 0072 0082 0083 0086 0087 0095 0096 0098 0099 0102 0106 0109 0111 0112	001

MSN	CONFIGURATION
0113 0116 0118 0120 0121 0122 0127 0132 0138 0140 0143 0144 0148 0153 0155 0162 0165 0171 0172 0177 0181 0189 0195 0198 0200 0206 0209 0211 0219 0222 0223 0224 0226 0229 0230 0231 0232 0234 0238 0240 0241 0244 0247 0248 0249 0250 0251 0253 0254 0255 0256 0258 0259 0261 0262 0265 0266 0267 0269 0271 0272 0275 0276 0277 0279 0281 0283 0284 0285 0286 0287 0288 0290 0291 0293 0294 0295 0296 0299 0300 0301 0303 0305 0306 0308 0309 0311 0312 0313 0314 0315 0316 0317 0320 0322 0323 0324 0326 0328 0330 0333 0334 0337 0338 0339 0340 0342 0343 0344 0345 0346 0348 0349 0350 0351 0353 0356 0357 0358 0361 0362 0364 0365 0366 0368 0369 0370 0372 0375 0380 0382 0384 0386 0388 0389 0392 0393 0396 0397 0398 0400 0401 0403 0404 0405 0407 0408 0409 0412 0418 0419 0420 0421 0422 0423 0425 0427 0428 0432 0437 0439 0441 0443 0444 0448 0451 0452 0454 0455 0456 0458 0461 0462 0463 0465 0466 0469 0472 0473 0476 0477 0479 0480 0481 0484 0486 0487 0489 0490 0491 0493 0494 0496 0497 0498 0500 0501 0502 0503 0504 0505 0506 0507 0508 0509 0510 0512 0522	002

(5) Configuration definition

****CONF 001**

Config. 001 is valid for aircraft on which Mod. No. 49202S16307 and Mod. No. 41652S11927 are not embodied.

****CONF 002**

Config. 002 is valid for aircraft on which Mod. No. 49202S16307 is not embodied and Mod. No. 41652S11927 is embodied.

(6) Material Effectivity

****CONF 001**

MATERIAL	QTY PER A/C	SEE NOTES
Kit 533144A02R03	1	
Kit 533144A01R04	1	
Consumable CMLA01	As required	
Standard tool TOOLA01	1	

****CONF 002**

MATERIAL	QTY PER A/C	SEE NOTES
Kit 533144A01R04	1	
Consumable CMLA01	As required	
Standard tool TOOLA01	1	

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

None

C. REASON**(1) History**

Several damages occurred at FR45, FR53.3 and FR54 circumferential junctions on A330/A340 aircraft fatigue test specimen. Several modifications have been introduced in production line to increase the lateral and upper circumferential straps thickness. A further production modification No. 49202 adds external circumferential straps at FR45, FR53.3 and FR54 for A330 and A340 aircraft. A retrofit modification No. 49403 has also been defined for A330 aircraft pre-mod. No. 49202, consisting in adding external circumferential straps at FR53.3 with fasteners oversizing, through mandatory Service bulletin No. A330-53-3127 and A330-53-3143. Inspection by rototest of circumferential junctions lapping areas is too penalizing (removal of fasteners at each inspection and re-installation with possible hole oversizing) and alternative method by X-ray is also a heavy task with much lower intervals in the Maintenance Review Board (MRB). Therefore operators have asked for a terminative action when removing the fasteners for rototest inspection. In order to cancel this task, new retrofit modification No. 52911 has been defined for A330-200/-300 aircraft premod No. 49202 (at FR45) and A330-301/321/322/341/342 aircraft premod No. 41652 (at FR54). This modification consists in oversizing fastener holes to next nominal diameter and fastening with cold working and high interference fit.

(2) Objective/Action

This Service Bulletin recommends oversizing to next nominal diameter and fastening with cold working and high interference fit of four fasteners rows holes between STGR3 and 5 and between STGR11 and 13 for FR45, and between STGR 4 and 5 for FR54.

(3) Advantages

Accomplishment of this Service Bulletin improves the fatigue life in this area and cancels the inspection requirements of MRB - Airworthiness Limitation Items (ALI) 53-30-09 and Airworthiness Limitation Items (ALI) 53-30-41 (previously Airworthiness Limitation Items (ALI) 53-30-12) for A330 aircraft premod No. 41652 (at FR54) and premod No. 49202 (at FR45) when applicable.

(4) Operational/Maintenance Consequences

Accomplishment of this Service Bulletin will reduce the maintenance tasks.

D. DESCRIPTION

To accomplish this Service Bulletin it is necessary to :

****CONF 001**

Task 533144-831-801-001: MODIFICATION

- (1) Replace the fasteners from fuselage at FR45 between LH STGR3 and LH STGR5.
- (2) Replace the fasteners from fuselage at FR45 between LH STGR11 and LH STGR13.
- (3) Replace the fasteners from fuselage at FR45 between RH STGR3 and RH STGR5.
- (4) Replace the fasteners from fuselage at FR45 between RH STGR11 and RH STGR13.
- (5) Replace the fasteners from fuselage at FR54 between LH STGR4 and LH STGR5.
- (6) Replace the fasteners from fuselage at FR54 between RH STGR4 and RH STGR5.

****CONF 002**

Task 533144-831-801-001: MODIFICATION

- (1) Replace the fasteners from fuselage at FR45 between LH STGR3 and LH STGR5.
- (2) Replace the fasteners from fuselage at FR45 between LH STGR11 and LH STGR13.
- (3) Replace the fasteners from fuselage at FR45 between RH STGR3 and RH STGR5.
- (4) Replace the fasteners from fuselage at FR45 between RH STGR11 and RH STGR13.

****CONF ALL****E. COMPLIANCE**

- (1) Classification

MANDATORY: Service Bulletin must be accomplished.

- (2) Accomplishment Timescale

This Service Bulletin has been classified Mandatory. It is expected that an Airworthiness Directive (AD) published by the European Aviation Safety Agency (EASA) will be issued to confirm this classification. It is anticipated that the AD will confirm the thresholds given but reference should be made to the AD for confirmation of the mandated accomplishment timescale.

Aircraft Series	Weight Variant (WV) Group See NOTE (*)	Weight Variant (WV)	Aircraft utilization See NOTE (**) See NOTE (***)	Threshold
A330-200	GR32A	020, 021, 022, 023, 024, 025, 026 and 027	Short Range (SR)	32500 Flight Cycles (FC) / 113000 Flight Hours (FH)
			Long Range (LR)	26600 FC / 173000 FH
A330-300	GR33A	000, 001, 002, 003 and 004	SR	23770 FC / 71330 FH
			LR	20410 FC / 122460 FH
	GR33B	010, 011, 012, 013 and 014	SR	27600 FC / 83000 FH
			LR	23700 FC / 142000 FH
	GR33C	020, 024, 025, 026 and 027	SR	23300 FC / 70000 FH
			LR	20000 FC / 120000 FH
	GR33D	022	SR	22700 FC / 68300 FH
			LR	19500 FC / 117200 FH
NOTE (*): For definition of the aircraft Weight Variants (WV) Groups, refer to Airworthiness Limitation Section (ALS) Part 2 NOTE (**): SR = FC-optimized set for aircraft in Short Range operations, refer to Airworthiness Limitation Section (ALS) Part 2 NOTE (***) : LR = FH-optimized set for aircraft in Long Range operations, refer to Airworthiness Limitation Section (ALS) Part 2				

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 effectivity 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

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.

****CONF 001**

Task 533144-831-801-001: MODIFICATION	
Get Access	8.00
On Aircraft	
Replace the fasteners from fuselage at FR45 between LH STGR3 and LH STGR5.	24.00
Replace the fasteners from fuselage at FR45 between LH STGR11 and LH STGR13.	24.00
Replace the fasteners from fuselage at FR45 between RH STGR3 and RH STGR5.	24.00
Replace the fasteners from fuselage at FR45 between RH STGR11 and RH STGR13.	24.00
Replace the fasteners from fuselage at FR54 between LH STGR4 and LH STGR5.	24.00
Replace the fasteners from fuselage at FR54 between RH STGR4 and RH STGR5.	24.00
Tests	1.00
Close-Up	9.00
TOTAL MANHOURS	162.00
ELAPSED TIME (HOURS)	66.00

NOTE: For an explanation of the manhours and elapsed time, refer to the Gantt Chart, [Fig. A-FAAAA](#) given in Appendix 01 - Elapsed Time Assumption .

****CONF 002**

Task 533144-831-801-001: MODIFICATION	
Get Access	8.00
On Aircraft	
Replace the fasteners from fuselage at FR45 between LH STGR3 and LH STGR5.	24.00
Replace the fasteners from fuselage at FR45 between LH STGR11 and LH STGR13.	24.00
Replace the fasteners from fuselage at FR45 between RH STGR3 and RH STGR5.	24.00
Replace the fasteners from fuselage at FR45 between RH STGR11 and RH STGR13.	24.00
Tests	1.00
Close-Up	9.00
TOTAL MANHOURS	114.00
ELAPSED TIME (HOURS)	66.00

NOTE: For an explanation of the manhours and elapsed time, refer to the Gantt Chart, [Fig. A-FAAAB](#) given in Appendix 01 - Elapsed Time Assumption .

****CONF ALL**
H. WEIGHT AND BALANCE

Not Changed

I. ELECTRICAL LOAD DATA

Not Changed

J. REFERENCES
****CONF 001**

Airworthiness Limitation Item (ALI)	Airworthiness Limitation Items (ALI) 53-30-12 Airworthiness Limitation Items (ALI) 53-30-41 Airworthiness Limitation Items (ALI) 53-30-09		
Airworthiness Limitation Section (ALS)	Airworthiness Limitation Section (ALS) Part 2		
Aircraft Maintenance Manual (AMM)	06-20-00 20-21-11 23-73-46	06-31-53 21-20-00 25-23-41	12-34-24 21-21-64 25-80-00
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-55-00		
Non Destructive Test Manual (NTM)	51-10-01		
Service Bulletin (SB)	A330-53-3127 A330-53-3143		
Service Information Letter (SIL)	SIL 51-012		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-21-11 51-40-00 51-44-00 51-75-12	51-23-11 51-42-00 51-46-11	51-24-00 51-43-00 51-48-00

****CONF 002**

Airworthiness Limitation Item (ALI)	Airworthiness Limitation Items (ALI) 53-30-12 Airworthiness Limitation Items (ALI) 53-30-41 Airworthiness Limitation Items (ALI) 53-30-09		
Airworthiness Limitation Section (ALS)	Airworthiness Limitation Section (ALS) Part 2		
Aircraft Maintenance Manual (AMM)	06-20-00 20-21-11 23-73-46	06-31-53 21-20-00 25-23-41	12-34-24 21-21-64 25-80-00
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-55-00		

SERVICE BULLETIN

Non Destructive Test Manual (NTM)	51-10-01
Service Bulletin (SB)	A330-53-3127 A330-53-3143
Service Information Letter (SIL)	SIL 51-012
Standards Manual (SM)	
Structural Repair Manual (SRM)	51-21-11 51-23-11 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-46-11 51-48-00 51-75-12

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

Airworthiness Limitation Section (ALS)	Part 2
Maintenance Planning Document (MPD)	533009-01-1 533009-01-2 533009-01-3 533009-01-4 533009-02-1 533009-02-2 533009-02-3 533009-02-4

L. INTERCHANGEABILITY/MIXABILITY

Not Applicable

M. SPARES

None

2. MATERIAL INFORMATION

****CONF ALL**

A. MATERIAL - PRICE AND AVAILABILITY

(1) Procurement Addresses

Customers with aircraft shown in the effectivity of this Service Bulletin should send a purchase order to AIRBUS. Quote the number of this Service Bulletin. The address is:

Kit 533144A01R04 Kit 533144A02R03	AIRBUS Material, Logistics and Suppliers ATP II B, Hein-Sass Weg 14 21129 HAMBURG GERMANY For ordering by internet: http://spares.airbus.com For ordering by E-mail: airbus.kit@airbus.com Telephone Hotlines: A350/A380: +49 40 743 51775 A330/340, A300/310: +49 40 743 51616 A318/319/320/321: +49 40 743 51660
--------------------------------------	---

(2) Price and Availability

Kit 533144A01R04	
Cost	5,100.00 USD
Availability	60 calendar days from receipt of order

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.

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 AirbusSpares portal or through a request for quotation to airbus.kit@airbus.com.

Kit 533144A02R03	
Cost	2,250.00 USD
Availability	60 calendar days from receipt of order

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.

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 AirbusSpares portal or through a request for quotation to airbus.kit@airbus.com.

B. INDUSTRY SUPPORT INFORMATION

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

This Service Bulletin is the subject of an AIRBUS monitored retrofit campaign.

For the organisation of this retrofit, you are kindly requested to contact AIRBUS retrofit management department.

AIRBUS
CUSTOMER SERVICES DIRECTORATE
1 Rond Point Maurice Bellonte
31707 BLAGNAC CEDEX
France
Tel : (33) 5 67 19 06 22
E-mail : monitored.retrofit@airbus.com
Fax : (33) 5 61 93 27 45

C. LIST OF COMPONENTS

Kit 533144A01R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
10	EN6114V5-8	16	BOLT				
11	EN6114V5-9	42	BOLT				
12	EN6114V5-10	40	BOLT				
13	EN6114V5-11	46	BOLT				
15	ASNA2531-5	160	NUT				
20	EN6114V5-6	16	BOLT				

NOTE: If you find part numbers of hardware components in the related kit(s) which you cannot identify in the LIST OF COMPONENTS of this Service Bulletin, refer to Standards Manual (SM). The SM will give you the correct part number to part number relationship.

Kit 533144A02R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	EN6114V4-7	14	BOLT				
2	EN6114V4-8	8	BOLT				
3	EN6114V4-9	16	BOLT				
4	EN6114V4-10	20	BOLT				
6	ASNA2531-4	80	NUT				
21	EN6114V4-4	2	BOLT				
22	EN6114V4-5	6	BOLT				
23	EN6114V4-6	14	BOLT				

NOTE: If you find part numbers of hardware components in the related kit(s) which you cannot identify in the LIST OF COMPONENTS of this Service Bulletin, refer to Standards Manual (SM). The SM will give you the correct part number to part number relationship.

D. LIST OF MATERIALS - OPERATOR SUPPLIED

(1) Consumable Materials

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer-Structure	04CMA2	As required	
	Primer Polyurethane Paint- Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane-External Structure	04JAA3	As required	
	Top Coat Polyurethane-Decorative External Structure	04JMD3	As required	
	Top Coat Polyurethane-Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conversion	10ABC1	As required	

(2) Components

None

(3) Equipment

None

E. PARTS TO BE RE-IDENTIFIED BY OPERATOR

None

F. TOOLING

(1) Tooling - Price and Availability

(a) Procurement Addresses

Operators interested in obtaining the FTI tool kits should contact:

Standard tool TOOLA01	Fatigue Technology Inc. 401 Andover Park East SEATTLE, WA 98188-7605 USA Internet: http://www.fatiguetechnology.com Phone: (206) 2462010 Fax: (206) 2449886
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(b) Price and Availability

Standard tool TOOLA01

Procurement to be negotiated directly with FTI.

(2) Tools

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

- Equipment and materials for check of holes as per NTM 51-10-01, Part 6, Procedure A.

Standard tool TOOLA01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533144-1	Durable Tooling	1	(1)
	EKA330533144-1	Expendable Tooling	1	(2)
	FTIA330533144-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the following tool kit numbers for cold expansion: For the definition of capital, durable and expendable tools, refer to SIL 51-012.

NOTE (1): Durable tooling: Ref. DK-A330-53-3144-1

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 SIL 51-012.

NOTE (2): Expendable tooling: Ref. EK-A330-53-3144-1

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.

NOTE (3): Capital tooling: Ref. FTI-A330-53-3144-1

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 FTI.

(3) Special Tools

None

3. ACCOMPLISHMENT INSTRUCTIONS

Task 533144-831-801-001 - 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 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 is classified mandatory or expected to be classified mandatory by an Airworthiness Directive (AD). The paragraphs 3.C. and 3.D. in these accomplishment instructions are Required for Compliance (RC) and must be done to comply with the AD. Other paragraphs are recommended and may be deviated from, done as part of other actions or done with accepted methods different from those given in the Service Bulletin, as long as the RC paragraphs can be done and the aircraft can be put back into a serviceable condition.

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

Task Associated Data

****CONF 001**

Zone	
250 260	
Manpower	
TOTAL MANHOURS	162.00
ELAPSED TIME (HOURS)	66.00

****CONF 002**

Zone	
250	
Manpower	
TOTAL MANHOURS	114.00
ELAPSED TIME (HOURS)	66.00

****CONF ALL**

A. GENERAL

****CONF 001**

(1) Subtask 533144-831-001-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 06-31-53, Page Block 001 Task 20-21-11-911-801
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-46-11 51-48-00 51-75-12

- (a) For the Frame (FR) identification, refer to AMM 06-31-53, Page Block 001.
- (b) For the identification of zones, refer to AMM 06-20-00, Page Block 001.
- (c) For the specification of materials (Mat. No.) given in this Service Bulletin, refer to the Consumable Material List (CML).
- (d) Remove and install fasteners in accordance with SRM 51-42-00.

