



SERVICE BULLETIN
REVISION TRANSMITTAL SHEET

AIRBUS
CUSTOMER SERVICES DIRECTORATE
1 Rond Point Maurice Bellonte
31707 BLAGNAC CEDEX FRANCE
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MANDATORY MANDATORY MANDATORY

ATA SYSTEM : 53

TITLE : FUSELAGE - FUSELAGE AFT SECTION - CHANGE FASTENER AT FR91

MODIFICATION No. : 13011D23063

This page transmits Revision No. 01 of Service Bulletin No. A310-53-2126.

ADDITIONAL WORK

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

REASON

This Revision is issued to :

- remove aircraft MSN 0419, 0427, 0430, 0454, 0468, 0486 and 0487 from the effectivity because they have no trim tank.
- remove aircraft MSN 0412 and 0504 from the effectivity (out of Service),
- add MSN 0441, 0444, 0522 and 0523 to the effectivity,
- introduce minor changes.

CHANGES

SUMMARY :

- REASON/DESCRIPTION/OPERATIONAL CONSEQUENCES
 - . EVALUATION TABLE, Kit prices added.
- EFFECTIVITY
 - . Effectivity updated.

PLANNING INFORMATION :

- EFFECTIVITY
 - . 1.A. Effectivity updated.

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MATERIAL INFORMATION :

- MATERIAL - PRICE AND AVAILABILITY
- Price and Availability
 - . 2.A.(2) Data for Kit D01, D02 and D03 updated.

ACCOMPLISHMENT INSTRUCTIONS :

- CLOSE-UP
 - . 3.D.(1)(d) Designation of the access door updated.

NOTE : Layout changes due to computerization of this revision are not identified.

FILING INSTRUCTIONS

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

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

HISTORY OF PREVIOUS REVISIONS

No previous revisions.

REVISION SEQUENCE

ORIGINAL : Nov 28/06

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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 - FUSELAGE AFT SECTION - CHANGE FASTENER AT FR91

MODIFICATION No. : 13011D23063

REASON/DESCRIPTION/OPERATIONAL CONSEQUENCES

Due to the recalculation of loads for the MultiRole Transporter and Tanker (MRTT) aircraft, it has been found that a structural reinforcement at FR91 is required. This reinforcement is only applicable to A310 aircraft with a Trim Tank installed.

This Service Bulletin details the work required to :

- for aircraft pre-modification 6922D6053 :
 - . replace the fasteners in the attachment areas of the upper and lower diagonal struts at FR91,
 - . install reinforcing brace plates on the diagonal struts between FR87 and FR91.
- For aircraft post-modification 6922D6053 :
 - . replace the fasteners in the attachment area of the diagonal struts at FR91.

Accomplishment of this Service Bulletin reinforces the structure by replacing the fasteners at the attachments of the diagonal struts at FR91 and reinforcing the diagonal struts between FR87 and FR91.

| EVALUATION TABLE | | | |
|----------------------|-----------|------------------------|----|
| COMPLIANCE | Mandatory | CANCELS INSPECTION SB | No |
| AD | Yes | A/C OPERATION AFFECTED | No |
| RELIABILITY AFFECTED | No | PAX COMFORT AFFECTED | No |
| COST SAVING | No | ETOPS AFFECTED | No |

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| EVALUATION TABLE | | | |
|----------------------|------|---------------------|-----|
| STRUCTURAL LIFE EXTN | No | VENDOR SB INVOLVED | No |
| KIT PRICE (USD) D01 | 648 | KIT PRICE (USD) D02 | 380 |
| KIT PRICE (USD) D03 | 4980 | | |

| MODIFICATION CLASSIFICATION | |
|-----------------------------|-------------|
| MAJOR | 13011D23063 |
| MINOR | None |

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.

EFFECTIVITY

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

34W 58X 82Z 99Y A1L AIC ARG BBC BLM CFC CSA DGA F2I FDX GAF IRA IRM IYE JAV KAC
MGL MPD MPJ MWA PIA QSC R1T RJA ROT RZO SBI SGX SUD TAP THY TSC UAE UZB WHT

CONCURRENT REQUIREMENTS

None

REFERENCES/REPERCUSSIONS

TFU : None
OEB : None
AOT : None
SIL : None
LIFE LIMIT : None
LINE MAINTENANCE AFFECTED : No
OTHERS : None

NATURE OF THE WORK

AIRCRAFT : Yes
EQUIPMENT : No
HARD : No
SOFT : No
OBRM : No

MANPOWER

Config. 01

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| | |
|----------------------|--------|
| TOTAL MANHOURS | 27.50 |
| ELAPSED TIME (HOURS) | 14.00 |
| Config. 02 | |
| TOTAL MANHOURS | 115.50 |
| ELAPSED TIME (HOURS) | 80.00 |
| Config. 03 | |
| TOTAL MANHOURS | 13.50 |
| ELAPSED TIME (HOURS) | 7.00 |

MATERIAL INFORMATION

AIRCRAFT DATA

Config. 01 and Config. 03

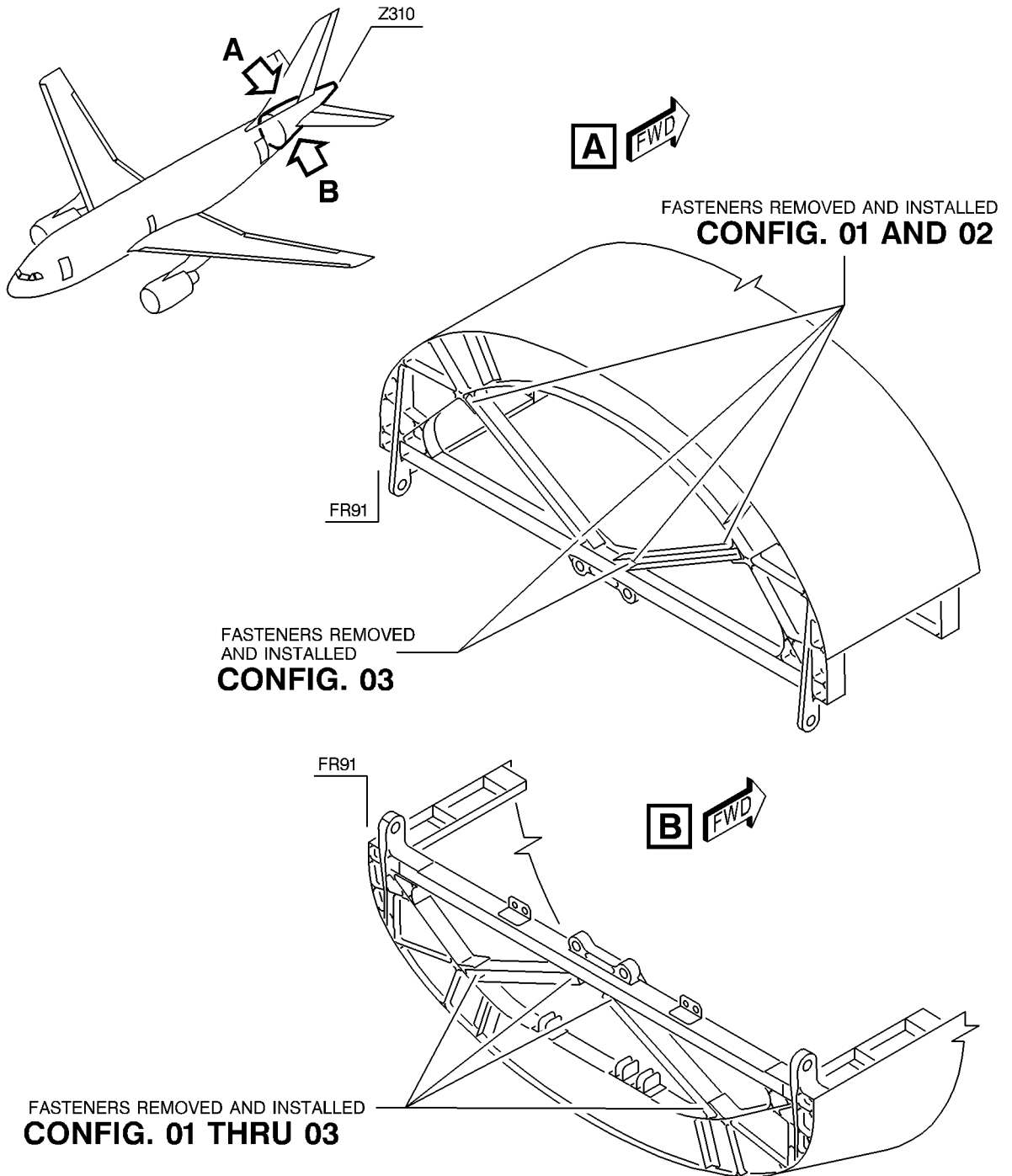
Pins and collars.

Config. 02

Pins, collars, profiles, sheets, stays, brace plates.