- (e) Do the cold expansion of the fastener holes in accordance with SRM 51-48-00.
- (f) Countersink the holes in accordance with SRM 51-46-11.
- (g) Protect the areas to prevent damage to the equipment and structure and all the parts.
- (h) Apply sealant in accordance with SRM 51-24-00.
- (i) To torque tighten the standard threaded fasteners, refer to AMM Task 20-21-11-911-801.
- (j) Obtain alternative and substitute fastener data in accordance with SRM 51-43-00.
- (k) Obtain fastener hole diameters and drill data in accordance with SRM 51-44-00.
- (l) If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with SRM 51-40-00'Mating Part' column.
- (m) 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.
- (n) Renew the protective finish in accordance with SRM 51-75-12.

(2) Subtask 533144-900-002-001 - Documentation

Manpower Resources	
Skills	NON SPECIFIC

Write in the applicable aircraft records that you have done all the work given in the Service Bulletin.

****CONF 002****(1) Subtask 533144-831-001-001 - Standard Practices**

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 06-31-53, Page Block 001 Task 20-21-11-911-801
Consumable Material List (CML)	

References	
Structural Repair Manual (SRM)	51-24-00
	51-40-00
	51-42-00
	51-43-00
	51-44-00
	51-46-11
	51-48-00
	51-75-12

- (a) For the Frame (FR) identification, refer to AMM 06-31-53, Page Block 001.
- (b) For the identification of zones, refer to AMM 06-20-00, Page Block 001.
- (c) For the specification of materials (Mat. No.) given in this Service Bulletin, refer to the Consumable Material List (CML).
- (d) Remove and install fasteners in accordance with SRM 51-42-00.
- (e) Do the cold expansion of the fastener holes in accordance with SRM 51-48-00.
- (f) Countersink the holes in accordance with SRM 51-46-11.
- (g) Protect the areas to prevent damage to the equipment and structure and all the parts.
- (h) Apply sealant in accordance with SRM 51-24-00.
- (i) To torque tighten the standard threaded fasteners, refer to AMM Task 20-21-11-911-801.
- (j) Obtain alternative and substitute fastener data in accordance with SRM 51-43-00.
- (k) Obtain fastener hole diameters and drill data in accordance with SRM 51-44-00.
- (l) If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with SRM 51-40-00'Mating Part' column.
- (m) 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.
- (n) Renew the protective finish in accordance with SRM 51-75-12.

(2) Subtask 533144-900-002-001 - Documentation

Manpower Resources	
Skills	NON SPECIFIC

Write in the applicable aircraft records that you have done all the work given in the Service Bulletin.

****CONF ALL****B. PREPARATION******CONF 001****(1) Subtask 533144-831-003-001 - Preparation**

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 12-34-24-860-802
	Task 21-20-00-010-801
	Task 23-73-46-000-801
	Task 25-23-41-000-801
	Task 25-80-00-000-801

NOTE:

The items given in this note shall be considered as the basic Aircraft configuration before you start a maintenance task:

- Aircraft on the ground resting on landing gear (the ground safety locks and the wheel chocks are in position on the landing gear)
 - Engine shut down, thrust reversers closed and locked
 - Aircraft in clean configuration
 - Parking brake applied
 - Aircraft electrical network de-energized
 - Hydraulic systems depressurized
 - Access to the cockpit and cabin is available
 - All circuit breakers are in closed position
 - All controls in NORM, AUTO or OFF position
- (a) Make sure that the aircraft is electrically grounded, refer to AMM Task 12-34-24-860-802.
- (b) Put an access platform in position at zone 250 and zone 260.
- (c) Remove the ceiling panels 251JC for LH side and 252JC for RH side, refer to AMM Task 25-23-41-000-801.
- (d) Remove the ceiling panels 261CC and 261DC for LH side and 262CC and 262DC for RH side, refer to AMM Task 25-23-41-000-801.
- (e) Remove the air distribution ducts for an easier access to the work areas, refer to AMM Task 21-20-00-010-801.

- (f) Disengage the electrical wires and the insulation blankets from the work area, refer to AMM Task 25-80-00-000-801.

NOTE: If necessary, disengage the support plates of the decoder/encoder units 200RH11 and 200RH12 to get access to the work area. Hold the support plates because you must not pull the electrical wires. Retain the fasteners. (Refer to AMM Task 23-73-46-000-801)

****CONF 002**

(1) Subtask 533144-831-003-002 - Preparation

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 12-34-24-860-802
	Task 21-20-00-010-801
	Task 23-73-46-000-801
	Task 25-23-41-000-801
	Task 25-80-00-000-801

NOTE: The items given in this note shall be considered as the basic Aircraft configuration before you start a maintenance task:

- Aircraft on the ground resting on landing gear (the ground safety locks and the wheel chocks are in position on the landing gear)
 - Engine shut down, thrust reversers closed and locked
 - Aircraft in clean configuration
 - Parking brake applied
 - Aircraft electrical network de-energized
 - Hydraulic systems depressurized
 - Access to the cockpit and cabin is available
 - All circuit breakers are in closed position
 - All controls in NORM, AUTO or OFF position
- (a) Make sure that the aircraft is electrically grounded, refer to AMM Task 12-34-24-860-802.
- (b) Put an access platform in position at zone 250.
- (c) Remove the ceiling panels 251JC for LH side and 252JC for RH side, refer to AMM Task 25-23-41-000-801.

- (d) Remove the air distribution ducts for an easier access to the work areas, refer to AMM Task 21-20-00-010-801.
- (e) Disengage the electrical wires and the insulation blankets from the work area, refer to AMM Task 25-80-00-000-801.

NOTE: If necessary, disengage the support plates of the decoder/encoder units 200RH11 and 200RH12 to get access to the work area. Hold the support plates because you must not pull the electrical wires. Retain the fasteners. (Refer to AMM Task 23-73-46-000-801))

****CONF ALL**

C. PROCEDURE

****CONF 001**

- (1) **Subtask 533144-831-005-002 - Replace the fasteners from fuselage at FR45 between LH STGR3 and LH STGR5.**

Work Zones and Access Panels			
	Zone	Access/Work location	
	250	Work location	Frame 45 from Stringer 3 to Stringer 5

Manpower Resources	
Manhours	24.00
Minimum number of person	1
Subtask elapsed time	24.00
Skills	NON SPECIFIC

Material necessary to do the job

Kit 533144A01R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	EN6114V5-8	4	BOLT	
11	EN6114V5-9	11	BOLT	
12	EN6114V5-10	9	BOLT	
13	EN6114V5-11	12	BOLT	
15	ASNA2531-5	40	NUT	
20	EN6114V5-6	4	BOLT	

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer-Structure	04CMA2	As required	
	Primer Polyurethane Paint-Corrosion Inhibiting	04EAC2	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Top Coat Polyurethane-External Structure	04JAA3	As required	
	Top Coat Polyurethane-Decorative External Structure	04JMD3	As required	
	Top Coat Polyurethane-Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conversion	10ABC1	As required	

Standard tool TOOLA01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533144-1	Durable Tooling	1	(1)
	EKA330533144-1	Expendable Tooling	1	(2)
	FTIA330533144-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the following tool kit numbers for cold expansion:
For the definition of capital, durable and expendable tools, refer to SIL 51-012.

NOTE (1): Durable tooling: Ref. DK-A330-53-3144-1

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 SIL 51-012.

NOTE (2): Expendable tooling: Ref. EK-A330-53-3144-1

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.

NOTE (3): Capital tooling: Ref. FTI-A330-53-3144-1

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 FTI.

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-801

References	
Non Destructive Test Manual (NTM)	51-10-01 Part 6 Procedure A
Structural Repair Manual (SRM)	51-21-11 51-23-11 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-46-11 51-48-00 51-48-00 51-75-12
Fig. A-FBAAA Replacement of the fasteners between STGR3 and STGR5 and between STGR11 and STGR13 on FR45.	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

(a) Remove the fasteners of the holes No. 1 thru 40.

CAUTION: PERFORM THE REPAIR ON ONE SIDE ONLY AT A TIME.

Refer to [Fig. A-FBAAA Sheet 01](#) and [Fig. A-FBAAA Sheet 02](#)

In accordance with SRM 51-42-00

1 Remove :

40	screw	Discard
40	nut	Discard

NOTE: Be careful not to damage the holes.

2 Do a check of the actual hole diameter and the length of the removed fasteners. Compare these with the values given in the figure [Fig. A-FBAAA Sheet 02](#). If the values are not the same, contact AIRBUS.

3 Do a rotating probe inspection of the holes No. 1 thru 40.

Refer to NTM 51-10-01 Part 6 Procedure A.

a If crack is detected :

<1> Contact AIRBUS

b If no crack is detected :

<1> Do the operations described below.

- (b) Do the cold expansion of the 40 holes.

Refer to [Fig. A-FBAAA Sheet 03](#) and [Fig. A-FBAAA Sheet 04](#)

In accordance with SRM 51-48-00 and SRM 51-46-11

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.

Use FTI tool list No.

DKA330533144-1 Durable Tooling 1

EKA330533144-1 Expendable Tooling 1

FTIA330533144-1 Capital Tooling 1

NOTE (02): For a better access, the work should be realized from the outside of the aircraft.

1 Ream the 40 holes to the start hole diameter comprised between 7.19 mm (0.283 in.) and 7.26 mm (0.286 in.)

2 Deburr the holes

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

4 Ream the 40 cold expanded holes to the final hole diameter comprised between 7.815 mm (0.308 in.) and 7.849 mm (0.309 in.)

5 Deburr the holes.

6 Countersink the holes in accordance with SRM 51-46-11.

- (c) Install the new fasteners in the holes No. 1 thru 40.

Refer to [Fig. A-FBAAA Sheet 01](#) and [Fig. A-FBAAA Sheet 04](#)

In accordance with SRM 51-24-00, SRM 51-40-00, SRM 51-42-00, SRM 51-43-00, SRM 51-44-00

Refer to AMM Task 20-21-11-911-801

1

NOTE: Clean the surface to seal with:

Non Aqueous Cleaner-General	08BAA9	As required
--------------------------------	--------	-------------

NOTE: Apply

SERVICE BULLETIN

Polysulfide Sealant- 06AAA1 As required
General Purpose
Brushable

to the countersunk holes before fastener installation.

2 Install :

4	Bolt	EN6114V5-6	Item 20
12	Bolt	EN6114V5-11	Item 13
9	Bolt	EN6114V5-10	Item 12
11	Bolt	EN6114V5-9	Item 11
4	Bolt	EN6114V5-8	Item 10
40	Nut	ASNA2531-5	Item 15

(d) Renew the protective finish in accordance with SRM 51-75-12 with:

Surface 10ABC1 As required
Pretreatment-Light
Alloys Chemical
Conversion

Wash Primer- 04CMA2 As required
Structure

,

Primer 04EAC2 As required
Polyurethane Paint-
Corrosion Inhibiting

,

Top Coat 04JME4 As required
Polyurethane-Grey
Internal Structure

,

Top Coat 04JAA3 As required
Polyurethane-
External Structure

or

Top Coat 04JMD3 As required
Polyurethane-
Decorative External
Structure

in accordance with SRM 51-21-11 and SRM 51-23-11.

- (2) **Subtask 533144-831-006-001 - Replace the fasteners from fuselage at FR45 between LH STGR11 and LH STGR13.**

Work Zones and Access Panels			
	Zone	Access/Work location	
	250	Work location	Frame 45 from Stringer 11 to Stringer 13

Manpower Resources	
Manhours	24.00
Minimum number of person	1
Subtask elapsed time	24.00
Skills	NON SPECIFIC

Material necessary to do the job

Kit 533144A01R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	EN6114V5-8	4	BOLT	
11	EN6114V5-9	10	BOLT	
12	EN6114V5-10	11	BOLT	
13	EN6114V5-11	11	BOLT	
15	ASNA2531-5	40	NUT	
20	EN6114V5-6	4	BOLT	

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer-Structure	04CMA2	As required	
	Primer Polyurethane Paint-Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane-External Structure	04JAA3	As required	
	Top Coat Polyurethane-Decorative External Structure	04JMD3	As required	
	Top Coat Polyurethane-Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conversion	10ABC1	As required	

Standard tool TOOLA01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533144-1	Durable Tooling	1	(1)
	EKA330533144-1	Expendable Tooling	1	(2)
	FTIA330533144-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the following tool kit numbers for cold expansion:
For the definition of capital, durable and expendable tools, refer to SIL 51-012.

NOTE (1): Durable tooling: Ref. DK-A330-53-3144-1

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 SIL 51-012.

NOTE (2): Expendable tooling: Ref. EK-A330-53-3144-1

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.

NOTE (3): Capital tooling: Ref. FTI-A330-53-3144-1

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 FTI.

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-801
Non Destructive Test Manual (NTM)	51-10-01 Part 6 Procedure A
Structural Repair Manual (SRM)	51-21-11 51-23-11 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-46-11 51-48-00
Fig. A-FBAAA Replacement of the fasteners between STGR3 and STGR5 and between STGR11 and STGR13 on FR45.	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

Replace the fasteners from fuselage at FR45 between LH STGR11 and LH STGR13.

Refer to Kit 533144A01R04

[Fig. A-FBAAA Sheet 01](#) and [Fig. A-FBAAA Sheet 05](#) thru [Fig. A-FBAAA Sheet 07](#)

(a) Remove the fasteners of the holes No. 1 thru 40.

Refer to [Fig. A-FBAAA Sheet 01](#) and [Fig. A-FBAAA Sheet 05](#)

In accordance with SRM 51-42-00

1 Remove :

40	screw	Discard
40	nut	Discard

NOTE: Be careful not to damage the holes.

2 Do a check of the actual hole diameter and the length of the removed fasteners. Compare these with the values given in the figure [Fig. A-FBAAA Sheet 05](#). If the values are not the same, contact AIRBUS.

3 Do a rotating probe inspection of the holes No. 1 thru 40.

Refer to NTM 51-10-01 Part 6 Procedure A.

a If crack is detected :

<1> Contact AIRBUS

b If no crack is detected :

<1> Do the operations described below.

(b) Do the cold expansion of the 40 holes.

Refer to [Fig. A-FBAAA Sheet 06](#) and [Fig. A-FBAAA Sheet 07](#)

In accordance with SRM 51-48-00 and SRM 51-46-11

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.

Use FTI tool list No.

DKA330533144-1	Durable Tooling	1
EKA330533144-1	Expendable Tooling	1
FTIA330533144-1	Capital Tooling	1

SERVICE BULLETIN

NOTE (02): For a better access, the work should be realized from the outside of the aircraft.

- 1 Ream the 40 holes to the start hole diameter comprised between 7.19 mm (0.283 in.) and 7.26 mm (0.286 in.)
 - 2 Deburr the holes
 - 3 Do the cold expansion of the holes in the fuselage in accordance with SRM 51-48-00.
 - 4 Ream the 40 cold expanded holes to the final hole diameter comprised between 7.815 mm (0.308 in.) and 7.849 mm (0.309 in.)
 - 5 Deburr the holes.
 - 6 Countersink the holes in accordance with SRM 51-46-11.
- (c) Install the new fasteners in the holes No. 1 thru 40.

Refer to [Fig. A-FBAAA Sheet 01](#) and [Fig. A-FBAAA Sheet 06](#) and [Fig. A-FBAAA Sheet 07](#)

In accordance with SRM 51-24-00, SRM 51-40-00, SRM 51-42-00, SRM 51-43-00, SRM 51-44-00

Refer to AMM Task 20-21-11-911-801

1

NOTE: Clean the surface to seal with:

Non Aqueous Cleaner-General	08BAA9	As required
--------------------------------	--------	-------------

NOTE: Apply

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

to the countersunk holes before fastener installation.

2 Install :

█	11	Bolt	EN6114V5-11	Item 13
█	11	Bolt	EN6114V5-10	Item 12
█	10	Bolt	EN6114V5-9	Item 11
█	4	Bolt	EN6114V5-8	Item 10
█	4	Bolt	EN6114V5-6	Item 20

5 DATE: Aug 23/05

SERVICE BULLETIN No.: A330-53-3144

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40 Nut ASNA2531-5 Item 15

(d) Renew the protective finish with:

Surface 10ABC1 As required
Pretreatment-Light
Alloys Chemical
Conversion

Wash Primer- 04CMA2 As required
Structure

,

Primer 04EAC2 As required
Polyurethane Paint-
Corrosion Inhibiting

,

Top Coat 04JME4 As required
Polyurethane-Grey
Internal Structure

,

Top Coat 04JAA3 As required
Polyurethane-
External Structure

or

Top Coat 04JMD3 As required
Polyurethane-
Decorative External
Structure

in accordance with SRM 51-21-11 and SRM 51-23-11.

(3) Subtask 533144-831-007-001 - Replace the fasteners from fuselage at FR45 between RH STGR3 and RH STGR5.

Work Zones and Access Panels			
	Zone	Access/Work location	
	250	Work location	Frame 45 from Stringer 3 to Stringer 5

Manpower Resources	
Manhours	24.00
Minimum number of person	1
Subtask elapsed time	24.00
Skills	NON SPECIFIC

Material necessary to do the job

Kit 533144A01R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	EN6114V5-8	4	BOLT	
11	EN6114V5-9	11	BOLT	
12	EN6114V5-10	9	BOLT	
13	EN6114V5-11	12	BOLT	
15	ASNA2531-5	40	NUT	
20	EN6114V5-6	4	BOLT	

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer-Structure	04CMA2	As required	
	Primer Polyurethane Paint-Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane-External Structure	04JAA3	As required	
	Top Coat Polyurethane-Decorative External Structure	04JMD3	As required	
	Top Coat Polyurethane-Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conversion	10ABC1	As required	

Standard tool TOOLA01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533144-1	Durable Tooling	1	(1)
	EKA330533144-1	Expendable Tooling	1	(2)
	FTIA330533144-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the following tool kit numbers for cold expansion:
For the definition of capital, durable and expendable tools, refer to SIL 51-012.

NOTE (1): Durable tooling: Ref. DK-A330-53-3144-1

SERVICE BULLETIN

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 SIL 51-012.

NOTE (2): Expendable tooling: Ref. EK-A330-53-3144-1

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.

NOTE (3): Capital tooling: Ref. FTI-A330-53-3144-1

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 FTI.

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-801
Non Destructive Test Manual (NTM)	51-10-01 Part 6 Procedure A
Structural Repair Manual (SRM)	51-21-11 51-23-11 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-46-11 51-48-00
Fig. A-FBAAA Replacement of the fasteners between STGR3 and STGR5 and between STGR11 and STGR13 on FR45.	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

Replace the fasteners from fuselage at FR45 between RH STGR3 and RH STGR5.

Refer to Kit 533144A01R04

Refer to [Fig. A-FBAAA Sheet 01](#) thru [Fig. A-FBAAA Sheet 04](#)

(a) Remove the fasteners of the holes No. 1 thru 40.

CAUTION: PERFORM THE REPAIR ON ONE SIDE ONLY AT A TIME.

Refer to [Fig. A-FBAAA Sheet 01](#) and [Fig. A-FBAAA Sheet 02](#)

In accordance with SRM 51-42-00

- | | | |
|----|-------------------|---------|
| | <u>1</u> Remove : | |
| 40 | screw | Discard |
| 40 | nut | Discard |

NOTE: Be careful not to damage the holes.

2 Do a check of the actual hole diameter and the length of the removed fasteners. Compare these with the values given in the figure [Fig. A-FBAAA Sheet 02](#). If the values are not the same, contact AIRBUS.

3 Do a rotating probe inspection of the holes No. 1 thru 40.

Refer to NTM 51-10-01 Part 6 Procedure A.

a If crack is detected :

<1> Contact AIRBUS

b If no crack is detected :

<1> Do the operations described below.

(b) Do the cold expansion of the 40 holes.

Refer to [Fig. A-FBAAA Sheet 03](#) and [Fig. A-FBAAA Sheet 04](#)

In accordance with SRM 51-48-00 and SRM 51-46-11

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.

Use FTI tool list No.

DKA330533144-1 Durable Tooling 1

EKA330533144-1 Expendable Tooling 1

FTIA330533144-1 Capital Tooling 1

NOTE (02): For a better access, the work should be realized from the outside of the aircraft.

1 Ream the 40 holes to the start hole diameter comprised between 7.19 mm (0.283 in.) and 7.26 mm (0.286 in.)

2 Deburr the holes

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

4 Ream the 40 cold expanded holes to the final hole diameter comprised between 7.815 mm (0.308 in.) and 7.849 mm (0.309 in.)

5 Deburr the holes.

6 Countersink the holes in accordance SRM 51-46-11.

(c) Install the new fasteners in the holes No. 1 thru 32.

Refer to [Fig. A-FBAAA Sheet 01](#) and [Fig. A-FBAAA Sheet 04](#)

In accordance with SRM 51-24-00, SRM 51-40-00, SRM 51-42-00, SRM 51-43-00, SRM 51-44-00

Refer to AMM Task 20-21-11-911-801

1

NOTE: Clean the surface to seal with:

Non Aqueous Cleaner-General	08BAA9	As required
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NOTE: Apply

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

to the countersunk holes before fastener installation.

2 Install :

I	4	Bolt	EN6114V5-6	Item 20
I	12	Bolt	EN6114V5-11	Item 13
I	9	Bolt	EN6114V5-10	Item 12
I	11	Bolt	EN6114V5-9	Item 11
I	4	Bolt	EN6114V5-8	Item 10
	40	Nut	ASNA2531-5	Item 15

(d) Renew the protective finish with:

Surface Pretreatment-Light Alloys Chemical Conversion	10ABC1	As required
--	--------	-------------

Wash Primer- Structure	04CMA2	As required
---------------------------	--------	-------------

,

SERVICE BULLETIN

Primer 04EAC2 As required
Polyurethane Paint-
Corrosion Inhibiting

Top Coat 04JME4 As required
Polyurethane-Grey
Internal Structure

Top Coat 04JAA3 As required
Polyurethane-
External Structure

or

Top Coat 04JMD3 As required
Polyurethane-
Decorative External
Structure

in accordance with SRM 51-21-11 and SRM 51-23-11.

(4) Subtask 533144-831-008-001 - Replace the fasteners from fuselage at FR45 between RH STGR11 and RH STGR13.

Work Zones and Access Panels			
	Zone	Access/Work location	
	250	Work location	Frame 45 from Stringer 11 to Stringer 13

Manpower Resources	
Manhours	24.00
Minimum number of person	1
Subtask elapsed time	24.00
Skills	NON SPECIFIC

Material necessary to do the job

Kit 533144A01R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	EN6114V5-8	4	BOLT	
11	EN6114V5-9	10	BOLT	
12	EN6114V5-10	11	BOLT	
13	EN6114V5-11	11	BOLT	
15	ASNA2531-5	40	NUT	
20	EN6114V5-6	4	BOLT	

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer-Structure	04CMA2	As required	
	Primer Polyurethane Paint-Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane-External Structure	04JAA3	As required	
	Top Coat Polyurethane-Decorative External Structure	04JMD3	As required	
	Top Coat Polyurethane-Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conversion	10ABC1	As required	

Standard tool TOOLA01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533144-1	Durable Tooling	1	(1)
	EKA330533144-1	Expendable Tooling	1	(2)
	FTIA330533144-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the following tool kit numbers for cold expansion:
For the definition of capital, durable and expendable tools, refer to SIL 51-012.

NOTE (1): Durable tooling: Ref. DK-A330-53-3144-1

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 SIL 51-012.

NOTE (2): Expendable tooling: Ref. EK-A330-53-3144-1

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.

NOTE (3): Capital tooling: Ref. FTI-A330-53-3144-1

SERVICE BULLETIN

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 FTI.

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-801
Non Destructive Test Manual (NTM)	51-10-01 Part 6 Procedure A
Structural Repair Manual (SRM)	51-21-11 51-23-11 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-46-11 51-48-00
Fig. A-FBAAA Replacement of the fasteners between STGR3 and STGR5 and between STGR11 and STGR13 on FR45.	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

Replace the fasteners from fuselage at FR45 between RH STGR11 and RH STGR13.

Refer to Kit 533144A01R04

Refer to [Fig. A-FBAAA Sheet 01](#), [Fig. A-FBAAA Sheet 05](#) thru [Fig. A-FBAAA Sheet 07](#)

(a) Remove the fasteners of the holes No. 1 thru 40.

Refer to [Fig. A-FBAAA Sheet 01](#), [Fig. A-FBAAA Sheet 05](#) and [Fig. A-FBAAA Sheet 07](#)

In accordance with SRM 51-42-00

1 Remove :

40	screw	Discard
40	nut	Discard

NOTE: Be careful not to damage the holes.

2 Do a check of the actual diameter. Compare with the value given in the figure , [Fig. A-FBAAA Sheet 05](#) which gives the diameter of the holes that you must found. If the values are not the same, contact AIRBUS.

3 Do a rotating probe inspection of the holes No. 1 thru 40.

Refer to NTM 51-10-01 Part 6 Procedure A.

a If crack is detected :

<1> Contact AIRBUS

b If no crack is detected :

<1> Do the operations described below.

(b) Do the cold expansion of the 40 holes.

Refer to [Fig. A-FBAAA Sheet 01](#), [Fig. A-FBAAA Sheet 06](#) and [Fig. A-FBAAA Sheet 07](#)

In accordance with SRM 51-48-00 and SRM 51-46-11

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.

Use FTI tool list No.

DKA330533144-1 Durable Tooling 1

EKA330533144-1 Expendable Tooling 1

FTIA330533144-1 Capital Tooling 1

NOTE (02): For a better access, the work should be realized from the outside of the aircraft.

1 Ream the 40 holes to the start hole diameter comprised between 7.19 mm (0.283 in.) and 7.26 mm (0.286 in.)

2 Deburr the holes

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

4 Ream the 40 cold expanded holes to the final hole diameter comprised between 7.815 mm (0.308 in.) and 7.849 mm (0.309 in.)

5 Deburr the holes.

6 Countersink the holes in accordance with SRM 51-46-11.

(c) Install the new fasteners in the holes No. 1 thru 40.

Refer to [Fig. A-FBAAA Sheet 01](#) and [Fig. A-FBAAA Sheet 07](#)

In accordance with SRM 51-24-00, SRM 51-40-00, SRM 51-42-00, SRM 51-43-00, SRM 51-44-00

Refer to AMM Task 20-21-11-911-801

1

SERVICE BULLETIN

NOTE: Clean the surface to seal with:

Non Aqueous Cleaner-General	08BAA9	As required
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NOTE: Apply

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

to the countersunk holes before fastener installation.

2 Install :

I	11	Bolt	EN6114V5-11	Item 13
I	11	Bolt	EN6114V5-10	Item 12
I	10	Bolt	EN6114V5-9	Item 11
I	4	Bolt	EN6114V5-8	Item 10
I	4	Bolt	EN6114V5-6	Item 20
	40	Nut	ASNA2531-5	Item 15

(d) Renew the protective finish with:

Surface Pretreatment-Light Alloys Chemical Conversion	10ABC1	As required
--	--------	-------------

Wash Primer- Structure	04CMA2	As required
---------------------------	--------	-------------

,

Primer Polyurethane Paint- Corrosion Inhibiting	04EAC2	As required
---	--------	-------------

,

Top Coat Polyurethane-Grey Internal Structure	04JME4	As required
---	--------	-------------

,

Top Coat Polyurethane- External Structure	04JAA3	As required
---	--------	-------------

or

SERVICE BULLETIN

Top Coat 04JMD3 As required
Polyurethane-
Decorative External
Structure

in accordance with SRM 51-21-11 and SRM 51-23-11.

(5) Subtask 533144-831-009-001 - Replace the fasteners from fuselage at FR54 between LH STGR4 and LH STGR5.

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	Frame 54 from Stringer 4 to Stringer 5

Manpower Resources	
Manhours	24.00
Minimum number of person	1
Subtask elapsed time	24.00
Skills	NON SPECIFIC

Material necessary to do the job

Kit 533144A02R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	EN6114V4-7	7	BOLT	
2	EN6114V4-8	4	BOLT	
3	EN6114V4-9	8	BOLT	
4	EN6114V4-10	10	BOLT	
6	ASNA2531-4	40	NUT	
21	EN6114V4-4	1	BOLT	
22	EN6114V4-5	3	BOLT	
23	EN6114V4-6	7	BOLT	

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer-Structure	04CMA2	As required	
	Primer Polyurethane Paint-Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane-External Structure	04JAA3	As required	
	Top Coat Polyurethane-Decorative External Structure	04JMD3	As required	
	Top Coat Polyurethane-Grey Internal Structure	04JME4	As required	

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner- General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conversion	10ABC1	As required	

Standard tool TOOLA01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533144-1	Durable Tooling	1	(1)
	EKA330533144-1	Expendable Tooling	1	(2)
	FTIA330533144-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the following tool kit numbers for cold expansion:
For the definition of capital, durable and expendable tools, refer to SIL 51-012.

NOTE (1): Durable tooling: Ref. DK-A330-53-3144-1

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 SIL 51-012.

NOTE (2): Expendable tooling: Ref. EK-A330-53-3144-1

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.

NOTE (3): Capital tooling: Ref. FTI-A330-53-3144-1

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 FTI.

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-801
Non Destructive Test Manual (NTM)	51-10-01 Part 6 Procedure A

References	
Structural Repair Manual (SRM)	51-21-11 51-23-11 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-46-11 51-48-00
Fig. A-FBBAA Replacement of the fasteners between STGR4 and STGR5 on FR54	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

Replace the fasteners from fuselage at FR54 between LH STGR4 and LH STGR5.

Refer to Kit 533144A02R03

Refer to [Fig. A-FBBAA Sheet 01](#) thru [Fig. A-FBBAA Sheet 04](#)

(a) Remove the fasteners of the holes No. 1 thru 40.

CAUTION: PERFORM THE REPAIR ON ONE SIDE ONLY AT A TIME.

Refer to [Fig. A-FBBAA Sheet 01](#) and [Fig. A-FBBAA Sheet 02](#)

In accordance with SRM 51-42-00

1 Remove :

40	screw	Discard
40	nut	Discard

NOTE: Be careful not to damage the holes.

2 Do a check of the actual hole diameter and the length of the removed fasteners. Compare these with the values given in the figure [Fig. A-FBBAA Sheet 02](#). If the values are not the same, contact AIRBUS.

3 Do a rotating probe inspection of the holes No. 1 thru 40.

Refer to NTM 51-10-01 Part 6 Procedure A.

a If crack is detected :

<1> Contact AIRBUS

b If no crack is detected :

<1> Do the operations described below.

(b) Do the cold expansion of the 40 holes.

Refer to [Fig. A-FBBAA Sheet 01](#), [Fig. A-FBBAA Sheet 03](#) and [Fig. A-FBBAA Sheet 04](#)

In accordance with SRM 51-48-00 and SRM 51-46-11

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.

Use FTI tool list No.

DKA330533144-1 Durable Tooling 1

EKA330533144-1 Expendable Tooling 1

FTIA330533144-1 Capital Tooling 1

NOTE (02): For a better access, the work should be realized from the outside of the aircraft.

1 Ream the 40 holes to the start hole diameter comprised between 5.715 mm (0.225 in.) and 5.791mm (0.228 in.)

2 Deburr the holes

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

4 Ream the 40 cold expanded holes to the final hole diameter comprised between 6.227mm (0.24516 in.) and 6.262 mm (0.24654 in.)

5 Deburr the holes.

6 Countersink the holes in accordance with SRM 51-46-11.

(c) Install the new fasteners in the holes No. 1 thru 40.

Refer to [Fig. A-FBBAA Sheet 01](#), [Fig. A-FBBAA Sheet 03](#) and [Fig. A-FBBAA Sheet 04](#)

In accordance with SRM 51-24-00, SRM 51-40-00, SRM 51-42-00, SRM 51-43-00, SRM 51-44-00

Refer to AMM Task 20-21-11-911-801

1

NOTE: Clean the surface to seal with:

SERVICE BULLETIN

Non Aqueous Cleaner-General	08BAA9	As required
--------------------------------	--------	-------------

NOTE: Apply

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

to the countersunk holes before fastener installation.

2 Install :

I	7	Bolt	EN6114V4-7	Item 1
I	8	Bolt	EN6114V4-9	Item 3
I	10	Bolt	EN6114V4-10	Item 4
I	4	Bolt	EN6114V4-8	Item 2
I	1	Bolt	EN6114V4-4	Item 21
I	3	Bolt	EN6114V4-5	Item 22
I	7	Bolt	EN6114V4-6	Item 23
	40	Nut	ASNA2531-4	Item 6

(d) Renew the protective finish with:

Surface Pretreatment-Light Alloys Chemical Conversion	10ABC1	As required
--	--------	-------------

Wash Primer- Structure	04CMA2	As required
---------------------------	--------	-------------

,

Primer Polyurethane Paint- Corrosion Inhibiting	04EAC2	As required
---	--------	-------------

,

Top Coat Polyurethane-Grey Internal Structure	04JME4	As required
---	--------	-------------

,

SERVICE BULLETIN

Top Coat 04JAA3 As required
Polyurethane-
External Structure

or

Top Coat 04JMD3 As required
Polyurethane-
Decorative External
Structure

in accordance with SRM 51-21-11 and SRM 51-23-11.

(6) Subtask 533144-831-010-001 - Replace the fasteners from fuselage at FR54 between RH STGR4 and RH STGR5.