APPENDICES

None



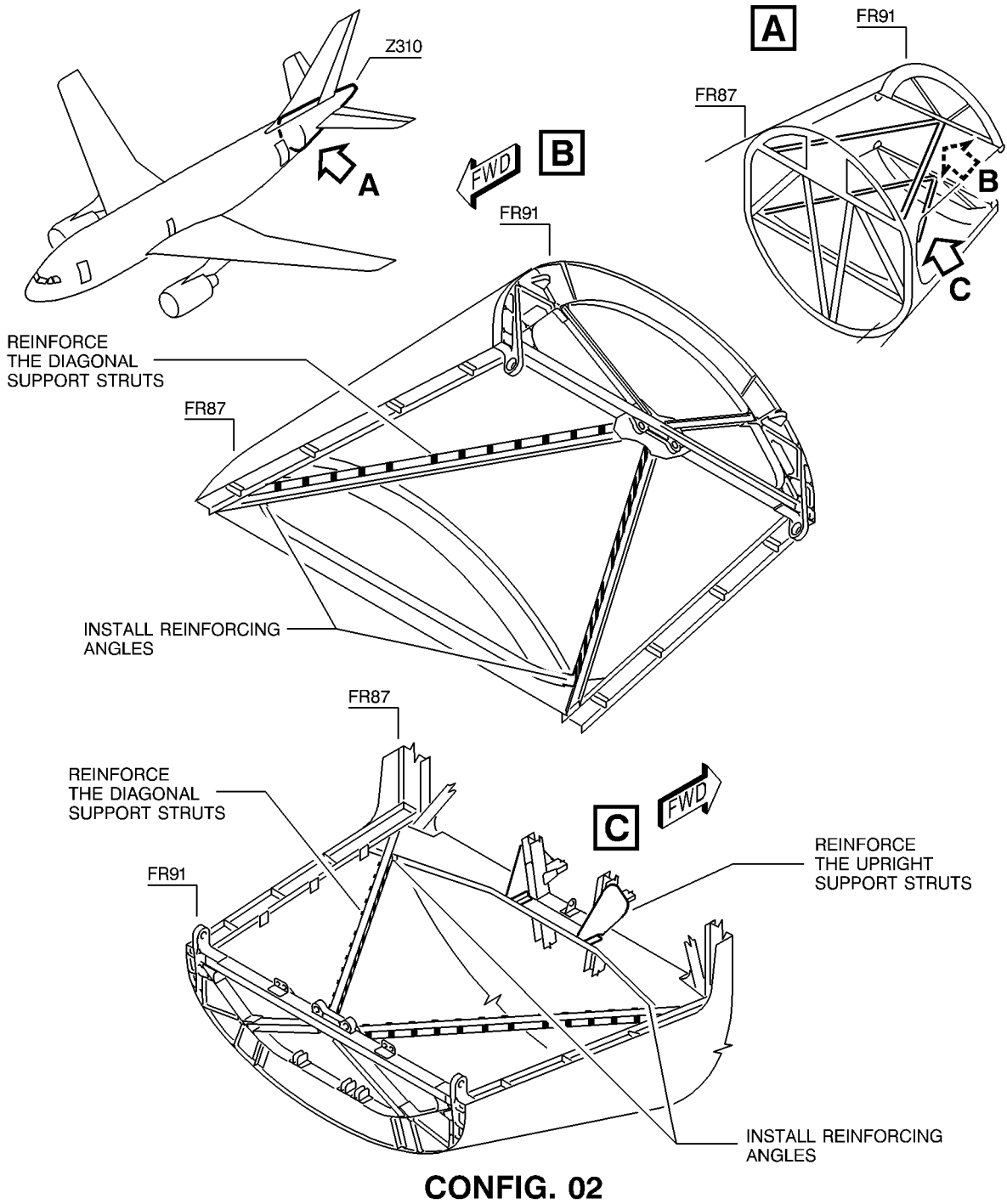
BB6 53 2126 AAMA-A

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ATA SYSTEM : 53

TITLE : FUSELAGE - FUSELAGE AFT SECTION - CHANGE FASTENER AT FR91

MODIFICATION No. : 13011D23063

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1. PLANNING INFORMATION

A. EFFECTIVITY

(1) Models

310-304 310-308 310-322 310-324 310-325

(2) Aircraft

(a) Effectivity by MSN

This Service Bulletin is applicable to aircraft MSN :

0378 0392 0399 0406 0407 0410 0413 0416 0418 0421 0422 0425
0428 0429 0431 0434 0436 0437 0439 0441 0444-0449 0451-0453
0455-0458 0467 0472 0473 0475 0476 0478 0480-0485 0488-0492
0494-0503 0519 0520 0522-0524 0526 0527 0531 0534 0535
0537-0539 0541 0542 0544 0545 0547-0552 0562 0564 0565 0567
0568 0571 0573 0574 0576 0585-0595 0597-0600 0620 0622 0624
0634 0636 0638 0640 0642 0644 0646-0654 0656 0658 0660 0661
0663 0665 0667 0669 0671 0672 0674 0676 0678 0680 0682 0684
0686 0687 0689 0691 0693 0695 0697 0698 0700 0702 0704 0706

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(b) 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 |
|----------|---|
| 34W | 0399 |
| 58X | 0431 |
| 82Z | 0550 0551 |
| 99Y | 0489 |
| A1L | 0648 |
| AIC | 0392 0406 0407 0413 0428 0429 0501 0538 0544 0548 0598 0654 0665 0669 0680 0684 0693 0695 0697 |
| ARG | 0640 0686 |
| BBC | 0594 0650 0698 0700 |
| BLM | 0488 |
| CFC | 0425 0441 0444 0446 0482 |
| CSA | 0564 0567 0672 0674 |
| DGA | 0418 0421 0422 |
| F2I | 0524 |
| FDX | 0378 0439 0449 0452 0456 0457 0458 0467 0492 0500 0534 0539 0542 0549 0552 0589 0593 0634 0638 |
| GAF | 0434 0484 0498 0499 0503 0522 0523 |
| IRA | 0436 0671 |
| IRM | 0537 0586 |
| IYE | 0535 0568 0702 0704 |
| JAV | 0481 |
| KAC | 0647 0649 0663 |
| MGL | 0526 |
| MPD | 0451 0455 0642 |
| MPJ | 0410 |
| MWA | 0652 |
| PIA | 0473 0585 0587 0590 0653 0656 0660 0676 0678 0682 0687 0689 0691 |
| QSC | 0620 |
| R1T | 0591 |
| RJA | 0416 0445 0490 0491 0531 |
| ROT | 0636 0644 |

| OPERATOR | MSN |
|----------|--|
| RZO | 0571 0624 0651 0661 |
| SBI | 0453 0475 0520 |
| SGX | 0519 0562 |
| SUD | 0437 |
| TAP | 0483 0494 0495 0541 0565 0573 |
| THY | 0476 0478 0480 0496 0497 0502 |
| TSC | 0447 0472 0485 0527 0545 0547 0588 0595 0597 0599 0600 0658 |
| UAE | 0592 0622 0646 0667 |
| UZB | 0574 0576 0706 |
| WHT | 0448 |

(c) Effectivity by MSN and Kit/Configuration

The kits and configurations applicable to these MSNs are given at the end of this list:

0418 0425 0441 0444 0446-0448 0472 0475 0481-0483 0485 0489
0492 0494-0503 0519-0520 0522-0524 0526-0527 0531 0534-0535
0537-0539 0541-0542 0544-0545 0547-0552 0562 0564-0565
0567-0568 0571 0573-0574 0576 0585-0591

| KIT No. | QTY PER A/C | CONFIGURATION |
|--------------|-------------|---------------|
| 532126D01R00 | 1 | 01 |

The kits and configurations applicable to these MSNs are given at the end of this list:

0378 0434 0439 0445 0449 0451-0453 0455-0458 0467 0473 0488
0491

| KIT No. | QTY PER A/C | CONFIGURATION |
|--------------|-------------|---------------|
| 532126D01R00 | 1 | 01 02 |
| 532126D03R02 | 1 | 02 |

The kits and configurations applicable to these MSNs are given at the end of this list:

0392 0399 0406-0407 0410 0413 0416 0421-0422 0428-0429 0431
0436-0437 0476 0478 0480 0484 0490

| KIT No. | QTY PER A/C CONFIGURATION | |
|--------------|---------------------------|----|
| 532126D01R00 | 1 | 02 |
| 532126D03R02 | 1 | 02 |

The kits and configurations applicable to these MSNs are given at the end of this list:

0592-0595 0597-0600 0620 0622 0624 0634 0636 0638 0640 0642
0644 0646-0654 0656 0658 0660-0661 0663 0665 0667 0669
0671-0672 0674 0676 0678 0680 0682 0684 0686-0687 0689 0691
0693 0695 0697-0698 0700 0702 0704 0706

| KIT No. | QTY PER A/C CONFIGURATION | |
|--------------|---------------------------|----|
| 532126D02R00 | 1 | 03 |

NOTE : Config. 01 is applicable to aircraft on which Service Bulletin A310-53-2072 (Mod. No. 6922D6053) is accomplished or Mod. No. 6922D6053 (FUSELAGE - STRUCTURE - REINFORCE STRUCTURE TO MAKE PROVISION FOR INCREASED DESIGN WEIGHTS (157T/124T/114T)) has been embodied in production.

NOTE : Config. 02 is applicable to aircraft on which Service Bulletin A310-53-2072 (Mod. No. 6922D6053) is not accomplished or Mod. No. 6922D6053 (FUSELAGE - STRUCTURE - REINFORCE STRUCTURE TO MAKE PROVISION FOR INCREASED DESIGN WEIGHTS (157T/124T/114T)) is not embodied.

NOTE : Config. 03 is applicable to aircraft on which Mod. No. 6922D6053 (FUSELAGE - STRUCTURE - REINFORCE STRUCTURE TO MAKE PROVISION FOR INCREASED DESIGN WEIGHTS (157T/124T/114T)) and Mod. No. 8128D7920 (STRUCTURE - REAR FUSELAGE - REINFORCE STRUCTURE TO MAKE PROVISIONS FOR MTOW 164T) have been embodied in production.