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	Frame 54 from Stringer 4 to Stringer 5

Manpower Resources	
Manhours	24.00
Minimum number of person	1
Subtask elapsed time	24.00
Skills	NON SPECIFIC

Material necessary to do the job

Kit 533144A02R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	EN6114V4-7	7	BOLT	
2	EN6114V4-8	4	BOLT	
3	EN6114V4-9	8	BOLT	
4	EN6114V4-10	10	BOLT	
6	ASNA2531-4	40	NUT	
21	EN6114V4-4	1	BOLT	
22	EN6114V4-5	3	BOLT	
23	EN6114V4-6	7	BOLT	

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer-Structure	04CMA2	As required	
	Primer Polyurethane Paint-Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane-External Structure	04JAA3	As required	

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Top Coat Polyurethane-Decorative External Structure	04JMD3	As required	
	Top Coat Polyurethane-Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conversion	10ABC1	As required	

Standard tool TOOLA01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533144-1	Durable Tooling	1	(1)
	EKA330533144-1	Expendable Tooling	1	(2)
	FTIA330533144-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the following tool kit numbers for cold expansion: For the definition of capital, durable and expendable tools, refer to SIL 51-012.

NOTE (1): Durable tooling: Ref. DK-A330-53-3144-1

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 SIL 51-012.

NOTE (2): Expendable tooling: Ref. EK-A330-53-3144-1

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.

NOTE (3): Capital tooling: Ref. FTI-A330-53-3144-1

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 FTI.

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-801
Non Destructive Test Manual (NTM)	51-10-01 Part 6 Procedure A

References	
Structural Repair Manual (SRM)	51-21-11 51-23-11 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-46-11 51-48-00
Fig. A-FBBAA Replacement of the fasteners between STGR4 and STGR5 on FR54	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

Replace the fasteners from fuselage at FR54 between RH STGR4 and RH STGR5.

Refer to Kit 533144A02R03

(a) Remove the fasteners of the holes No. 1 thru 40.

CAUTION: PERFORM THE REPAIR ON ONE SIDE ONLY AT A TIME.

Refer to [Fig. A-FBBAA Sheet 01](#) thru [Fig. A-FBBAA Sheet 04](#)

In accordance with SRM 51-42-00

1 Remove :

40	screw	Discard
40	nut	Discard

NOTE: Be careful not to damage the holes.

2 Refer to [Fig. A-FBBAA Sheet 02](#)

3 Do a check of the actual hole diameter and the length of the removed fasteners. Compare these with the values given in the figure [Fig. A-FBBAA Sheet 02](#). If the values are not the same, contact AIRBUS.

4 Do a rotating probe inspection of the holes No. 1 thru 40.

Refer to NTM 51-10-01 Part 6 Procedure A.

a If crack is detected :

<1> Contact AIRBUS

b If no crack is detected :

<1> Do the operations described below.

(b) Do the cold expansion of the 40 holes.

Refer to [Fig. A-FBBAA Sheet 01](#), [Fig. A-FBBAA Sheet 03](#) and [Fig. A-FBBAA Sheet 04](#)

In accordance with SRM 51-48-00 and SRM 51-46-11

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.

Use FTI tool list No.

DKA330533144-1 Durable Tooling 1

EKA330533144-1 Expendable Tooling 1

FTIA330533144-1 Capital Tooling 1

NOTE (02): For a better access, the work should be realized from the outside of the aircraft.

1 Ream the 40 holes to the start hole diameter comprised between 5.715 mm (0.225 in.) and 5.791mm (0.228 in.)

2 Deburr the holes

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

4 Ream the 40 cold expanded holes to the final hole diameter comprised between 6.227mm (0.24516 in.) and 6.262 mm (0.24654 in.)

5 Deburr the holes.

6 Countersink the holes in accordance with SRM 51-46-11.

(c) Install the new fasteners in the holes No. 1 thru 40.

Refer to [Fig. A-FBBAA Sheet 01](#) and [Fig. A-FBBAA Sheet 04](#)

In accordance with SRM 51-24-00, SRM 51-40-00, SRM 51-42-00, SRM 51-43-00, SRM 51-44-00

Refer to AMM Task 20-21-11-911-801

1

NOTE: Clean the surface to seal with:

SERVICE BULLETIN

Non Aqueous Cleaner-General	08BAA9	As required
--------------------------------	--------	-------------

NOTE: Apply

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

to the countersunk holes before fastener installation.

2 Install :

I	7	Bolt	EN6114V4-7	Item 1
I	8	Bolt	EN6114V4-9	Item 3
I	10	Bolt	EN6114V4-10	Item 4
I	4	Bolt	EN6114V4-8	Item 2
I	1	Bolt	EN6114V4-4	Item 21
I	3	Bolt	EN6114V4-5	Item 22
I	7	Bolt	EN6114V4-6	Item 23
	40	Nut	ASNA2531-4	Item 6

(d) Renew the protective finish with:

Surface Pretreatment-Light Alloys Chemical Conversion	10ABC1	As required
--	--------	-------------

Wash Primer- Structure	04CMA2	As required
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,

Primer Polyurethane Paint- Corrosion Inhibiting	04EAC2	As required
---	--------	-------------

,

Top Coat Polyurethane-Grey Internal Structure	04JME4	As required
---	--------	-------------

,

SERVICE BULLETIN

Top Coat 04JAA3 As required
Polyurethane-
External Structure

or

Top Coat 04JMD3 As required
Polyurethane-
Decorative External
Structure

in accordance with SRM 51-21-11 and SRM 51-23-11.

**CONF 002

- (1) **Subtask 533144-831-005-002 - Replace the fasteners from fuselage at FR45 between LH STGR3 and LH STGR5.**

Work Zones and Access Panels			
	Zone	Access/Work location	
	250	Work location	Frame 45 from Stringer 3 to Stringer 5

Manpower Resources	
Manhours	24.00
Minimum number of person	1
Subtask elapsed time	24.00
Skills	NON SPECIFIC

Material necessary to do the job

Kit 533144A01R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	EN6114V5-8	4	BOLT	
11	EN6114V5-9	11	BOLT	
12	EN6114V5-10	9	BOLT	
13	EN6114V5-11	12	BOLT	
15	ASNA2531-5	40	NUT	
20	EN6114V5-6	4	BOLT	

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer-Structure	04CMA2	As required	
	Primer Polyurethane Paint-Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane-External Structure	04JAA3	As required	

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Top Coat Polyurethane-Decorative External Structure	04JMD3	As required	
	Top Coat Polyurethane-Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conversion	10ABC1	As required	

Standard tool TOOLA01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533144-1	Durable Tooling	1	(1)
	EKA330533144-1	Expendable Tooling	1	(2)
	FTIA330533144-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the following tool kit numbers for cold expansion:
For the definition of capital, durable and expendable tools, refer to SIL 51-012.

NOTE (1): Durable tooling: Ref. DK-A330-53-3144-1

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 SIL 51-012.

NOTE (2): Expendable tooling: Ref. EK-A330-53-3144-1

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.

NOTE (3): Capital tooling: Ref. FTI-A330-53-3144-1

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 FTI.

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-801
Non Destructive Test Manual (NTM)	51-10-01 Part 6 Procedure A

References	
Structural Repair Manual (SRM)	51-21-11 51-23-11 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-46-11 51-48-00 51-48-00 51-75-12
Fig. A-FBAAA Replacement of the fasteners between STGR3 and STGR5 and between STGR11 and STGR13 on FR45.	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

(a) Remove the fasteners of the holes No. 1 thru 40.

CAUTION: PERFORM THE REPAIR ON ONE SIDE ONLY AT A TIME.

Refer to [Fig. A-FBAAA Sheet 01](#) and [Fig. A-FBAAA Sheet 02](#)

In accordance with SRM 51-42-00

1 Remove :

40	screw	Discard
40	nut	Discard

NOTE: Be careful not to damage the holes.

2 Do a check of the actual hole diameter and the length of the removed fasteners. Compare these with the values given in the figure [Fig. A-FBAAA Sheet 02](#). If the values are not the same, contact AIRBUS.

3 Do a rotating probe inspection of the holes No. 1 thru 40.

Refer to NTM 51-10-01 Part 6 Procedure A.

a If crack is detected :

<1> Contact AIRBUS

b If no crack is detected :

<1> Do the operations described below.

- (b) Do the cold expansion of the 40 holes.

Refer to [Fig. A-FBAAA Sheet 03](#) and [Fig. A-FBAAA Sheet 04](#)

In accordance with SRM 51-48-00 and SRM 51-46-11

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.

Use FTI tool list No.

DKA330533144-1 Durable Tooling 1

EKA330533144-1 Expendable Tooling 1

FTIA330533144-1 Capital Tooling 1

NOTE (02): For a better access, the work should be realized from the outside of the aircraft.

1 Ream the 40 holes to the start hole diameter comprised between 7.19 mm (0.283 in.) and 7.26 mm (0.286 in.)

2 Deburr the holes

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

4 Ream the 40 cold expanded holes to the final hole diameter comprised between 7.815 mm (0.308 in.) and 7.849 mm (0.309 in.)

5 Deburr the holes.

6 Countersink the holes in accordance with SRM 51-46-11.

- (c) Install the new fasteners in the holes No. 1 thru 40.

Refer to [Fig. A-FBAAA Sheet 01](#) and [Fig. A-FBAAA Sheet 04](#)

In accordance with SRM 51-24-00, SRM 51-40-00, SRM 51-42-00, SRM 51-43-00, SRM 51-44-00

Refer to AMM Task 20-21-11-911-801

1

NOTE: Clean the surface to seal with:

Non Aqueous	08BAA9	As required
Cleaner-General		

NOTE: Apply

SERVICE BULLETIN

Polysulfide Sealant- 06AAA1 As required
General Purpose
Brushable

to the countersunk holes before fastener installation.

2 Install :

4	Bolt	EN6114V5-6	Item 20
12	Bolt	EN6114V5-11	Item 13
9	Bolt	EN6114V5-10	Item 12
11	Bolt	EN6114V5-9	Item 11
4	Bolt	EN6114V5-8	Item 10
40	Nut	ASNA2531-5	Item 15

(d) Renew the protective finish in accordance with SRM 51-75-12 with:

Surface 10ABC1 As required
Pretreatment-Light
Alloys Chemical
Conversion

Wash Primer- 04CMA2 As required
Structure

,

Primer 04EAC2 As required
Polyurethane Paint-
Corrosion Inhibiting

,

Top Coat 04JME4 As required
Polyurethane-Grey
Internal Structure

,

Top Coat 04JAA3 As required
Polyurethane-
External Structure

or

Top Coat 04JMD3 As required
Polyurethane-
Decorative External
Structure

in accordance with SRM 51-21-11 and SRM 51-23-11.

- (2) Subtask 533144-831-006-001 - Replace the fasteners from fuselage at FR45 between LH STGR11 and LH STGR13.

Work Zones and Access Panels			
	Zone	Access/Work location	
	250	Work location	Frame 45 from Stringer 11 to Stringer 13

Manpower Resources	
Manhours	24.00
Minimum number of person	1
Subtask elapsed time	24.00
Skills	NON SPECIFIC

Material necessary to do the job

Kit 533144A01R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	EN6114V5-8	4	BOLT	
11	EN6114V5-9	10	BOLT	
12	EN6114V5-10	11	BOLT	
13	EN6114V5-11	11	BOLT	
15	ASNA2531-5	40	NUT	
20	EN6114V5-6	4	BOLT	

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer-Structure	04CMA2	As required	
	Primer Polyurethane Paint-Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane-External Structure	04JAA3	As required	
	Top Coat Polyurethane-Decorative External Structure	04JMD3	As required	
	Top Coat Polyurethane-Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conversion	10ABC1	As required	

Standard tool TOOLA01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533144-1	Durable Tooling	1	(1)
	EKA330533144-1	Expendable Tooling	1	(2)
	FTIA330533144-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the following tool kit numbers for cold expansion:
For the definition of capital, durable and expendable tools, refer to SIL 51-012.

NOTE (1): Durable tooling: Ref. DK-A330-53-3144-1

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 SIL 51-012.

NOTE (2): Expendable tooling: Ref. EK-A330-53-3144-1

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.

NOTE (3): Capital tooling: Ref. FTI-A330-53-3144-1

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 FTI.

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-801
Non Destructive Test Manual (NTM)	51-10-01 Part 6 Procedure A
Structural Repair Manual (SRM)	51-21-11 51-23-11 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-46-11 51-48-00
Fig. A-FBAAA Replacement of the fasteners between STGR3 and STGR5 and between STGR11 and STGR13 on FR45.	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

Replace the fasteners from fuselage at FR45 between LH STGR11 and LH STGR13.

Refer to Kit 533144A01R04

[Fig. A-FBAAA Sheet 01](#) and [Fig. A-FBAAA Sheet 05](#) thru [Fig. A-FBAAA Sheet 07](#)

(a) Remove the fasteners of the holes No. 1 thru 40.

Refer to [Fig. A-FBAAA Sheet 01](#) and [Fig. A-FBAAA Sheet 05](#)

In accordance with SRM 51-42-00

1 Remove :

40	screw	Discard
40	nut	Discard

NOTE: Be careful not to damage the holes.

2 Do a check of the actual hole diameter and the length of the removed fasteners. Compare these with the values given in the figure [Fig. A-FBAAA Sheet 05](#). If the values are not the same, contact AIRBUS.

3 Do a rotating probe inspection of the holes No. 1 thru 40.

Refer to NTM 51-10-01 Part 6 Procedure A.

a If crack is detected :

<1> Contact AIRBUS

b If no crack is detected :

<1> Do the operations described below.

(b) Do the cold expansion of the 40 holes.

Refer to [Fig. A-FBAAA Sheet 06](#) and [Fig. A-FBAAA Sheet 07](#)

In accordance with SRM 51-48-00 and SRM 51-46-11

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.

Use FTI tool list No.

DKA330533144-1	Durable Tooling	1
EKA330533144-1	Expendable Tooling	1
FTIA330533144-1	Capital Tooling	1

SERVICE BULLETIN

NOTE (02): For a better access, the work should be realized from the outside of the aircraft.

- 1 Ream the 40 holes to the start hole diameter comprised between 7.19 mm (0.283 in.) and 7.26 mm (0.286 in.)
 - 2 Deburr the holes
 - 3 Do the cold expansion of the holes in the fuselage in accordance with SRM 51-48-00.
 - 4 Ream the 40 cold expanded holes to the final hole diameter comprised between 7.815 mm (0.308 in.) and 7.849 mm (0.309 in.)
 - 5 Deburr the holes.
 - 6 Countersink the holes in accordance with SRM 51-46-11.
- (c) Install the new fasteners in the holes No. 1 thru 40.

Refer to [Fig. A-FBAAA Sheet 01](#) and [Fig. A-FBAAA Sheet 06](#) and [Fig. A-FBAAA Sheet 07](#)

In accordance with SRM 51-24-00, SRM 51-40-00, SRM 51-42-00, SRM 51-43-00, SRM 51-44-00

Refer to AMM Task 20-21-11-911-801

1

NOTE: Clean the surface to seal with:

Non Aqueous Cleaner-General	08BAA9	As required
--------------------------------	--------	-------------

NOTE: Apply

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

to the countersunk holes before fastener installation.

2 Install :

█	11	Bolt	EN6114V5-11	Item 13
█	11	Bolt	EN6114V5-10	Item 12
█	10	Bolt	EN6114V5-9	Item 11
█	4	Bolt	EN6114V5-8	Item 10
█	4	Bolt	EN6114V5-6	Item 20

5 DATE: Aug 23/05

SERVICE BULLETIN No.: A330-53-3144

REVISION No.: 04 - Nov 23/15

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40 Nut ASNA2531-5 Item 15

(d) Renew the protective finish with:

Surface 10ABC1 As required
Pretreatment-Light
Alloys Chemical
Conversion

Wash Primer- 04CMA2 As required
Structure

,

Primer 04EAC2 As required
Polyurethane Paint-
Corrosion Inhibiting

,

Top Coat 04JME4 As required
Polyurethane-Grey
Internal Structure

,

Top Coat 04JAA3 As required
Polyurethane-
External Structure

or

Top Coat 04JMD3 As required
Polyurethane-
Decorative External
Structure

in accordance with SRM 51-21-11 and SRM 51-23-11.

(3) Subtask 533144-831-007-001 - Replace the fasteners from fuselage at FR45 between RH STGR3 and RH STGR5.

Work Zones and Access Panels			
	Zone	Access/Work location	
	250	Work location	Frame 45 from Stringer 3 to Stringer 5

Manpower Resources	
Manhours	24.00
Minimum number of person	1
Subtask elapsed time	24.00
Skills	NON SPECIFIC

Material necessary to do the job

Kit 533144A01R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	EN6114V5-8	4	BOLT	
11	EN6114V5-9	11	BOLT	
12	EN6114V5-10	9	BOLT	
13	EN6114V5-11	12	BOLT	
15	ASNA2531-5	40	NUT	
20	EN6114V5-6	4	BOLT	

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer-Structure	04CMA2	As required	
	Primer Polyurethane Paint-Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane-External Structure	04JAA3	As required	
	Top Coat Polyurethane-Decorative External Structure	04JMD3	As required	
	Top Coat Polyurethane-Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conversion	10ABC1	As required	

Standard tool TOOLA01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533144-1	Durable Tooling	1	(1)
	EKA330533144-1	Expendable Tooling	1	(2)
	FTIA330533144-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the following tool kit numbers for cold expansion:
For the definition of capital, durable and expendable tools, refer to SIL 51-012.

NOTE (1): Durable tooling: Ref. DK-A330-53-3144-1

SERVICE BULLETIN

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 SIL 51-012.

NOTE (2): Expendable tooling: Ref. EK-A330-53-3144-1

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.

NOTE (3): Capital tooling: Ref. FTI-A330-53-3144-1

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 FTI.

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-801
Non Destructive Test Manual (NTM)	51-10-01 Part 6 Procedure A
Structural Repair Manual (SRM)	51-21-11 51-23-11 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-46-11 51-48-00
Fig. A-FBAAA Replacement of the fasteners between STGR3 and STGR5 and between STGR11 and STGR13 on FR45.	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

Replace the fasteners from fuselage at FR45 between RH STGR3 and RH STGR5.

Refer to Kit 533144A01R04

Refer to [Fig. A-FBAAA Sheet 01](#) thru [Fig. A-FBAAA Sheet 04](#)

(a) Remove the fasteners of the holes No. 1 thru 40.

CAUTION: PERFORM THE REPAIR ON ONE SIDE ONLY AT A TIME.

Refer to [Fig. A-FBAAA Sheet 01](#) and [Fig. A-FBAAA Sheet 02](#)

In accordance with SRM 51-42-00

- 1 Remove :
- | | | |
|----|-------|---------|
| 40 | screw | Discard |
| 40 | nut | Discard |

NOTE: Be careful not to damage the holes.

2 Do a check of the actual hole diameter and the length of the removed fasteners. Compare these with the values given in the figure [Fig. A-FBAAA Sheet 02](#). If the values are not the same, contact AIRBUS.

3 Do a rotating probe inspection of the holes No. 1 thru 40.

Refer to NTM 51-10-01 Part 6 Procedure A.

a If crack is detected :

<1> Contact AIRBUS

b If no crack is detected :

<1> Do the operations described below.

(b) Do the cold expansion of the 40 holes.

Refer to [Fig. A-FBAAA Sheet 03](#) and [Fig. A-FBAAA Sheet 04](#)

In accordance with SRM 51-48-00 and SRM 51-46-11

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.

Use FTI tool list No.

DKA330533144-1 Durable Tooling 1

EKA330533144-1 Expendable Tooling 1

FTIA330533144-1 Capital Tooling 1

NOTE (02): For a better access, the work should be realized from the outside of the aircraft.

1 Ream the 40 holes to the start hole diameter comprised between 7.19 mm (0.283 in.) and 7.26 mm (0.286 in.)

2 Deburr the holes

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

4 Ream the 40 cold expanded holes to the final hole diameter comprised between 7.815 mm (0.308 in.) and 7.849 mm (0.309 in.)

5 Deburr the holes.

6 Countersink the holes in accordance SRM 51-46-11.

(c) Install the new fasteners in the holes No. 1 thru 32.

Refer to [Fig. A-FBAAA Sheet 01](#) and [Fig. A-FBAAA Sheet 04](#)

In accordance with SRM 51-24-00, SRM 51-40-00, SRM 51-42-00, SRM 51-43-00, SRM 51-44-00

Refer to AMM Task 20-21-11-911-801

1

NOTE: Clean the surface to seal with:

Non Aqueous Cleaner-General	08BAA9	As required
--------------------------------	--------	-------------

NOTE: Apply

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

to the countersunk holes before fastener installation.

2 Install :

I	4	Bolt	EN6114V5-6	Item 20
I	12	Bolt	EN6114V5-11	Item 13
I	9	Bolt	EN6114V5-10	Item 12
I	11	Bolt	EN6114V5-9	Item 11
I	4	Bolt	EN6114V5-8	Item 10
	40	Nut	ASNA2531-5	Item 15

(d) Renew the protective finish with:

Surface Pretreatment-Light Alloys Chemical Conversion	10ABC1	As required
--	--------	-------------

Wash Primer- Structure	04CMA2	As required
---------------------------	--------	-------------

,

SERVICE BULLETIN

Primer 04EAC2 As required
Polyurethane Paint-
Corrosion Inhibiting

Top Coat 04JME4 As required
Polyurethane-Grey
Internal Structure

Top Coat 04JAA3 As required
Polyurethane-
External Structure

or

Top Coat 04JMD3 As required
Polyurethane-
Decorative External
Structure

in accordance with SRM 51-21-11 and SRM 51-23-11.

(4) Subtask 533144-831-008-001 - Replace the fasteners from fuselage at FR45 between RH STGR11 and RH STGR13.

Work Zones and Access Panels			
	Zone	Access/Work location	
	250	Work location	Frame 45 from Stringer 11 to Stringer 13

Manpower Resources	
Manhours	24.00
Minimum number of person	1
Subtask elapsed time	24.00
Skills	NON SPECIFIC

Material necessary to do the job

Kit 533144A01R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	EN6114V5-8	4	BOLT	
11	EN6114V5-9	10	BOLT	
12	EN6114V5-10	11	BOLT	
13	EN6114V5-11	11	BOLT	
15	ASNA2531-5	40	NUT	
20	EN6114V5-6	4	BOLT	

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer-Structure	04CMA2	As required	
	Primer Polyurethane Paint-Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane-External Structure	04JAA3	As required	
	Top Coat Polyurethane-Decorative External Structure	04JMD3	As required	
	Top Coat Polyurethane-Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conversion	10ABC1	As required	

Standard tool TOOLA01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533144-1	Durable Tooling	1	(1)
	EKA330533144-1	Expendable Tooling	1	(2)
	FTIA330533144-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the following tool kit numbers for cold expansion:
For the definition of capital, durable and expendable tools, refer to SIL 51-012.

NOTE (1): Durable tooling: Ref. DK-A330-53-3144-1

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 SIL 51-012.

NOTE (2): Expendable tooling: Ref. EK-A330-53-3144-1

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.

NOTE (3): Capital tooling: Ref. FTI-A330-53-3144-1

SERVICE BULLETIN

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 FTI.

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-801
Non Destructive Test Manual (NTM)	51-10-01 Part 6 Procedure A
Structural Repair Manual (SRM)	51-21-11 51-23-11 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-46-11 51-48-00
Fig. A-FBAAA Replacement of the fasteners between STGR3 and STGR5 and between STGR11 and STGR13 on FR45.	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

Replace the fasteners from fuselage at FR45 between RH STGR11 and RH STGR13.

Refer to Kit 533144A01R04

Refer to [Fig. A-FBAAA Sheet 01](#), [Fig. A-FBAAA Sheet 05](#) thru [Fig. A-FBAAA Sheet 07](#)

(a) Remove the fasteners of the holes No. 1 thru 40.

Refer to [Fig. A-FBAAA Sheet 01](#), [Fig. A-FBAAA Sheet 05](#) and [Fig. A-FBAAA Sheet 07](#)

In accordance with SRM 51-42-00

1 Remove :

40	screw	Discard
40	nut	Discard

NOTE: Be careful not to damage the holes.

2 Do a check of the actual diameter. Compare with the value given in the figure , [Fig. A-FBAAA Sheet 05](#) which gives the diameter of the holes that you must found. If the values are not the same, contact AIRBUS.

3 Do a rotating probe inspection of the holes No. 1 thru 40.

Refer to NTM 51-10-01 Part 6 Procedure A.

a If crack is detected :

<1> Contact AIRBUS

b If no crack is detected :

<1> Do the operations described below.

(b) Do the cold expansion of the 40 holes.

Refer to [Fig. A-FBAAA Sheet 01](#), [Fig. A-FBAAA Sheet 06](#) and [Fig. A-FBAAA Sheet 07](#)

In accordance with SRM 51-48-00 and SRM 51-46-11

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.

Use FTI tool list No.

DKA330533144-1 Durable Tooling 1

EKA330533144-1 Expendable Tooling 1

FTIA330533144-1 Capital Tooling 1

NOTE (02): For a better access, the work should be realized from the outside of the aircraft.

1 Ream the 40 holes to the start hole diameter comprised between 7.19 mm (0.283 in.) and 7.26 mm (0.286 in.)

2 Deburr the holes

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

4 Ream the 40 cold expanded holes to the final hole diameter comprised between 7.815 mm (0.308 in.) and 7.849 mm (0.309 in.)

5 Deburr the holes.

6 Countersink the holes in accordance with SRM 51-46-11.

(c) Install the new fasteners in the holes No. 1 thru 40.

Refer to [Fig. A-FBAAA Sheet 01](#) and [Fig. A-FBAAA Sheet 07](#)

In accordance with SRM 51-24-00, SRM 51-40-00, SRM 51-42-00, SRM 51-43-00, SRM 51-44-00

Refer to AMM Task 20-21-11-911-801

1

SERVICE BULLETIN

NOTE: Clean the surface to seal with:

Non Aqueous Cleaner-General	08BAA9	As required
--------------------------------	--------	-------------

NOTE: Apply

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

to the countersunk holes before fastener installation.

2 Install :

I	11	Bolt	EN6114V5-11	Item 13
I	11	Bolt	EN6114V5-10	Item 12
I	10	Bolt	EN6114V5-9	Item 11
I	4	Bolt	EN6114V5-8	Item 10
I	4	Bolt	EN6114V5-6	Item 20
	40	Nut	ASNA2531-5	Item 15

(d) Renew the protective finish with:

Surface Pretreatment-Light Alloys Chemical Conversion	10ABC1	As required
--	--------	-------------

Wash Primer- Structure	04CMA2	As required
---------------------------	--------	-------------

,

Primer Polyurethane Paint- Corrosion Inhibiting	04EAC2	As required
---	--------	-------------

,

Top Coat Polyurethane-Grey Internal Structure	04JME4	As required
---	--------	-------------

,

Top Coat Polyurethane- External Structure	04JAA3	As required
---	--------	-------------

or

Top Coat 04JMD3 As required
Polyurethane-
Decorative External
Structure

in accordance with SRM 51-21-11 and SRM 51-23-11.

****CONF ALL**

D. TEST

****CONF 001**

(1) Subtask 533144-831-015-001

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-410-801
	Task 21-21-64-400-801
	Task 23-73-46-400-801
	Task 25-23-41-400-801
	Task 25-80-00-400-801

(a) Install the removed equipment

- 1 If the support plates of the decoder/encoder units 200RH11 and 200RH12 have been disengaged to get access to the work area, put them back to their initial position and attach with the retained fasteners, refer to AMM Task 23-73-46-400-801.
 - 2 engage the electrical wires and the insulation blankets from the work area disengaged for access, refer to AMM Task 25-80-00-400-801.
 - 3 Install the air distribution ducts, refer to AMM Task 21-20-00-410-801.
- (b) Do the leak check after the installation of the air distribution ducts, refer to AMM Task 21-21-64-400-801.
- (c) Install the ceiling panels 251JC for LH side and 252JC for RH side, refer to AMM Task 25-23-41-400-801.
- (d) Install the ceiling panels 261CC and 261DC for LH side and 262CC and 262DC for RH side, refer to AMM Task 25-23-41-400-801.
- (e) Do the test after the installation of the ceiling panels, refer to AMM Task 25-23-41-400-801.

****CONF 002****(1) Subtask 533144-831-016-001 - Test**

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-410-801
	Task 21-21-64-400-801
	Task 23-73-46-400-801
	Task 25-23-41-400-801
	Task 25-80-00-400-801

(a) Install the removed equipment

- 1 If the support plates of the decoder/encoder units 200RH11 and 200RH12 have been disengaged to get access to the work area, put them back to their initial position and attach with the retained fasteners, refer to AMM Task 23-73-46-400-801.
- 2 engage the electrical wires and the insulation blankets from the work area disengaged for access, refer to AMM Task 25-80-00-400-801.
- 3 Install the air distribution ducts, refer to AMM Task 21-20-00-410-801.

(b) Do the leak check after the installation of the air distribution ducts, refer to AMM Task 21-21-64-400-801.

(c) Install the ceiling panels 251JC for LH side and 252JC for RH side, refer to AMM Task 25-23-41-400-801.

(d) Do the test after the installation of the ceiling panels, refer to AMM Task 25-23-41-400-801.

****CONF ALL****E. CLOSE-UP******CONF 001****(1) Subtask 533144-831-017-001 - Close-up**

Manpower Resources	
Skills	NON SPECIFIC

(a) Remove the access platform(s).

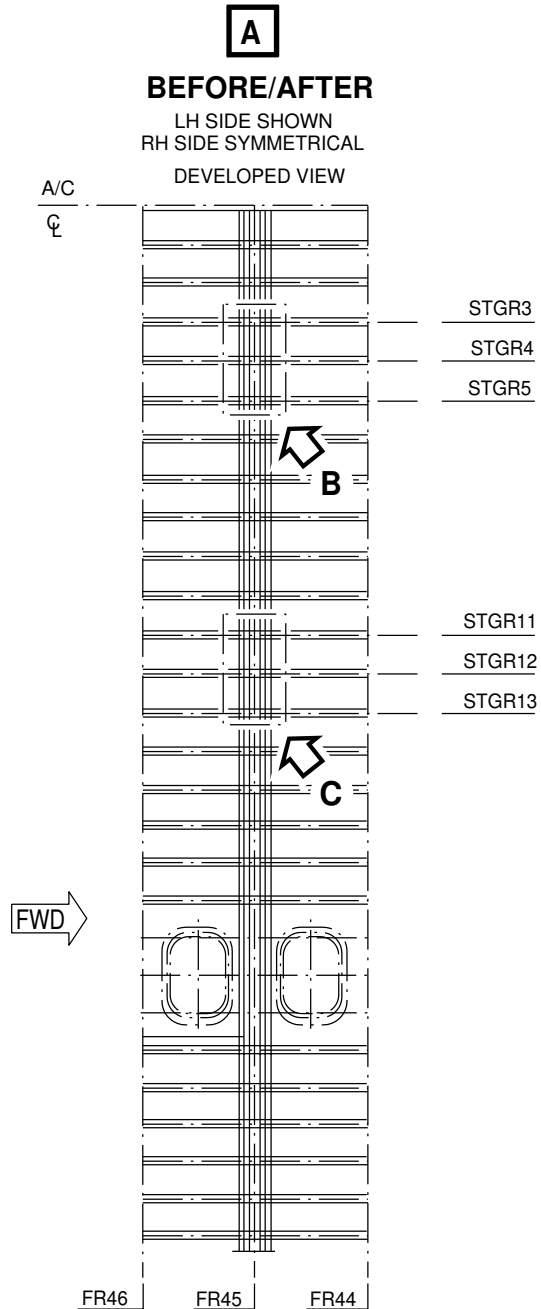
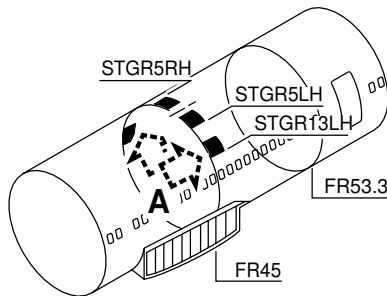
(b) Put the aircraft back to its initial configuration.

****CONF 002****(1) Subtask 533144-831-017-001 - Close-up**

Manpower Resources	
Skills	NON SPECIFIC

- (a) Remove the access platform(s).
- (b) Put the aircraft back to its initial configuration.

****CONF ALL**



G_SB_533144_5_BAAA_01_01

Figure A-FBAAA - Sheet 01
Replacement of the fasteners between STGR3 and STGR5 and between STGR11 and STGR13 on FR45.