(3) Spares

None

B. CONCURRENT REQUIREMENTS

None

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C. REASON**(1) History**

Due to the recalculation of loads for the Multi Role Transporter and Tanker (MRTT) aircraft, it has been found that a structural reinforcement at FR91 is required. This reinforcement is only applicable to A310 aircraft with a Trim Tank installed.

(2) Objective/Action

This Service Bulletin details the work required to :

- for aircraft pre-modification 6922D6053 :
 - . replace the fasteners in the attachment areas of the upper and lower diagonal struts at FR91,
 - . install reinforcing brace plates on the diagonal struts between FR87 and FR91.
- For aircraft post-modification 6922D6053 :
 - . replace the fasteners in the attachment area of the diagonal struts at FR91.

(3) Advantages

Accomplishment of this Service Bulletin reinforces the structure by replacing the fasteners at the attachments of the diagonal struts at FR91 and reinforcing the diagonal struts between FR87 and FR91.

(4) Operational/Maintenance Consequences

This Service Bulletin is based on the aircraft configuration as known by AIRBUS (first aircraft delivery configuration and modified by the reported incorporation of AIRBUS SBs). Prior to Service Bulletin embodiment, the operator is reminded to pay specific attention to structural damage which may exist and to repairs which were performed on the aircraft because they may be affected by the Service Bulletin. Operators must verify that all allowable damage limits and repairs performed (both in accordance with the SRM and outside of the SRM) are still applicable and effective to the new Service Bulletin configuration. There may be additional or modified maintenance requirements, such as temporary limits or additional inspections, that apply with respect to the Service Bulletin configuration. AIRBUS disclaims any liability for the effect which the Service Bulletin may have on repairs performed on the aircraft before embodiment of the Service Bulletin. If the post Service Bulletin repair status is no more covered by the SRM and for repairs outside of the SRM covered by a RAS issued by AIRBUS, the operator should contact AIRBUS Customer Services Repair Engineering Support (SER1). Repair review will be done by AIRBUS at conditions of the Customer Services Catalogue.

D. DESCRIPTION

To accomplish this Service Bulletin it is necessary to :

- (1) Config. 01
 - (a) Replace the fasteners in the upper support struts at FR91, LH and RH.
 - (b) Replace the fasteners in the lower support struts at FR91, LH and RH.
- (2) Config. 02
 - (a) Replace the fasteners in the upper support struts at FR91, LH and RH.
 - (b) Replace the fasteners in the lower support struts at FR91, LH and RH.
 - (c) Reinforce the upright support struts at FR87.
 - (d) Reinforce the upper diagonal support-struts.
 - (e) Reinforce the lower diagonal support-struts.
 - (f) Install the reinforcement angles on the diagonal support struts.
- (3) Config. 03
 - (a) Replace the fasteners in the upper support struts at FR91, LH and RH.
 - (b) Replace the fasteners in the lower support struts at FR91, LH and RH.

E. COMPLIANCE

- (1) Classification
Mandatory
- (2) Accomplishment Timescale

At the next convenient maintenance opportunity not exceeding 2,500 Flight Cycles (FC) from the issue of the Airworthiness Directive.

Accomplishment of this Service Bulletin is expected to be rendered mandatory by the issue of an Airworthiness Directive (AD) published by the European Aviation Safety Agency (EASA). It is anticipated that the AD will confirm the (thresholds and/or intervals and/or date) given above but reference should be made to the AD for confirmation of the mandated accomplishment timescale.

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F. APPROVAL

Approved under EASA 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.

Config. 01

| | |
|-----------------------|-------|
| Get access | 1.50 |
| Replace the fasteners | 25.00 |
| Close up | 1.00 |
| TOTAL MANHOURS | 27.50 |
| ELAPSED TIME (HOURS) | 14.00 |

Config. 02

| | |
|--------------------------------|--------|
| Get access | 1.50 |
| Replace the fasteners | 25.00 |
| Install the reinforcing stays | 20.00 |
| Install the brace plates | 60.00 |
| Install the reinforcing angles | 8.00 |
| Close up | 1.00 |
| TOTAL MANHOURS | 115.50 |
| ELAPSED TIME (HOURS) | 80.00 |

Config. 03

| | |
|-----------------------|-------|
| Get access | 1.50 |
| Replace the fasteners | 11.00 |
| Close up | 1.00 |

TOTAL MANHOURS 13.50
ELAPSED TIME (HOURS) 7.00

H. WEIGHT AND BALANCE

Config. 01

Manufacturers Empty Weight : +0.16 kg (+0.3527 lb)
Effect on Balance : +7.69 kgm (+55.621 lb.ft)

Config. 02

Manufacturers Empty Weight : +2.15 kg (+4.7398 lb)
Effect on Balance : +101.76 kgm (+736.030 lb.ft)

Config. 03

Manufacturers Empty Weight : +0.11 kg (+0.2425 lb)
Effect on Balance : +5.29 kgm (+38.262 lb.ft)

I. ELECTRICAL LOAD DATA

Not changed

J. REFERENCES

Aircraft Maintenance Manual (AMM) : 06-31-53 06-41-53 24-00-00
52-41-00 55-00-00
Elec. Std. Practices Manual (ESPM) : 20-55-00
Non destructive Testing Manual (NTM) : 51-10-01
Structural Repair Manual (SRM) : 51-40-30 51-40-44

Consumable Material List (CML)

Standards Manual (SM)

K. PUBLICATIONS AFFECTED

Structural Repair Manual (SRM) : 53-19-18 53-19-47

L. INTERCHANGEABILITY/MIXABILITY

Not applicable

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2. MATERIAL INFORMATIONA. MATERIAL – PRICE AND AVAILABILITY

(1) Material

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 :

AIRBUS
SPARES SUPPORT AND SERVICES
Weg beim Jaeger 150
D-22335 HAMBURG
GERMANY

For ordering by internet:<http://spares.airbus.com>
For ordering by fax: +49 40 50 76 25 90

(2) Price and Availability

Kit 532126D01R00

Cost : 648 US Dollars

Availability : 150 calendar days from receipt of order

The Kit availability given above is the standard lead time from the date of your purchase order. If you require the Kit(s) 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 at the issue date of the Service Bulletin.

Kit 532126D02R00

Cost : 380 US Dollars

Availability : 150 calendar days from receipt of order

The Kit availability given above is the standard lead time from the date of your purchase order. If you require the Kit(s) 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 at the issue date of the Service Bulletin.

Kit 532126D03R02

Cost : 4980 US Dollars

Availability : 150 calendar days from receipt of order

The Kit availability given above is the standard lead time from the date of your purchase order. If you require the Kit(s) 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 at the issue date of the Service Bulletin.

B. INDUSTRY SUPPORT INFORMATION

For aircraft out of warranty, modification of parts/equipment is at no charge for the Operator. The man-hours indicated in this Service Bulletin will remain at the Operators' cost.

For aircraft under warranty at the SB issue date, Airbus will provide the material at no charge, and will credit the manhours indicated in this Service Bulletin at the operator's agreed in-house warranty labor rate upon receipt of a warranty claim.

C. LIST OF COMPONENTS

Kit 532126D01R00

| ITEM | NEW PART No. | QTY | UM | KEYWORD | ITEM | OLD PART No. | INT | INST | DISP |
|------|--------------|-----|----|---------|------|--------------|-----|------|------|
| 1 | DAN7-6-7 | 28 | | PIN | | | | | |
| 2 | DAN7-6-9 | 26 | | PIN | | | | | |
| 3 | DAN12-6 | 54 | | COLLAR | | | | | |

NOTE : Refer to the AIRBUS Standards Manual (SM) 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. The SM will give you the correct part number to part number relationship.

Kit 532126D02R00

| ITEM | NEW PART No. | QTY | UM | KEYWORD | ITEM | OLD PART No. | INT | INST | DISP |
|------|--------------|-----|----|---------|------|--------------|-----|------|------|
| 1 | DAN7-6-7 | 4 | | PIN | | | | | |
| 2 | DAN7-6-9 | 26 | | PIN | | | | | |
| 3 | DAN12-6 | 30 | | COLLAR | | | | | |

NOTE : Refer to the AIRBUS Standards Manual (SM) 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. The SM will give you the correct part number to part number relationship.

Kit 532126D03R02

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| ITEM | NEW PART No. | QTY | UM | KEYWORD | ITEM | OLD PART No. | INT | INST | DISP |
|------|----------------|-----|----|----------|------|--------------|-----|------|------|
| 3 | DAN12-6 | 38 | | COLLAR | | | | | |
| 4 | A5398725920000 | 1 | | STAY | | | | | |
| 5 | A5398725920100 | 1 | | STAY | | | | | |
| 6 | A5398725920200 | 1 | | PROFILE | | | | | |
| 7 | A5398725920300 | 1 | | PROFILE | | | | | |
| 8 | A5398725920400 | 1 | | SHEET | | | | | |
| 9 | A5398725920500 | 1 | | SHEET | | | | | |
| 10 | A5398725920600 | 1 | | SHEET | | | | | |
| 11 | A5398725920700 | 1 | | SHEET | | | | | |
| 13 | A5398842820000 | 54 | | PLATE | | | | | |
| 14 | DAN7-6-6X | 8 | | PIN | | | | | |
| 15 | DAN12-6X | 14 | | COLLAR | | | | | |
| 16 | HL1012VDF6-4 | 38 | | PIN | | | | | |
| 17 | DAN7-5A3 | 236 | | PIN | | | | | |
| 18 | DAN8-6-4X | 2 | | PIN | | | | | |
| 19 | DAN7-6-5X | 4 | | PIN | | | | | |
| 20 | DAN7-5A4 | 34 | | PIN | | | | | |
| 21 | DAN12-5 | 270 | | COLLAR | | | | | |
| 22 | ASNA0082A302 | 2 | | BOLT | | | | | |
| 23 | NAS1671-3L2 | 4 | | FASTENER | | | | | |

NOTE : Refer to the AIRBUS Standards Manual (SM) 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. The SM will give you the correct part number to part number relationship.

D. LIST OF MATERIALS – OPERATOR SUPPLIED

(1) Consumable Materials

| DESCRIPTION | REFERENCE TO CML MAT. No. | QTY PER A/C | INST DISP |
|--|---------------------------|-------------|-----------|
| Solvent General Purpose | 11-026 | As required | |
| Anti-Corrosion Primer (Polyurethane) | 16-001 | As required | |
| Polyurethane Topcoat Grey (For Internal Applic.) | 16-002 | As required | |
| Wash Primer | 16-020 | As required | |
| Lint-Free Cotton Cloth | 19-003 | As required | |

(2) Components

None

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E. PARTS TO BE RE-IDENTIFIED BY THE OPERATOR

None

F. TOOLING – PRICE AND AVAILABILITY

To accomplish this Service Bulletin it is necessary to use the tools listed in AMM 55-00-00 Page block 301 and NTM 51-10-01 Page block 601, Procedure A.

G. SPECIAL TOOLS

None

3. ACCOMPLISHMENT INSTRUCTIONS

A. GENERAL

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 ELECTRICAL 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.

(1) Preparation

(a) Config. 01 thru Config. 03

- 1 Make sure that the aircraft is electrically grounded, (Refer to AMM 24-00-00 Page block 301).
- 2 Put the access platforms in position.
- 3 Open the access doors 312AR and 313AL, (Refer to AMM 52-41-00 Page block 001).
- 4 Make the Trimmable Horizontal Stabilizer (THS) safe, (Refer to AMM 55-00-00 Page block 301).
- 5 In the cockpit, put a warning notice in position to tell persons not to operate the pitch-trim control wheels.

(2) Standard Practices

- (a) Refer to the AIRBUS Standards Manual (SM) 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. The SM will give you the correct part number to part number relationship.
- (b) Refer to the Consumable Material List (CML) for the specification of the materials (Mat. No.) that you must use to accomplish this Service Bulletin.

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- (c) For the identification of access panels, (Refer to AMM 06-41-53 Page block 001).
- (d) For Frame (FR) identification, (Refer to AMM 06-31-53 Page block 001).
- (e) For fastener hole and drill data, (Refer to SRM 51-40-44 Page block 001).
- (f) After drilling, remove all the burrs from the holes.
- (g) For alternative and substitute fasteners, (Refer to SRM 51-40-30 Page block 001).
- (h) Clean the work area as necessary with Solvent General Purpose (Mat No. 11-026) and a Lint-Free Cotton Cloth (Mat No. 19-003) .
- (i) On reworked areas, apply :
 - Wash Primer (Mat No. 16-020)
 - Anti-Corrosion Primer (Polyurethane) (Mat No. 16-001)
 - Polyurethane Topcoat Grey (For Internal Applic.) (Mat No. 16-002) .
- (j) When you remove the fasteners, do a rotating probe inspection of the fastener holes, (Refer to NTM 51-10-01 Page block 601, Procedure A).
 - 1 If no cracks are found :
 - a Do the procedure to install the new fasteners.
 - 2 If cracks are found :
 - a Ream the fastener hole to a diameter of 4.8 mm (0.189 in.).
 - b Do the rotating probe inspection again :
 - if no cracks are found, install the new fasteners
 - if cracks are found, contact AIRBUS for repair information.

B. MODIFICATION

- (1) Config. 01
Refer to Figure 1
Refer to Kit 532126D01R00

- (a) Replace the fasteners in the upper support struts at FR91, LH and RH.

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Refer to Figure 1

Refer to Kit 532126D01R00

- 1 Replace the fasteners at the upper attachments of the upper support struts at FR91.

Refer to Figure 1 , Sheets 1 thru 3

CAUTION : YOU MUST REPLACE THE FASTENERS IN THE SEQUENCE THAT IS SHOWN ON THE ILLUSTRATION.

- a From the LH and RH upper attachment points, remove :

| | | |
|----|--------|---------|
| 14 | Collar | Discard |
| 14 | Pin | Discard |

Refer to Figure 1 , Sheet 1 and Sheet 2 , Detail C.

- b Do a rotating probe inspection of the fastener holes, refer to paragraph 3.A.(2)(j).
- c Ream the fastener holes to between 4.78 and 4.82 mm (0.188 and 0.190 in.).
- d Install :

| | | | |
|----|--------|----------|--------|
| 14 | Pin | DAN7-6-7 | Item 1 |
| 14 | Collar | DAN12-6 | Item 3 |

Refer to Figure 1 , Sheet 2 , Detail C and Sheet 3

- 2 Replace the fasteners at the lower attachments of the upper support struts at FR91.

Refer to Figure 1 , Sheets 1 thru 3

CAUTION : YOU MUST REPLACE THE FASTENERS IN THE SEQUENCE THAT IS SHOWN ON THE ILLUSTRATION.

- a From the LH and RH lower attachment points, remove :

| | | |
|----|--------|---------|
| 14 | Collar | Discard |
| 14 | Pin | Discard |

Refer to Figure 1 , Sheet 1 and Sheet 2 , Detail D.

- b Do a rotating probe inspection of the fastener holes, refer to paragraph 3.A.(2)(j).
- c Ream the fastener holes to between 4.78 and 4.82 mm (0.188 and 0.190 in.).
- d Install :

| | | | |
|----|--------|----------|--------|
| 14 | Pin | DAN7-6-7 | Item 1 |
| 14 | Collar | DAN12-6 | Item 3 |

Refer to Figure 1 , Sheet 2 , Detail D and Sheet 3

- (b) Replace the fasteners in the lower support struts at FR91, LH and RH.

Refer to Figure 1

Refer to Kit 532126D01R00

- 1 Replace the fasteners at the upper attachments of the lower support struts at FR91.

Refer to Figure 1 , Sheet 1 and Sheet 3

CAUTION : YOU MUST REPLACE THE FASTENERS IN THE SEQUENCE THAT IS SHOWN ON THE ILLUSTRATION.

- a From the upper attachment points, remove :

| | | | |
|----|--------|--|---------|
| 14 | Collar | | Discard |
| 14 | Pin | | Discard |

Refer to Figure 1 , Sheet 1 and Sheet 3 , Detail F.

- b Do a rotating probe inspection of the fastener holes, refer to paragraph 3.A.(2)(j).

- c Ream the fastener holes to between 4.78 and 4.82 mm (0.188 and 0.190 in.).

- d Install :

| | | | |
|----|--------|----------|--------|
| 14 | Pin | DAN7-6-9 | Item 2 |
| 14 | Collar | DAN12-6 | Item 3 |

Refer to Figure 1 , Sheet 1 and Sheet 3 , Detail F.

- 2 Replace the fasteners at the lower attachments of the lower support struts at FR91.

Refer to Figure 1 , Sheet 1 and Sheet 3

CAUTION : YOU MUST REPLACE THE FASTENERS IN THE SEQUENCE THAT IS SHOWN ON THE ILLUSTRATION.

- a From the lower attachment points, remove :

| | | | |
|----|--------|--|---------|
| 12 | Collar | | Discard |
| 12 | Pin | | Discard |

Refer to Figure 1 , Sheet 1 and Sheet 3 , Detail E.

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b Do a rotating probe inspection of the fastener holes, refer to paragraph 3.A.(2)(j).

c Ream the fastener holes to between 4.78 and 4.82 mm (0.188 and 0.190 in.).

d Install :

| | | | |
|----|--------|----------|--------|
| 12 | Pin | DAN7-6-9 | Item 2 |
| 12 | Collar | DAN12-6 | Item 3 |

Refer to Figure 1 , Sheet 1 and Sheet 3 , Detail E.

(2) Config. 02

Refer to Figure 1

Refer to Figure 3

Refer to Figure 4

Refer to Figure 5

Refer to Kit 532126D01R00

Refer to Kit 532126D03R02

(a) Replace the fasteners in the upper support struts at FR91, LH and RH.

Refer to Figure 1

Refer to Kit 532126D01R00

1 Replace the fasteners at the upper attachments of the upper support struts at FR91.

Refer to Figure 1 , Sheets 1 thru 3

CAUTION : YOU MUST REPLACE THE FASTENERS IN THE SEQUENCE THAT IS SHOWN ON THE ILLUSTRATION.

a From the LH and RH upper attachment points, remove :

| | | |
|----|--------|---------|
| 14 | Collar | Discard |
| 14 | Pin | Discard |

Refer to Figure 1 , Sheet 1 and Sheet 2 , Detail C.

b Do a rotating probe inspection of the fastener holes, refer to paragraph 3.A.(2)(j).

c Ream the fastener holes to between 4.78 and 4.82 mm (0.188 and 0.190 in.).

d Install :

| | | | |
|----|--------|----------|--------|
| 14 | Pin | DAN7-6-7 | Item 1 |
| 14 | Collar | DAN12-6 | Item 3 |

Refer to Figure 1 , Sheet 2 , Detail C and Sheet 3

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- 2 Replace the fasteners at the lower attachments of the upper support struts at FR91.

Refer to Figure 1 , Sheets 1 thru 3

CAUTION : YOU MUST REPLACE THE FASTENERS IN THE SEQUENCE THAT IS SHOWN ON THE ILLUSTRATION.