5 DATE: Aug 23/05

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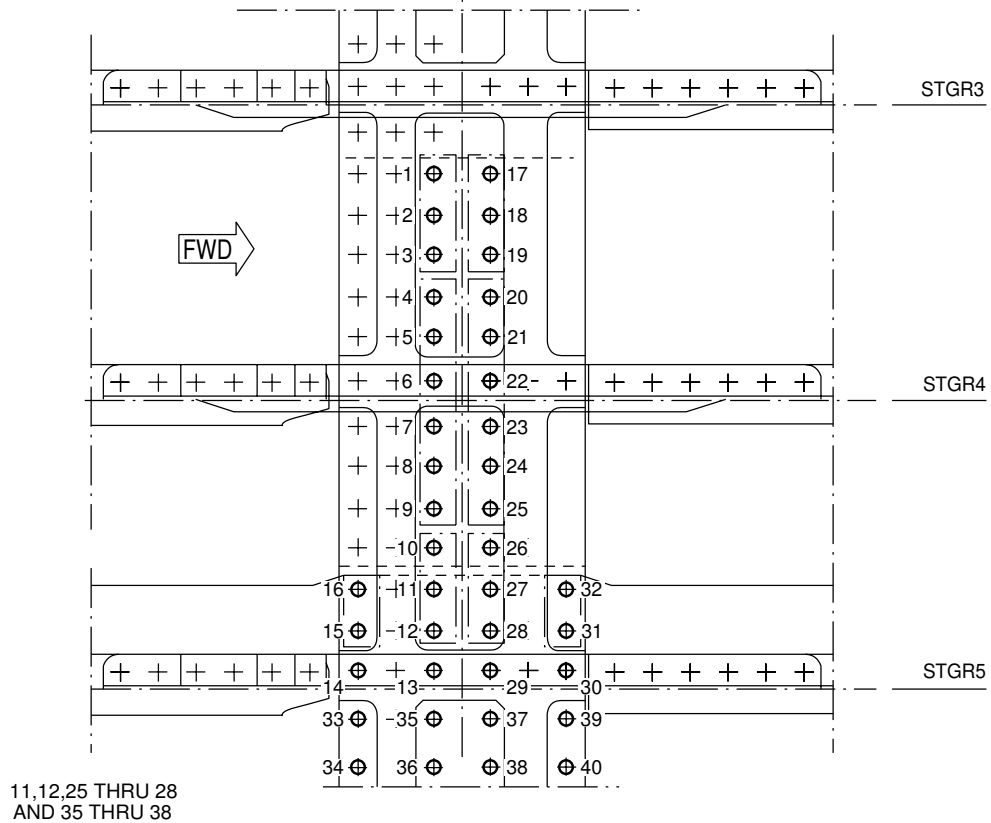
****CONF ALL**

B

BEFORE

VIEW LOOKING OUTBOARD

FR45



HOLES No.	FASTENER	NUT	EXISTING HOLES	
			Min. mm (in.)	Max. mm (in.)
1 THRU 4, 17 THRU 19, 35 thru 38	ASNA2391-4-09	ASNA2025-4	6,31 (0,248)	6,35 (0,25)
5 THRU 8, 20 THRU 24	ASNA2391-4-10	ASNA2025-4	6,31 (0,248)	6,35 (0,25)
9 THRU 14, 25 THRU 30	ASNA2391-4-11	ASNA2025-4	6,31 (0,248)	6,35 (0,25)
15,16,31 THRU 32	ASNA2391-4-08	ASNA2025-4	6,31 (0,248)	6,35 (0,25)
33, 34, 39 AND 40	ASNA2391-4-6	ASNA2025-4	6,31 (0,248)	6,35 (0,25)

G_SB_533144_5_BAAA_02_01

Figure A-FBAAA - Sheet 02

Replacement of the fasteners between STGR3 and STGR5 and between STGR11 and STGR13 on FR45.

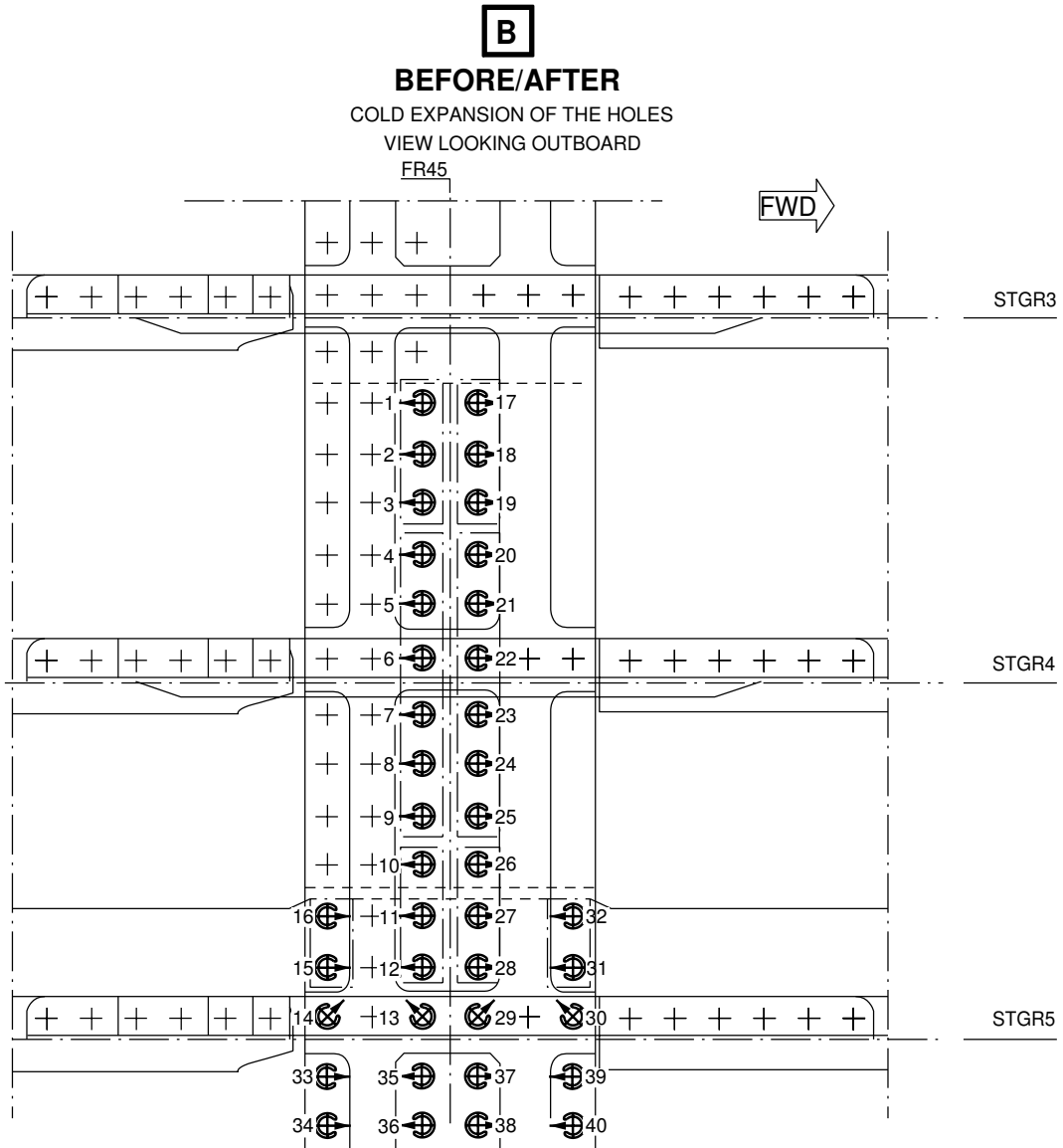
5 DATE: Aug 23/05

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****CONF ALL**



POSITIONING PRINCIPLE OF THE
INTERMEDIARY EXPANSION SLEEVE:

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G_SB_533144_5_BAAA_03_00

Figure A-FBAAA - Sheet 03
Replacement of the fasteners between STGR3 and STGR5 and between STGR11 and STGR13 on
FR45.

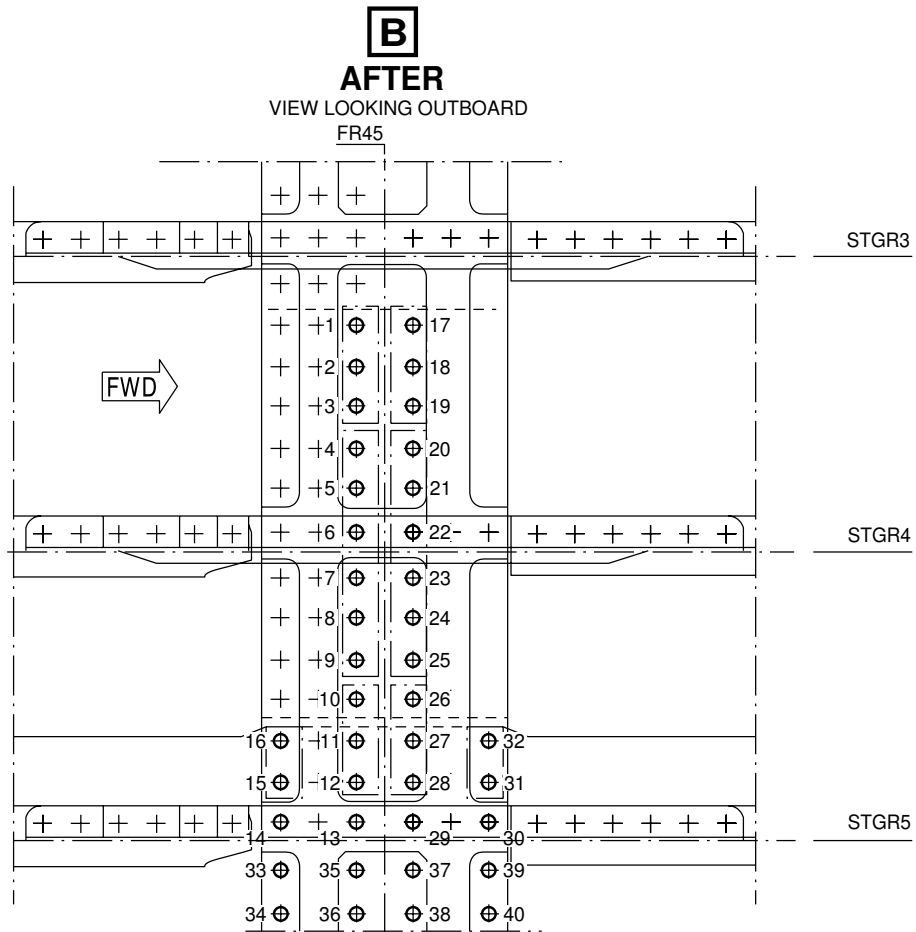
5 DATE: Aug 23/05

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HOLES No.	STARTING HOLE DIA.		STDN	FINAL HOLE DIA.		FASTENER	ITEM	NUT	ITEM
	MIN.	MAX.		MIN.	MAX.				
	mm (in.)	mm (in.)		mm (in.)	mm (in.)				
33, 34 39 AND 40	7,19 (0.283)	7,26 (0.286)	8-3-N	7,815 (0.308)	7,849 (0.309)	EN6114V5-6	20	ASNA2531-5	15
9 THRU 14, 25 THRU 30	7,19 (0.283)	7,26 (0.286)	8-3-N	7,815 (0.308)	7,849 (0.309)	EN6114V5-11	13	ASNA2531-5	15
5 THRU 8, 20 THRU 24	7,19 (0.283)	7,26 (0.286)	8-3-N	7,815 (0.308)	7,849 (0.309)	EN6114V5-10	12	ASNA2531-5	15
1 THRU 4, 17 THRU 19 AND 35 THRU 38	7,19 (0.283)	7,26 (0.286)	8-3-N	7,815 (0.308)	7,849 (0.309)	EN6114V5-9	11	ASNA2531-5	15
15, 16, 31 THRU 32	7,19 (0.283)	7,26 (0.286)	8-3-N	7,815 (0.308)	7,849 (0.309)	EN6114V5-8	10	ASNA2531-5	15

G_SB_533144_5_BAAA_04_03

Figure A-FBAAA - Sheet 04
Replacement of the fasteners between STGR3 and STGR5 and between STGR11 and STGR13 on FR45.

5 DATE: Aug 23/05

SERVICE BULLETIN No.: A330-53-3144

REVISION No.: 04 - Nov 23/15

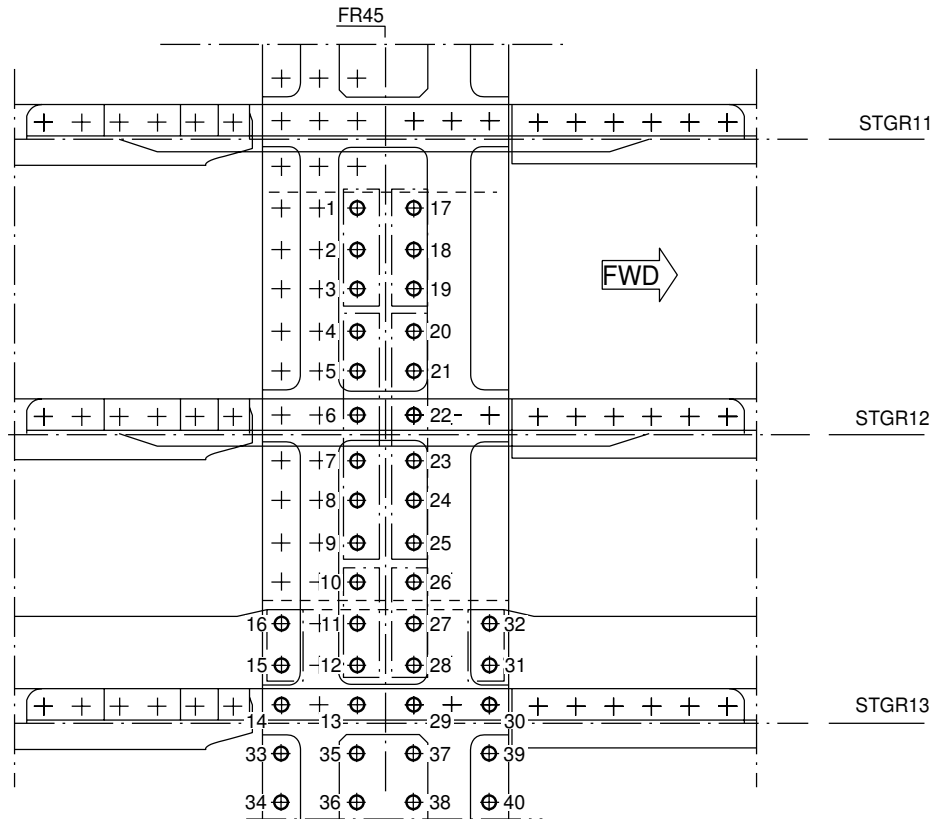
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****CONF ALL**

C

BEFORE

VIEW LOOKING OUTBOARD



HOLES No.	FASTENER	NUT	EXISTING HOLES	
			Min. mm (in.)	Max. mm (in.)
1 THRU 3, 17 THRU 19, 35 THRU 38	ASNA2391-4-09	ASNA2025-4	6,31 (0,248)	6,35 (0,25)
4 THRU 9 AND 20 THRU 24	ASNA2391-4-10	ASNA2025-4	6,31 (0,248)	6,35 (0,25)
10 THRU 14, 25 THRU 30	ASNA2391-4-11	ASNA2025-4	6,31 (0,248)	6,35 (0,25)
15, 16, 31, 32	ASNA2391-4-08	ASNA2025-4	6,31 (0,248)	6,35 (0,25)
33 AND 34, 39 and 40	ASNA2391-4-06	ASNA2025-4	6,31 (0,248)	6,35 (0,25)

G_SB_533144_5_BAAA_05_02

Figure A-FBAAA - Sheet 05

Replacement of the fasteners between STGR3 and STGR5 and between STGR11 and STGR13 on FR45.