- a From the LH and RH lower attachment points, remove :

| | | |
|----|--------|---------|
| 14 | Collar | Discard |
| 14 | Pin | Discard |

Refer to Figure 1 , Sheet 1 and Sheet 2 , Detail D.

- b Do a rotating probe inspection of the fastener holes, refer to paragraph 3.A.(2)(j).

- c Ream the fastener holes to between 4.78 and 4.82 mm (0.188 and 0.190 in.).

- d Install :

| | | | |
|----|--------|----------|--------|
| 14 | Pin | DAN7-6-7 | Item 1 |
| 14 | Collar | DAN12-6 | Item 3 |

Refer to Figure 1 , Sheet 2 , Detail D and Sheet 3

- (b) Replace the fasteners in the lower support struts at FR91, LH and RH.

Refer to Figure 1

Refer to Kit 532126D01R00

- 1 Replace the fasteners at the upper attachments of the lower support struts at FR91.

Refer to Figure 1 , Sheet 1 and Sheet 3

CAUTION : YOU MUST REPLACE THE FASTENERS IN THE SEQUENCE THAT IS SHOWN ON THE ILLUSTRATION.

- a From the upper attachment points, remove :

| | | |
|----|--------|---------|
| 14 | Collar | Discard |
| 14 | Pin | Discard |

Refer to Figure 1 , Sheet 1 and Sheet 3 , Detail F.

- b Do a rotating probe inspection of the fastener holes, refer to paragraph 3.A.(2)(j).

- c Ream the fastener holes to between 4.78 and 4.82 mm (0.188 and 0.190 in.).

d Install :

| | | | |
|----|--------|----------|--------|
| 14 | Pin | DAN7-6-9 | Item 2 |
| 14 | Collar | DAN12-6 | Item 3 |

Refer to Figure 1 , Sheet 1 and Sheet 3 , Detail F.

- 2 Replace the fasteners at the lower attachments of the lower support struts at FR91.

Refer to Figure 1 , Sheet 1 and Sheet 3

CAUTION : YOU MUST REPLACE THE FASTENERS IN THE SEQUENCE THAT IS SHOWN ON THE ILLUSTRATION.

a From the lower attachment points, remove :

| | | | |
|----|--------|--|---------|
| 12 | Collar | | Discard |
| 12 | Pin | | Discard |

Refer to Figure 1 , Sheet 1 and Sheet 3 , Detail E.

- b Do a rotating probe inspection of the fastener holes, refer to paragraph 3.A.(2)(j).

- c Ream the fastener holes to between 4.78 and 4.82 mm (0.188 and 0.190 in.).

d Install :

| | | | |
|----|--------|----------|--------|
| 12 | Pin | DAN7-6-9 | Item 2 |
| 12 | Collar | DAN12-6 | Item 3 |

Refer to Figure 1 , Sheet 1 and Sheet 3 , Detail E.

- (c) Reinforce the upright support struts at FR87.

Refer to Figure 3

Refer to Kit 532126D03R02

- 1 At FR87, remove from the LH and RH upright support struts :

| | | | |
|---|--------|----------------|-----------|
| 2 | Gusset | A5398745023400 | Item (12) |
|---|--------|----------------|-----------|

Refer to Figure 3 , Sheet 1 , Detail B, BEFORE.

- 2 From the T-section, adjacent to the LH and RH upright support struts, remove :

| | | | |
|---|-------|--|---------|
| 6 | Rivet | | Discard |
|---|-------|--|---------|

Refer to Figure 3 , Sheet 3 , Section A-A.

3 In the center holes, adjacent to the LH and RH upright support struts, install :

| | | | |
|---|--------|-----------|---------|
| 2 | Pin | DAN8-6-4X | Item 18 |
| 2 | Collar | DAN12-6X | Item 15 |

Refer to Figure 3 , Sheet 3 , Section A-A and Sheet 4

4 At the LH upright support strut, put in position :

| | | | |
|---|---------|----------------|--------|
| 1 | Profile | A5398725920200 | Item 6 |
| 1 | Stay | A5398725920000 | Item 4 |

and transfer drill the fastener holes.

Refer to Figure 3 , Sheets 2 thru 4

5 Attach the profile, Item 6 and the stay, Item 4, to the aircraft structure with :

| | | | |
|----|---|--------------|---------|
| 1 | Blind Bolt, Self-Locking Hexagonal Head | ASNA0082A302 | Item 22 |
| 2 | Fastener-Blind | NAS1671-3L2 | Item 23 |
| 17 | Pin | DAN7-5A4 | Item 20 |
| 3 | Pin | HL1012VDF6-4 | Item 16 |
| 4 | Pin | DAN7-6-6X | Item 14 |
| 10 | Pin | DAN7-5A3 | Item 17 |
| 2 | Pin | DAN7-6-5X | Item 19 |
| 3 | Collar | DAN12-6 | Item 3 |
| 6 | Collar | DAN12-6X | Item 15 |
| 27 | Collar | DAN12-5 | Item 21 |

Refer to Figure 3 , Sheet 3 and Sheet 4

6 At the RH upright support strut, put in position :

| | | | |
|---|---------|----------------|--------|
| 1 | Profile | A5398725920300 | Item 7 |
| 1 | Stay | A5398725920100 | Item 5 |

and transfer drill the fastener holes.

Refer to Figure 3 , Sheets 2 thru 4

7 Attach the profile, Item 7 and the stay, Item 5, to the aircraft structure with :

| | | | |
|----|---|--------------|---------|
| 1 | Blind Bolt, Self-Locking Hexagonal Head | ASNA0082A302 | Item 22 |
| 2 | Fastener-Blind | NAS1671-3L2 | Item 23 |
| 17 | Pin | DAN7-5A4 | Item 20 |
| 3 | Pin | HL1012VDF6-4 | Item 16 |
| 4 | Pin | DAN7-6-6X | Item 14 |

| | | | |
|----|--------|-----------|---------|
| 10 | Pin | DAN7-5A3 | Item 17 |
| 2 | Pin | DAN7-6-5X | Item 19 |
| 27 | Collar | DAN12-5 | Item 21 |
| 3 | Collar | DAN12-6 | Item 3 |
| 6 | Collar | DAN12-6X | Item 15 |

Refer to Figure 3 , Sheet 3 and 4

(d) Reinforce the upper diagonal support-struts.

Refer to Figure 4

Refer to Kit 532126D03R02

1 Put in position on the upper diagonal support-struts,
between FR87 and FR91 :

| | | | |
|----|-------------|----------------|---------|
| 28 | Plate-Brace | A5398842820000 | Item 13 |
|----|-------------|----------------|---------|

Refer to Figure 4 , Sheet 1 and Sheet 3

2 Transfer drill the holes and install the plates, Item 13,
with

| | | | |
|-----|--------|----------|---------|
| 112 | Pin | DAN7-5A3 | Item 17 |
| 112 | Collar | DAN12-5 | Item 21 |

Refer to Figure 4 , Sheet 3

(e) Reinforce the lower diagonal support-struts.

Refer to Figure 4

Refer to Kit 532126D03R02

1 Put in position on the lower diagonal support-struts,
between FR87 and FR91 :

| | | | |
|----|-------------|----------------|---------|
| 26 | Plate-Brace | A5398842820000 | Item 13 |
|----|-------------|----------------|---------|

Refer to Figure 4 , Sheet 2 and Sheet 3

2 Transfer drill the holes and install the plates, Item 13,
with

| | | | |
|-----|--------|----------|---------|
| 104 | Pin | DAN7-5A3 | Item 17 |
| 104 | Collar | DAN12-5 | Item 21 |

Refer to Figure 4 , Sheet 3

(f) Install the reinforcement angles on the diagonal support
struts.

Refer to Figure 5

Refer to Kit 532126D03R02

1 On the upper diagonal support-struts at FR87, put in position :

| | | | |
|---|------------|----------------|---------|
| 1 | Sheet (LH) | A5398725920600 | Item 10 |
| 1 | Sheet (RH) | A5398725920700 | Item 11 |

Refer to Figure 5 , Sheet 1 , Detail B.

2 Transfer drill the holes and install the sheets, Item 10 and Item 11, with :

| | | | |
|----|--------|--------------|---------|
| 16 | Pin | HL1012VDF6-4 | Item 16 |
| 16 | Collar | DAN12-6 | Item 3 |

Refer to Figure 5 , Sheet 2 , Details E and F.

3 On the lower support struts at FR87, put in position :

| | | | |
|---|------------|----------------|--------|
| 1 | Sheet (LH) | A5398725920400 | Item 8 |
| 1 | Sheet (RH) | A5398725920500 | Item 9 |

Refer to Figure 5 , Sheet 1 , Detail C.

4 Transfer drill the holes and install the sheets, Item 8 and Item 9, with :

| | | | |
|----|--------|--------------|---------|
| 16 | Pin | HL1012VDF6-4 | Item 16 |
| 16 | Collar | DAN12-6 | Item 3 |

Refer to Figure 5 , Sheet 2 , Details E and F.

(3) Config. 03
Refer to Figure 2
Refer to Kit 532126D02R00

(a) Replace the fasteners in the upper support struts at FR91, LH and RH.

Refer to Figure 2

Refer to Kit 532126D02R00

1 Replace the fasteners at the lower attachments of the upper support struts at FR91.

Refer to Figure 2 , Sheets 1 thru 3 .