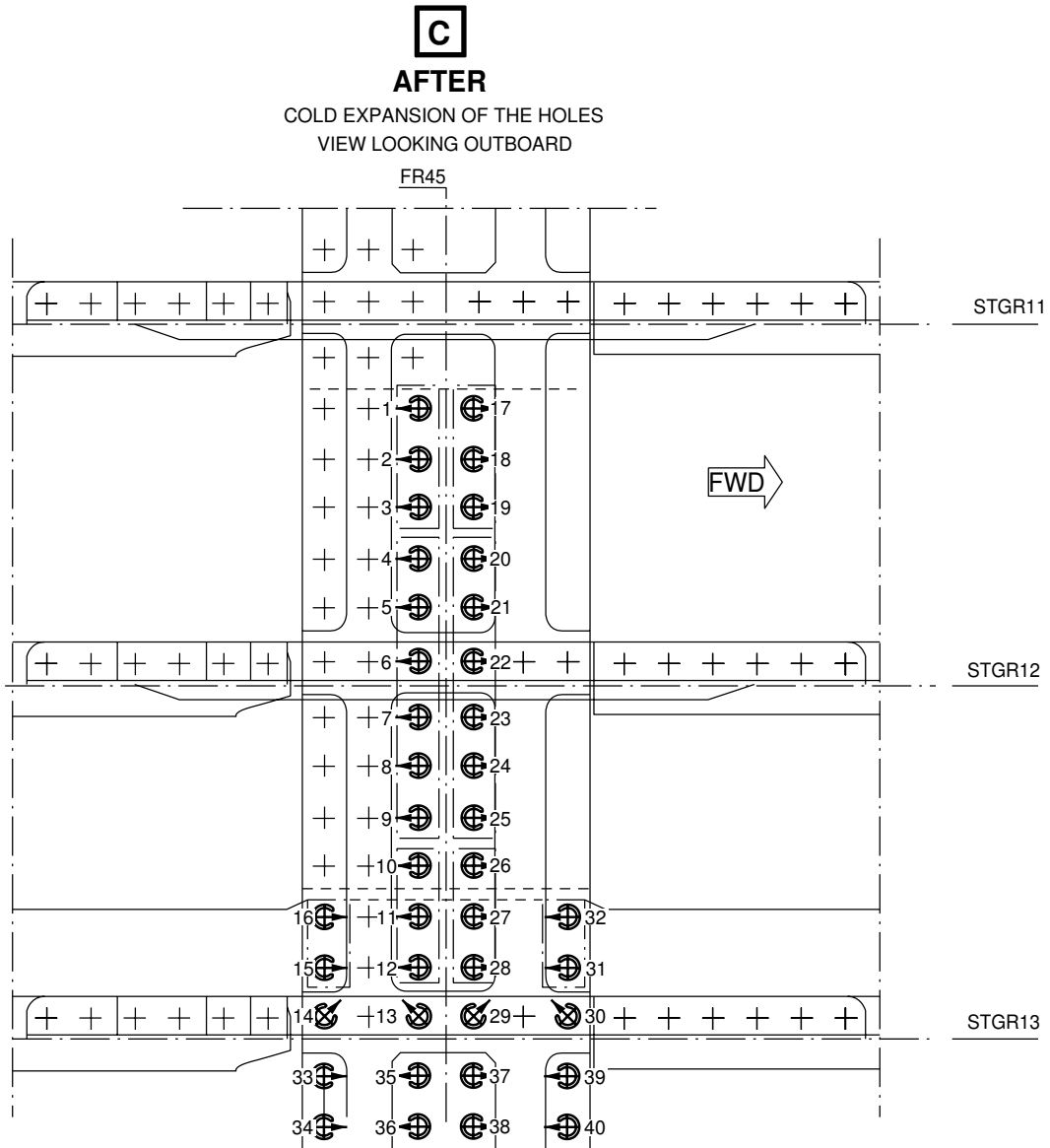
5 DATE: Aug 23/05

SERVICE BULLETIN No.: A330-53-3144

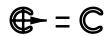
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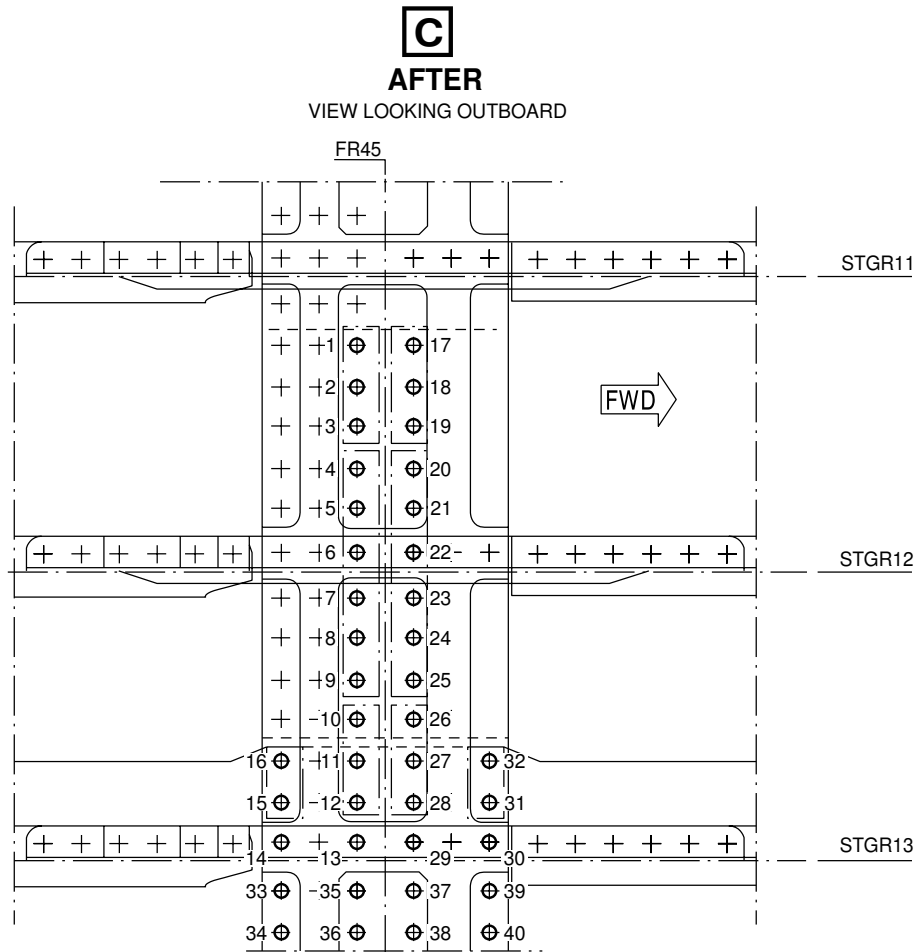
POSITIONING PRINCIPLE OF THE
INTERMEDIARY EXPANSION SLEEVE:



G_SB_533144_5_BAAA_06_00

Figure A-FBAAA - Sheet 06
Replacement of the fasteners between STGR3 and STGR5 and between STGR11 and STGR13 on
FR45.

****CONF ALL**



HOLES No.	STARTING HOLE DIA.		STDN	FINAL HOLE DIA.		FASTENER	ITEM	NUT	ITEM
	MIN.	MAX.		MIN.	MAX.				
	mm (in.)	mm (in.)		mm (in.)	mm (in.)				
10 THRU 14, 25 THRU 30	7,19 (0,283)	7,26 (0,286)	8-3-N	7,815 (0,308)	7,849 (0,309)	EN6114V5-11	13	ASNA2531-5	15
4 THRU 9 AND 20 THRU 24	7,19 (0,283)	7,26 (0,286)	8-3-N	7,815 (0,308)	7,849 (0,309)	EN6114V5-10	12	ASNA2531-5	15
1, 2, 3 AND 17 THRU 19, 35 THRU 38	7,19 (0,283)	7,26 (0,286)	8-3-N	7,815 (0,308)	7,849 (0,309)	EN6114V5-9	11	ASNA2531-5	15
15, 16, 31 THRU 32	7,19 (0,283)	7,26 (0,286)	8-3-N	7,815 (0,308)	7,849 (0,309)	EN6114V5-8	10	ASNA2531-5	15
33 AND 34, 39 AND 40	7,19 (0,283)	7,26 (0,286)	8-3-N	7,815 (0,308)	7,849 (0,309)	EN6114V5-6	20	ASNA2531-5	15

G_SB_533144_5_BAAA_07_02

Figure A-FBAAA - Sheet 07
Replacement of the fasteners between STGR3 and STGR5 and between STGR11 and STGR13 on FR45.

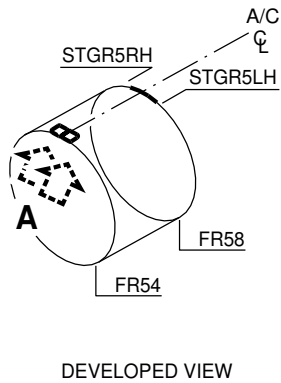
5 DATE: Aug 23/05

SERVICE BULLETIN No.: A330-53-3144

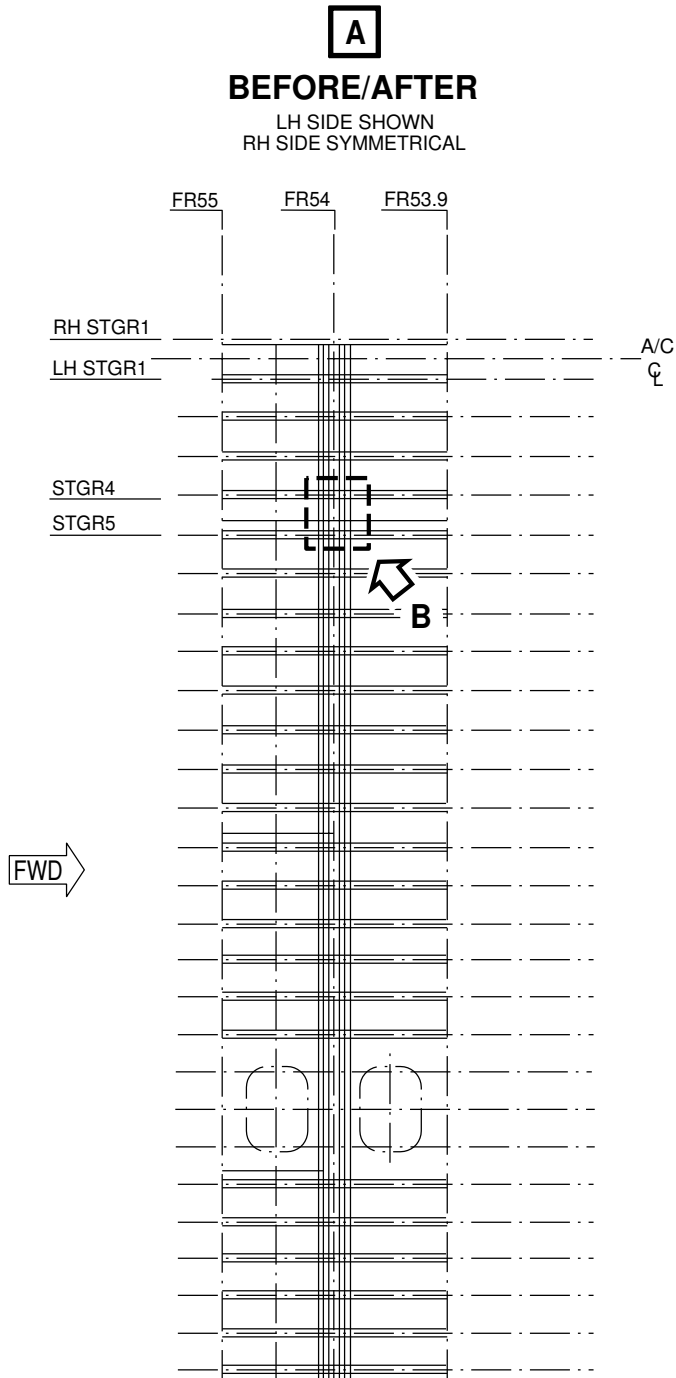
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****CONF 001**



DEVELOPED VIEW



G_SB_533144_5_BBAA_01_02

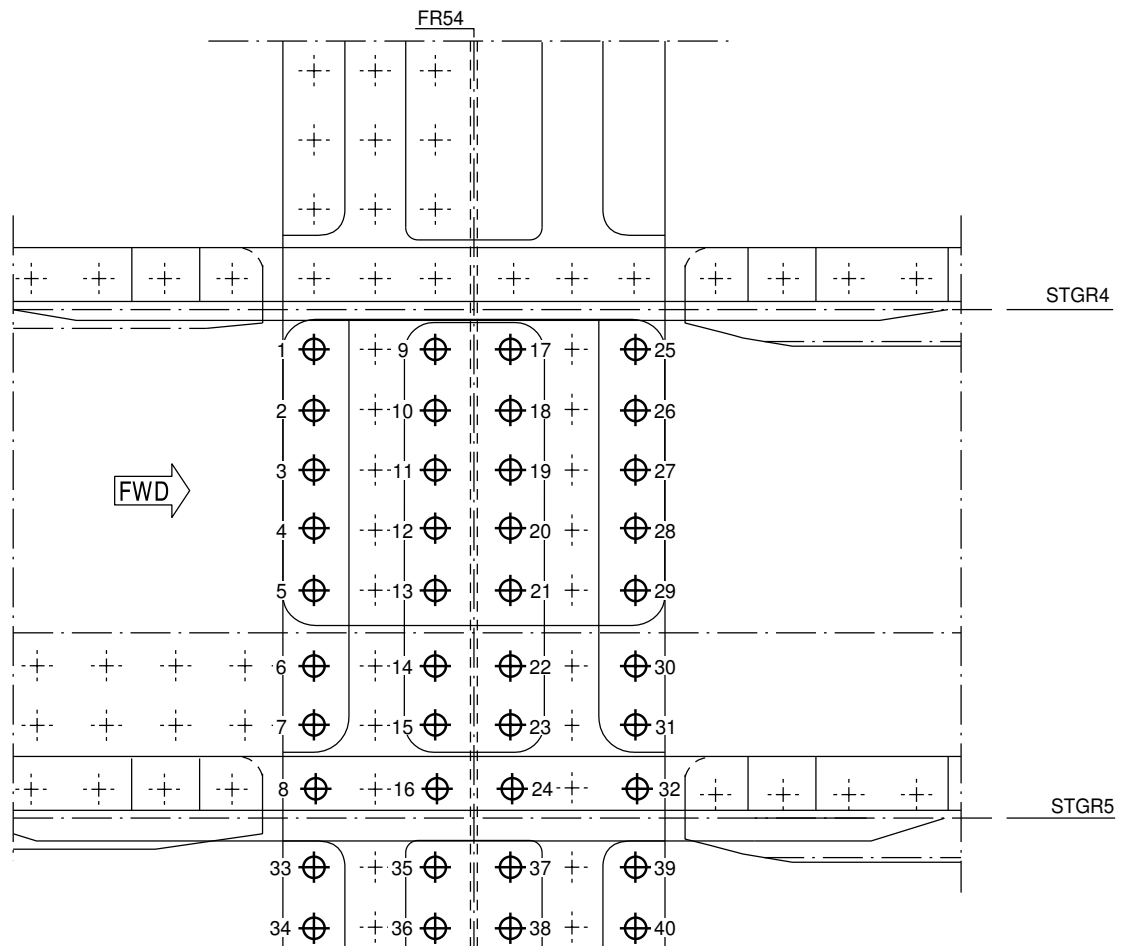
Figure A-FBBAA - Sheet 01
Replacement of the fasteners between STGR4 and STGR5 on FR54

****CONF 001**

B

BEFORE

VIEW LOOKING OUTBOARD



G_SB_533144_5_BBAA_02_02

Figure A-FBBAA - Sheet 02
Replacement of the fasteners between STGR4 and STGR5 on FR54

5 DATE: Aug 23/05

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HOLE	FASTENER	NUT	EXISTING HOLES	
			MIN.	MAX.
			mm (in.)	mm (in.)
4 THRU 7, 29 THRU 31	ASNA2391-3-07	ASNA2025-3	4.78 (0.188)	4.82 (0.190)
8 THRU 10, 16, THRU 18, 24 AND 32	ASNA2391-3-09	ASNA2025-3	4.78 (0.188)	4.82 (0.190)
11 THRU 15,	ASNA2391-3-10	ASNA2025-3	4.78 (0.188)	4.82 (0.190)
19 THRU 23	DAN6-6-10	NSA5075-6	4.78 (0.188)	4.82 (0.190)
1 THRU 3	ASNA2391-3-06	ASNA2025-3	4.78 (0.188)	4.82 (0.190)
33	ASNA2391-3-04	ASNA2025-3	4.78 (0.188)	4.82 (0.190)
34, 39 THRU 40	ASNA2391-3-05	ASNA2025-3	4.78 (0.188)	4.82 (0.190)
35 THRU 38	ASNA2391-3-08	ASNA2025-3	4.78 (0.188)	4.82 (0.190)
25 THRU 28	DAN6-5-6	NSA5075-5	4.125 (0.162)	4.16 (0.164)

G_SB_533144_5_BBAA_03_04

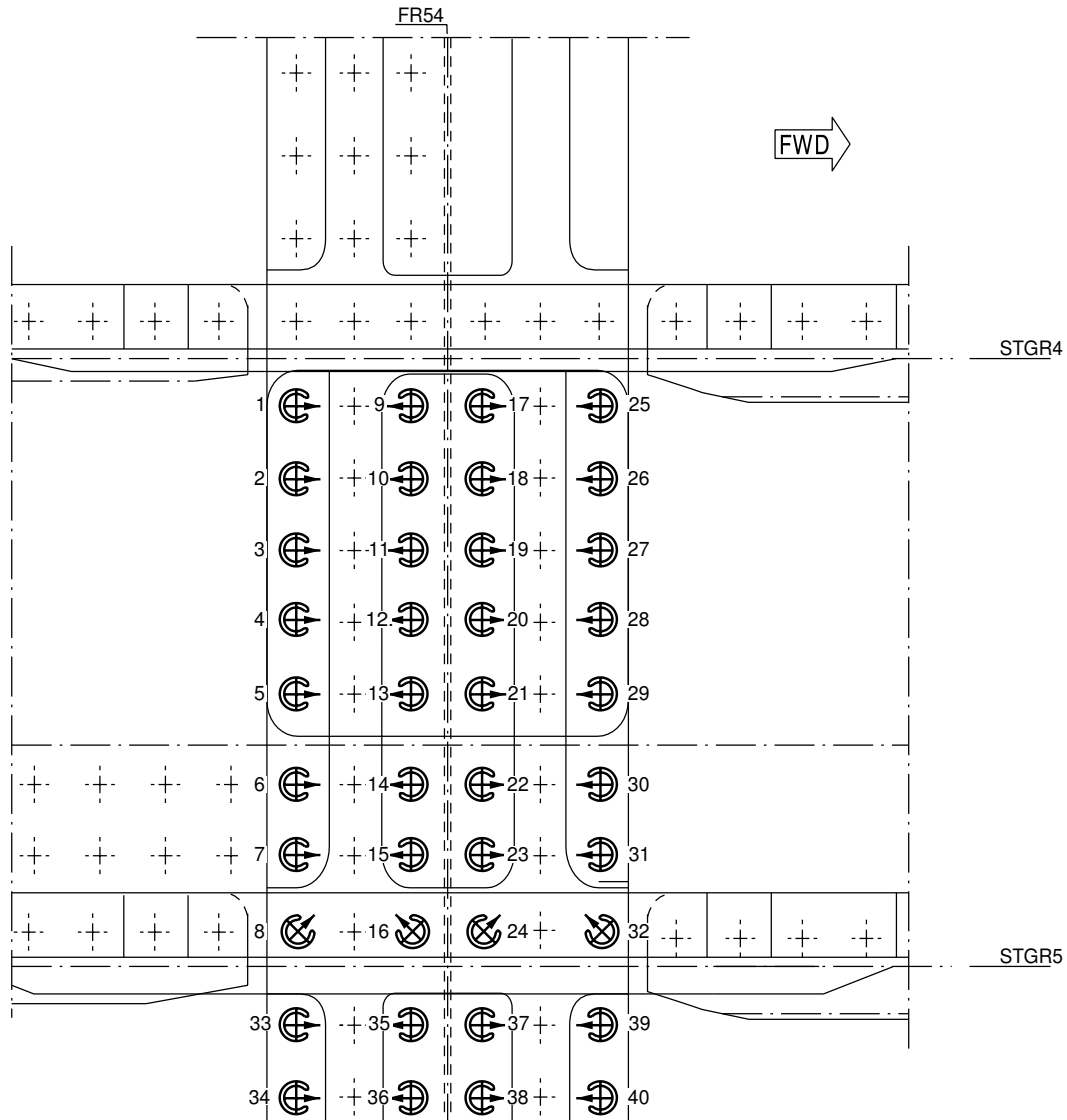
Figure A-FBBAA - Sheet 03
Replacement of the fasteners between STGR4 and STGR5 on FR54