CAUTION : YOU MUST REPLACE THE FASTENERS IN THE SEQUENCE THAT IS SHOWN ON THE ILLUSTRATION.

a From the LH and RH lower attachment points, remove :

| | | | |
|---|--------|--|---------|
| 4 | Collar | | Discard |
| 4 | Pin | | Discard |

Refer to Figure 2 , Sheet 1 and 2 , Detail C.

b Do a rotating probe inspection of the fastener holes, refer to paragraph 3.A.(2)(j).

c Ream the fastener holes to between 4.78 and 4.82 mm (0.188 and 0.190 in.).

d Install :

| | | | |
|---|--------|----------|--------|
| 4 | Pin | DAN7-6-7 | Item 1 |
| 4 | Collar | DAN12-6 | Item 3 |

Refer to Figure 2 , Sheet 2 , Detail C and Sheet 3 .

(b) Replace the fasteners in the lower support struts at FR91, LH and RH.

Refer to Figure 2

Refer to Kit 532126D02R00

1 Replace the fasteners at the upper attachments of the lower support struts at FR91.

Refer to Figure 2 , Sheet 1 and Sheet 3 .

CAUTION : YOU MUST REPLACE THE FASTENERS IN THE SEQUENCE THAT IS SHOWN ON THE ILLUSTRATION.

a From the upper attachment points, remove :

| | | | |
|----|--------|--|---------|
| 14 | Collar | | Discard |
| 14 | Pin | | Discard |

Refer to Figure 2 , Sheet 1 and 3 , Detail E.

b Do a rotating probe inspection of the fastener holes, refer to paragraph 3.A.(2)(j).

c Ream the fastener holes to between 4.78 and 4.82 mm (0.188 and 0.190 in.).

d Install :

| | | | |
|----|--------|----------|--------|
| 14 | Pin | DAN7-6-9 | Item 2 |
| 14 | Collar | DAN12-6 | Item 3 |

Refer to Figure 2 , Sheet 1 and 3 , Detail E.

- 2 Replace the fasteners at the lower attachments of the lower support struts at FR91.

Refer to Figure 2 , Sheets 1 thru 3 .

CAUTION : YOU MUST REPLACE THE FASTENERS IN THE SEQUENCE THAT IS SHOWN ON THE ILLUSTRATION.

- a From the lower attachment points, remove :

| | | |
|----|--------|---------|
| 12 | Collar | Discard |
| 12 | Pin | Discard |

Refer to Figure 2 , Sheet 1 and Sheet 2 , Detail D.

- b Do a rotating probe inspection of the fastener holes, refer to paragraph 3.A.(2)(j).

- c Ream the fastener holes to between 4.78 and 4.82 mm (0.188 and 0.190 in.).

- d Install :

| | | | |
|----|--------|----------|--------|
| 12 | Pin | DAN7-6-9 | Item 2 |
| 12 | Collar | DAN12-6 | Item 3 |

Refer to Figure 2 , Sheet 1 , Sheet 2 , Detail D and Sheet 3 .

C. TEST

None

D. CLOSE UP

- (1) Config. 01 thru Config. 03

- (a) Make sure that the work area is clean and clear of tools and other items of equipment.
- (b) In the cockpit, remove the warning notice.
- (c) Put the THS back to the correct operating condition, (Refer to AMM 55-00-00 Page block 301).
- (d) Close the access doors 312AR and 313AL, (Refer to AMM 52-41-00 Page block 001).
- (e) Remove the access platforms.

E. DOCUMENTATION

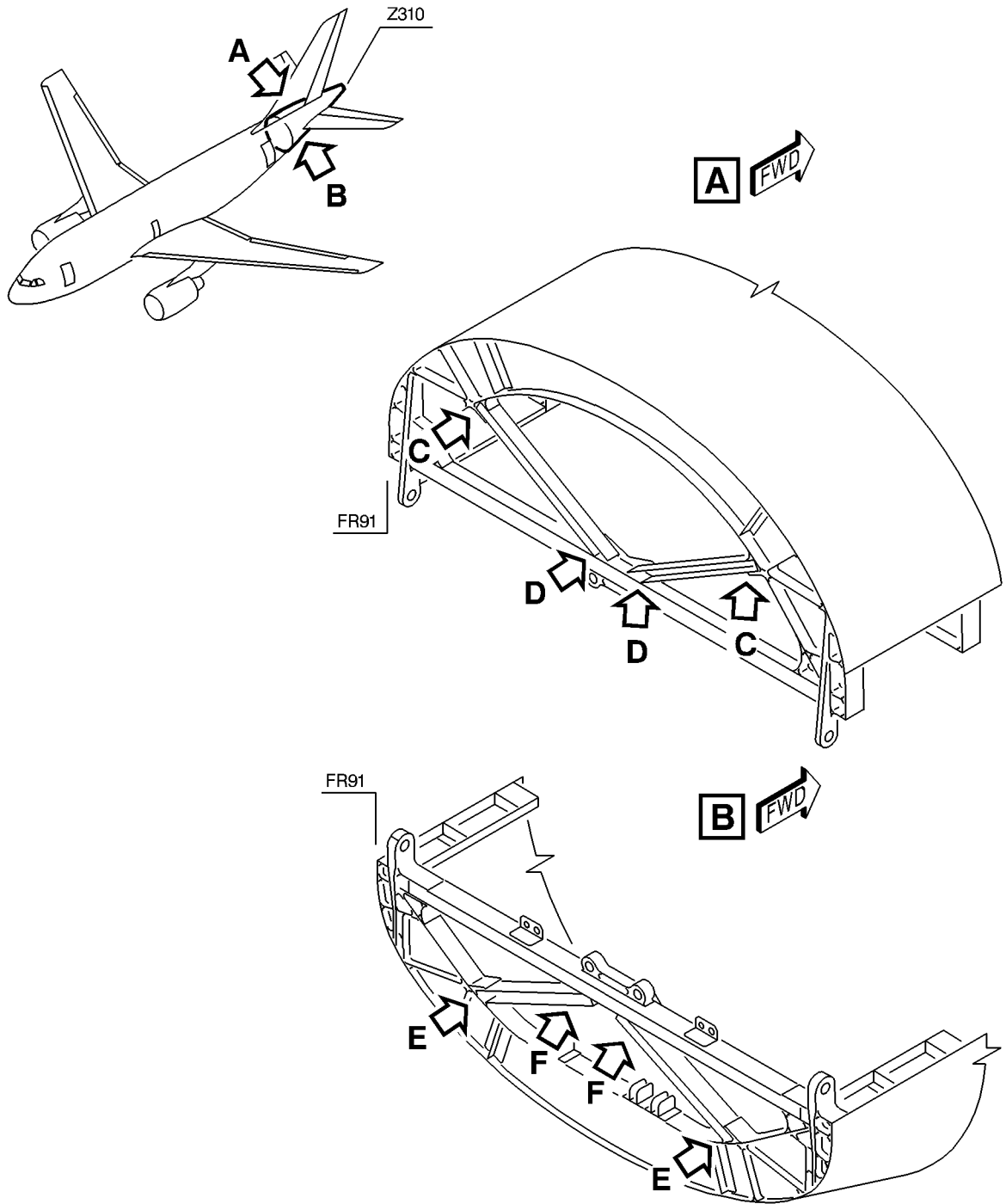
Write in the applicable aircraft records that you have done all the work given in the Service Bulletin.

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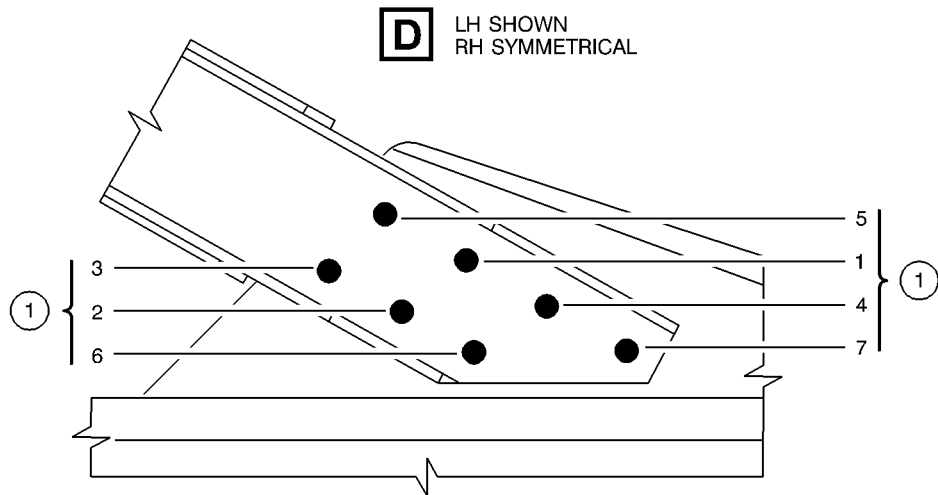
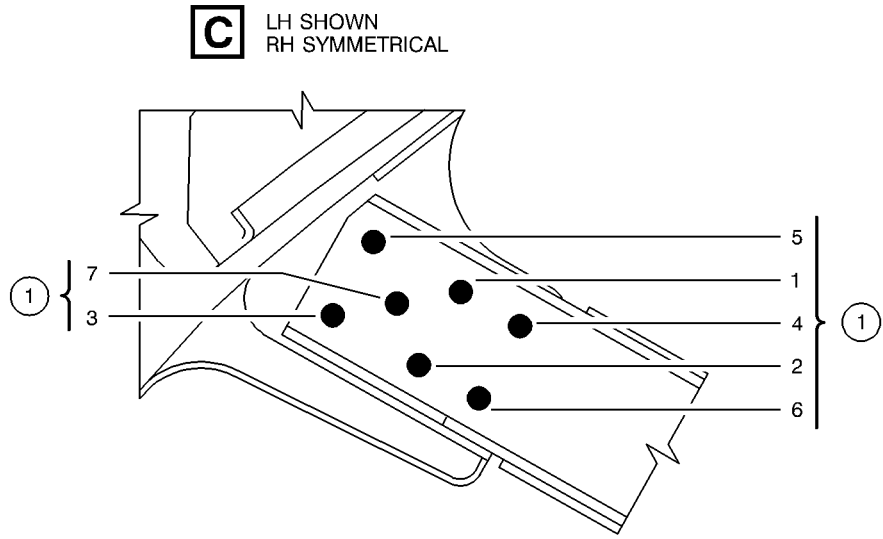
Figure 1 Sheet 1
Config. 01 thru 02: Replacement of the Fasteners

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NOTE: (1) THE FASTENERS MUST BE REMOVED AND INSTALLED IN THE FOLLOWING SEQUENCE:

1. FASTENER 1 AND 2
2. FASTENER 3 AND 4
3. FASTENER 5 AND 6
4. FASTENER 7

FOR FASTENER TABLE, REFER TO SHEET 3

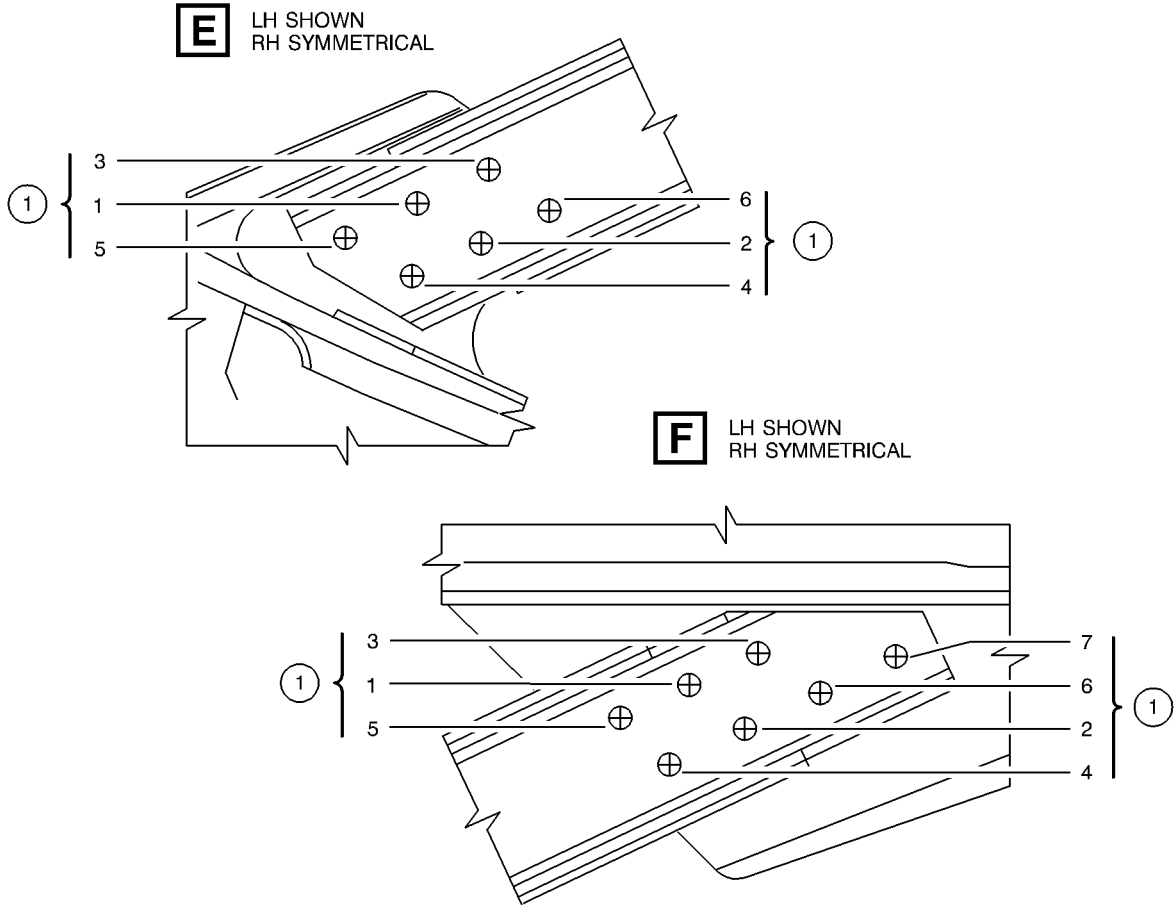
Figure 1 Sheet 2
Config. 01 thru 02: Replacement of the Fasteners

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| HOLE SYMBOL | ITEM | P/N | DESCRIPTION | KIT | HOLE DIAMETER | | REMARKS |
|-------------|----------|----------|-------------|-----|----------------------|----------------------|--------------------------------|
| | | | | | MIN | MAX | |
| ● | 1 | DAN7-6-7 | PIN | D01 | 4.78mm (0.188in.) | 4.82mm (0.190in.) | NOMINAL SIZE TRANSITION FIT |
| | 3 | DAN12-6 | COLLAR | | | | |
| ⊕ | 2 | DAN7-6-9 | PIN | D01 | 4.78mm (0.188in.) | 4.82mm (0.190in.) | NOMINAL SIZE TRANSITION FIT |
| | 3 | DAN12-6 | COLLAR | | | | |

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NOTE: (1) THE FASTENERS MUST BE REMOVED AND INSTALLED IN THE FOLLOWING SEQUENCE:
 1. FASTENER 1 AND 2
 2. FASTENER 3 AND 4
 3. FASTENER 5 AND 6
 4. FASTENER 7

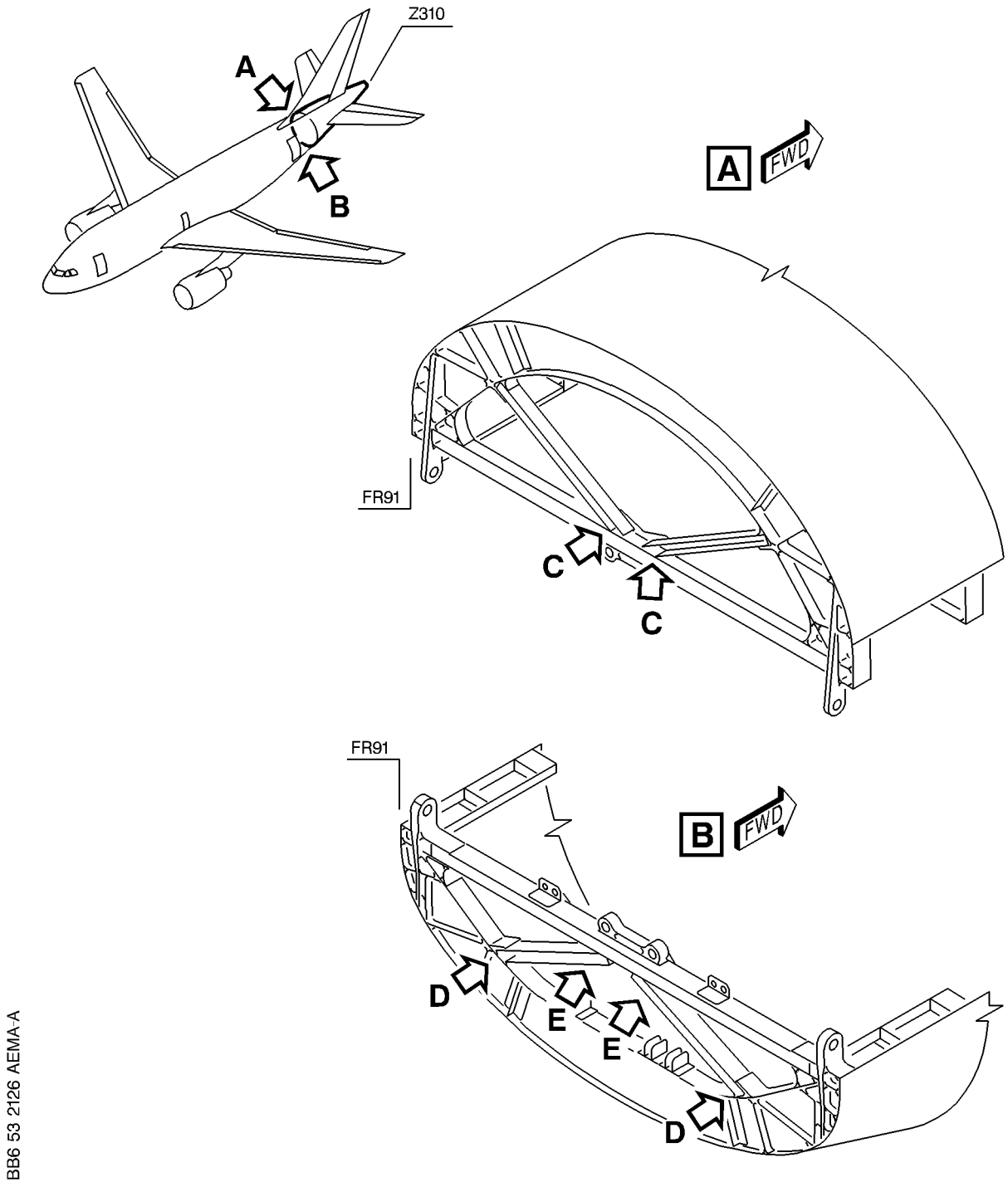
Figure 1 Sheet 3
 Config. 01 thru 02: Replacement of the Fasteners