****CONF 001**

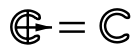
B

AFTER

COLD EXPANSION OF THE HOLES
VIEW LOOKING OUTBOARD



POSITIONING PRINCIPLE OF THE
INTERMEDIARY EXPANSION SLEEVE:



G_SB_533144_5_BBAA_04_02

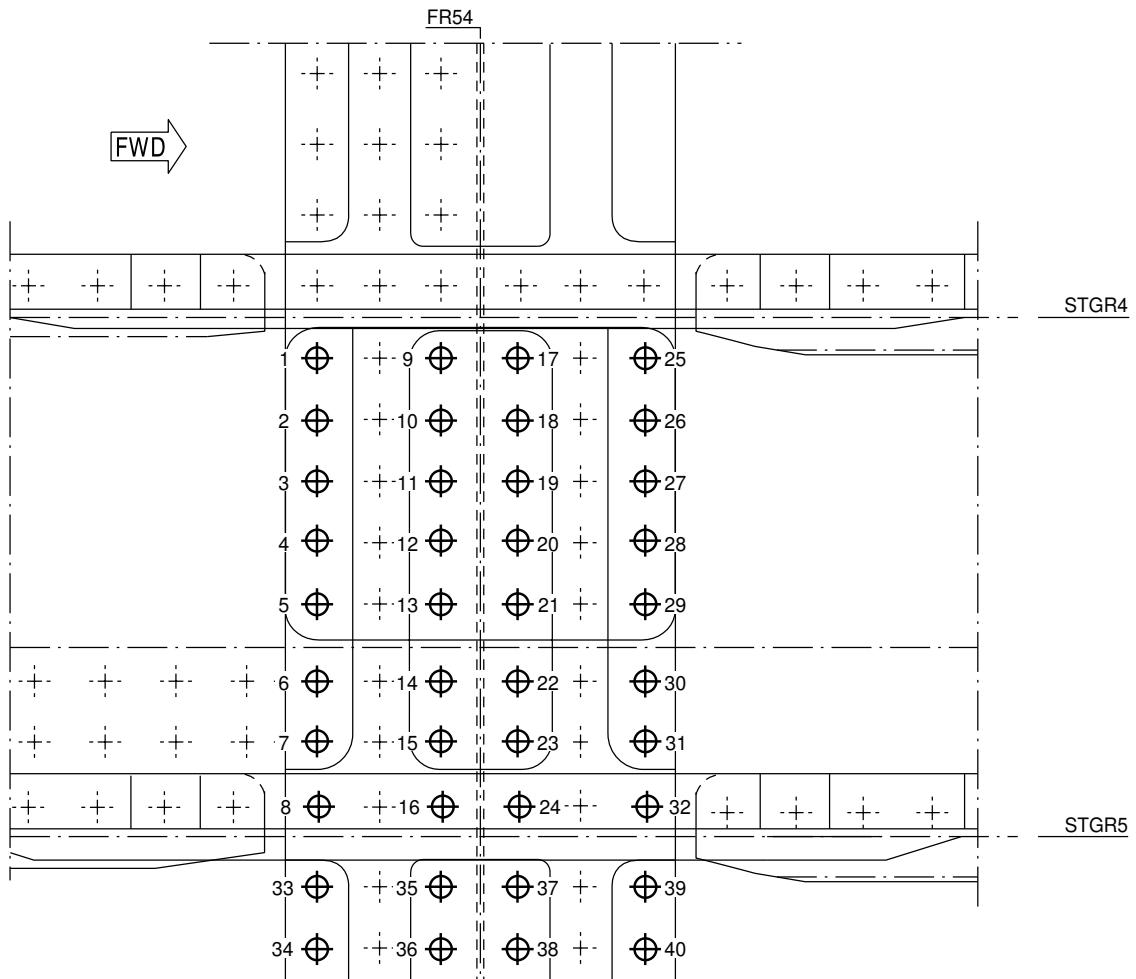
Figure A-FBBAA - Sheet 04
Replacement of the fasteners between STGR4 and STGR5 on FR54

****CONF 001**

B

AFTER

VIEW LOOKING OUTBOARD



G_SB_533144_5_BBAA_05_01

Figure A-FBBAA - Sheet 05
Replacement of the fasteners between STGR4 and STGR5 on FR54

****CONF 001**

HOLES No.	STARTING HOLE DIA.		STDN	FINAL HOLE DIA.		FASTENER	ITEM	NUT	ITEM
	MIN.	MAX.		MIN.	MAX.				
	mm (in.)	mm (in.)		mm (in.)	mm (in.)				
4 THRU 7, 29 THRU 31	5,715 (0,225)	5,791 (0,228)	6-3-N	6,227 (0.245)	6,262 (0.247)	EN6114V4-7	1	ASNA2531-4	6
8 THRU 10, 16 THRU 18, 24 AND 32	5,715 (0,225)	5,791 (0,228)	6-3-N	6,227 (0.245)	6,262 (0.247)	EN6114V4-9	3	ASNA2531-4	6
11 THRU 15, 19 THRU 23	5,715 (0,225)	5,791 (0,228)	6-3-N	6,227 (0.245)	6,262 (0.247)	EN6114V4-10	4	ASNA2531-4	6
35 THRU 38	5,715 (0,225)	5,791 (0,228)	6-3-N	6,227 (0.245)	6,262 (0.247)	EN6114V4-8	2	ASNA2531-4	6
33	5,715 (0,225)	5,791 (0,228)	6-3-N	6,227 (0.245)	6,262 (0.247)	EN6114V4-4	21	ASNA2531-4	6
34, 39 AND 40	5,715 (0,225)	5,791 (0,228)	6-3-N	6,227 (0.245)	6,262 (0.247)	EN6114V4-5	22	ASNA2531-4	6
1 THRU 3, 25 THRU 28	5,715 (0,225)	5,791 (0,228)	6-3-N	6,227 (0.245)	6,262 (0.247)	EN6114V4-6	23	ASNA2531-4	6

G_SB_533144_5_BBAA_06_01

Figure A-FBBAA - Sheet 06
Replacement of the fasteners between STGR4 and STGR5 on FR54

5 DATE: Aug 23/05

SERVICE BULLETIN No.: A330-53-3144

REVISION No.: 04 - Nov 23/15

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SERVICE BULLETIN
Appendix 01 - Elapsed Time Assumption

****CONF ALL**

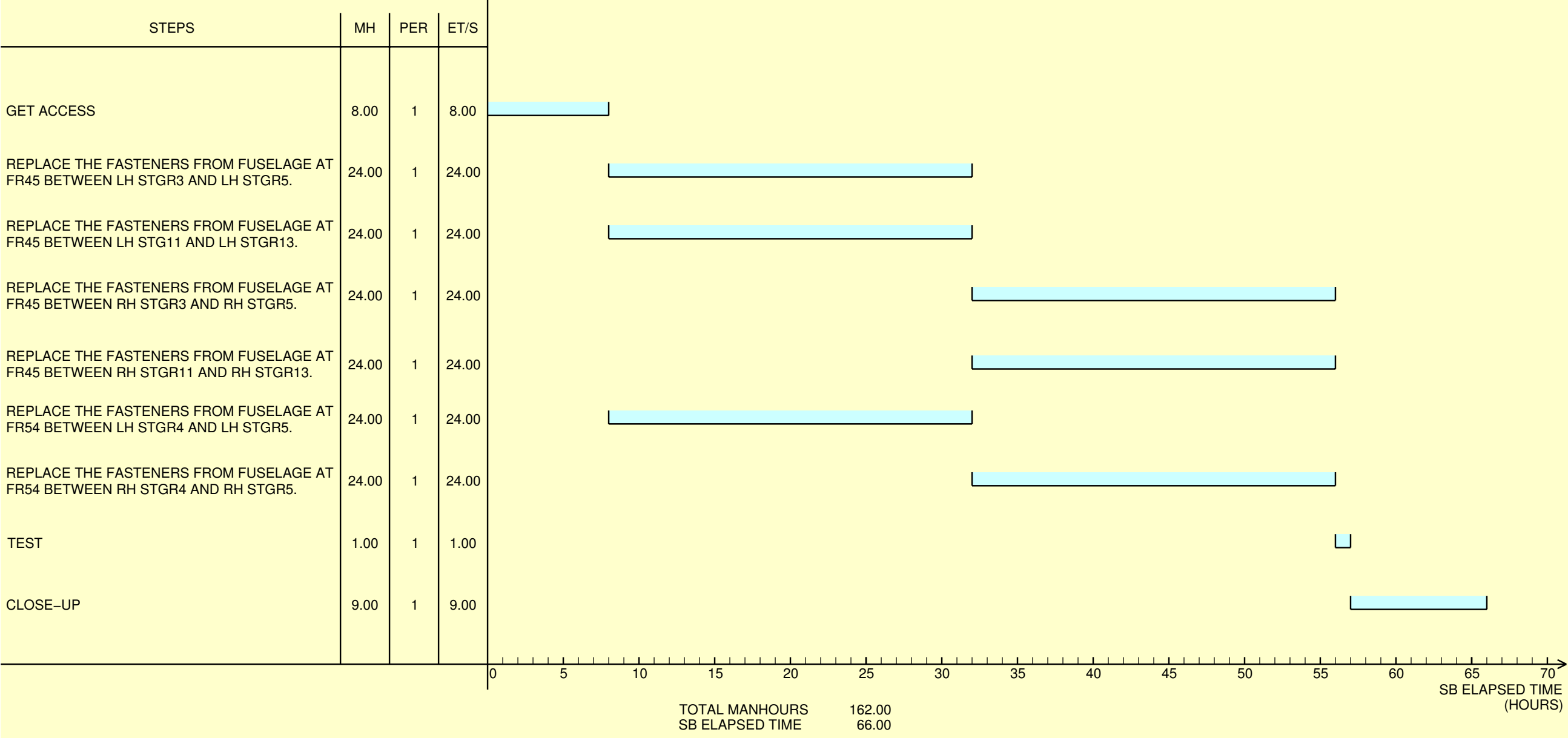
- (1) This chart is only a proposal. Operators may determine that another way to do the work is more suitable for them.

**CONF 001

ELAPSED TIME ASSUMPTIONS SERVICE BULLETIN No. A330-53-3144

01

02



NOTES:

01

THIS CHART IS ONLY A PROPOSAL.
OPERATORS MAY DETERMINE THAT ANOTHER WAY
TO DO THE WORK IS MORE SUITABLE FOR THEM.

02

MANHOURS GIVEN IN VENDOR SERVICE BULLETINS
ARE NOT REFLECTED IN THIS GANTT CHART.

MH : MANHOURS
PER: NUMBER OF PERSONS
ET/S: ELAPSED TIME PER STEP

G_SB_533144_5_AAAA_01_00

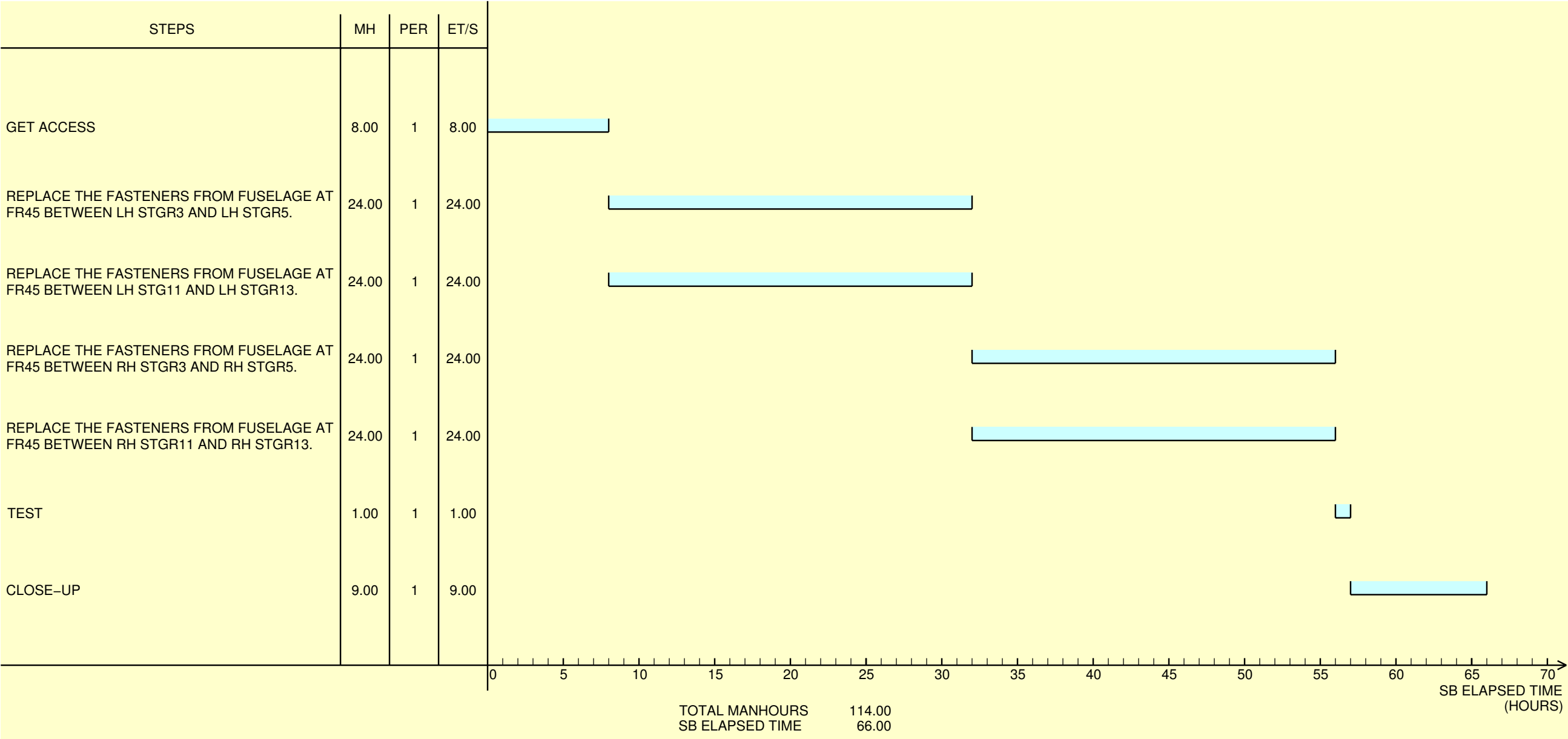
Figure A-FAAAA - Sheet 01
Gantt Chart

**CONF 002

ELAPSED TIME ASSUMPTIONS SERVICE BULLETIN No. A330-53-3144

01

02



- NOTES:
- 01

THIS CHART IS ONLY A PROPOSAL.
OPERATORS MAY DETERMINE THAT ANOTHER WAY
TO DO THE WORK IS MORE SUITABLE FOR THEM.
- 02

MANHOURS GIVEN IN VENDOR SERVICE BULLETINS
ARE NOT REFLECTED IN THIS GANTT CHART.

MH : MANHOURS
PER: NUMBER OF PERSONS
ET/S: ELAPSED TIME PER STEP

G_SB_533144_5_AAAB_01_00

Figure A-FAAAB - Sheet 01
Gantt Chart

**TITLE: FUSELAGE - CENTER FUSELAGE - CIRCUMFERENTIAL JOINTS AT
FRAME 45 AND 54 FATIGUE LIFE IMPROVEMENT.**

MODIFICATION No.: 52911S16337

Please complete the appropriate item (A or B):

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B - SB HAS BEEN embodied on aircraft:

Operator comments:

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