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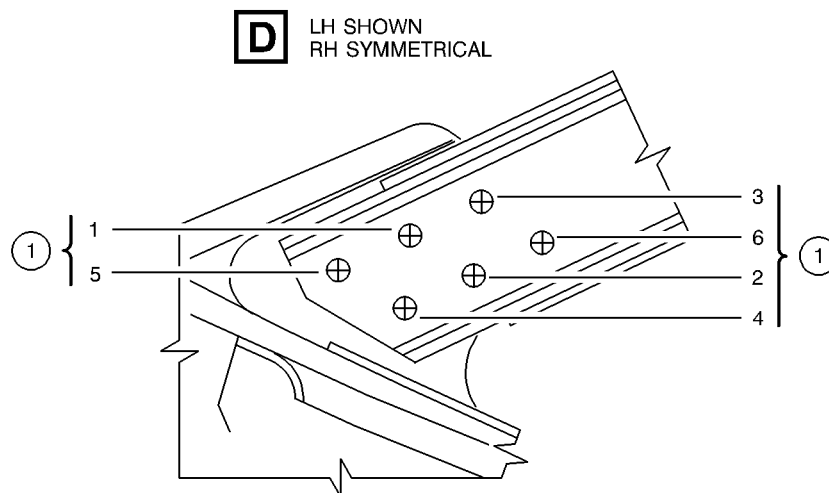
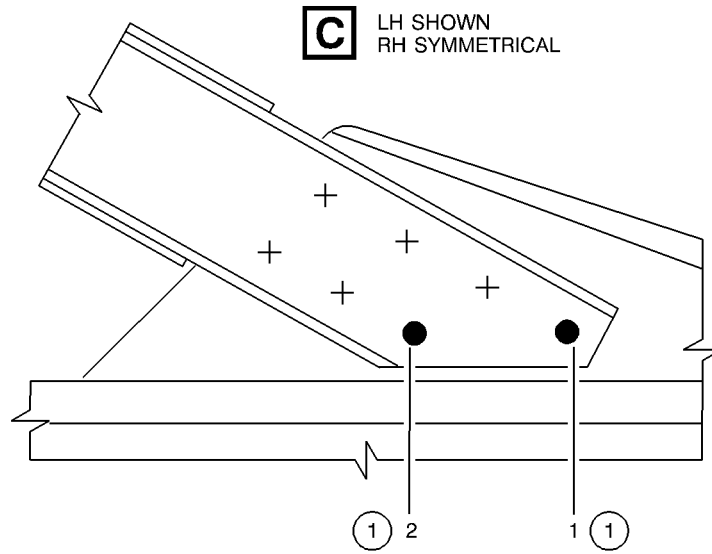
Figure 2 Sheet 1
Config. 03: Replacement of the Fasteners

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- NOTE:** (1) THE FASTENERS MUST BE REMOVED AND INSTALLED IN THE FOLLOWING SEQUENCE:
1. FASTENER 1 AND 2
 2. FASTENER 3 AND 4
 3. FASTENER 5 AND 6
 4. FASTENER 7

FOR FASTENER TABLE, REFER TO SHEET 3

Figure 2 Sheet 2
Config. 03: Replacement of the Fasteners

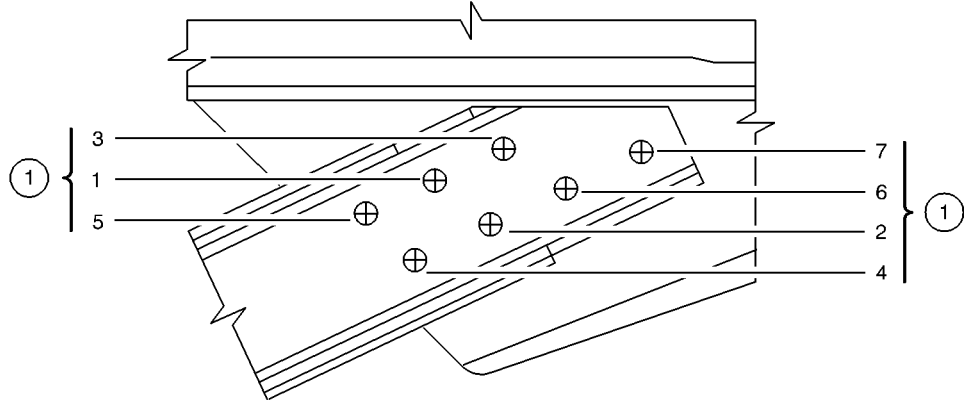
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E LH SHOWN
RH SYMMETRICAL



| HOLE SYMBOL | ITEM | P/N | DESCRIPTION | KIT | HOLE DIAMETER | | REMARKS |
|-------------|----------|----------|-------------|-----|----------------------|----------------------|--------------------------------|
| | | | | | MIN | MAX | |
| ● | 1 | DAN7-6-7 | PIN | D02 | 4.78mm (0.188in.) | 4.82mm (0.190in.) | NOMINAL SIZE TRANSITION FIT |
| | 3 | DAN12-6 | COLLAR | | | | |
| ⊕ | 2 | DAN7-6-9 | PIN | D02 | 4.78mm (0.188in.) | 4.82mm (0.190in.) | NOMINAL SIZE TRANSITION FIT |
| | 3 | DAN12-6 | COLLAR | | | | |

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NOTE: (1) THE FASTENERS MUST BE REMOVED AND INSTALLED IN THE FOLLOWING SEQUENCE:
 1. FASTENER 1 AND 2
 2. FASTENER 3 AND 4
 3. FASTENER 5 AND 6
 4. FASTENER 7

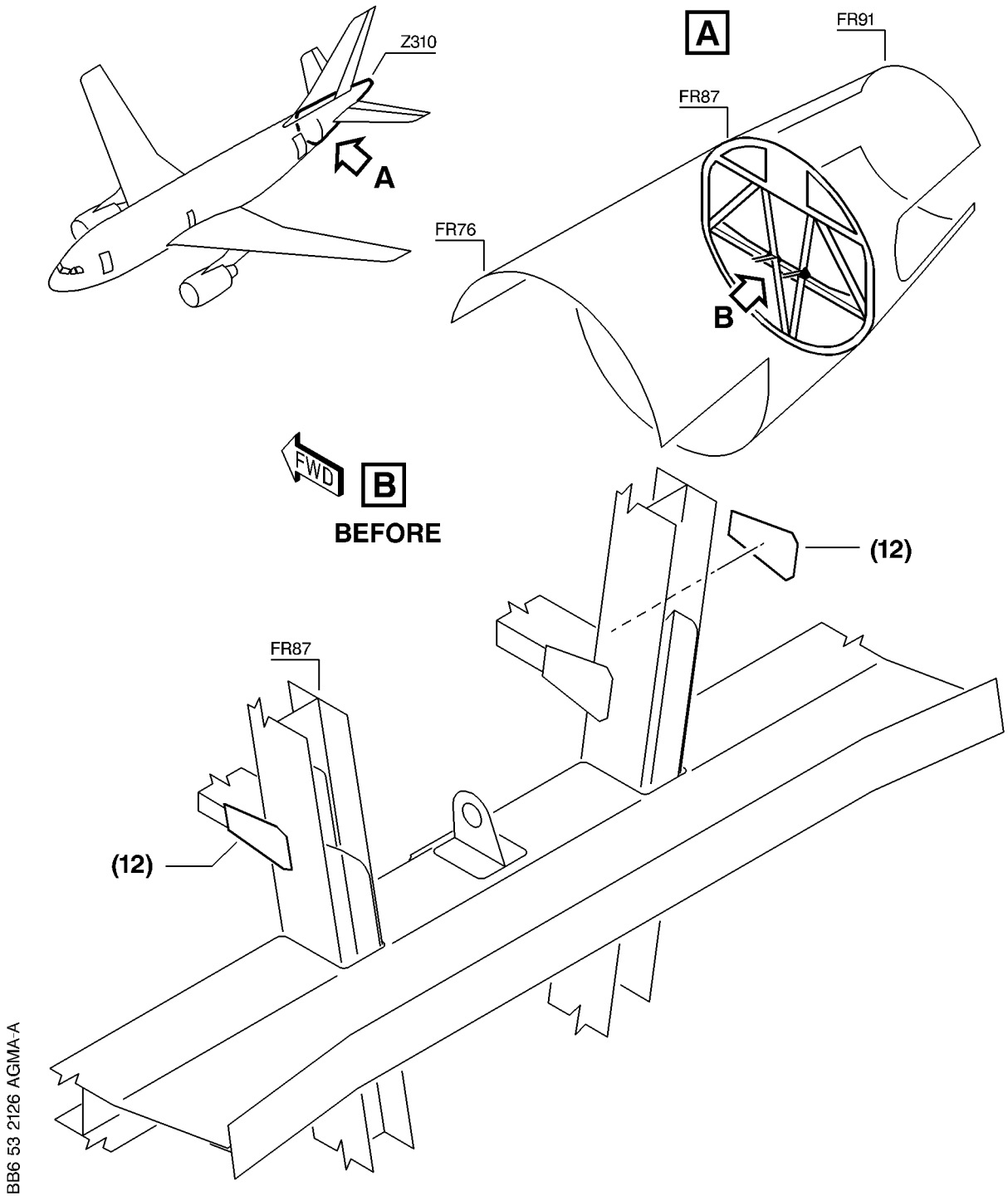
Figure 2 Sheet 3
Config. 03: Replacement of the Fasteners

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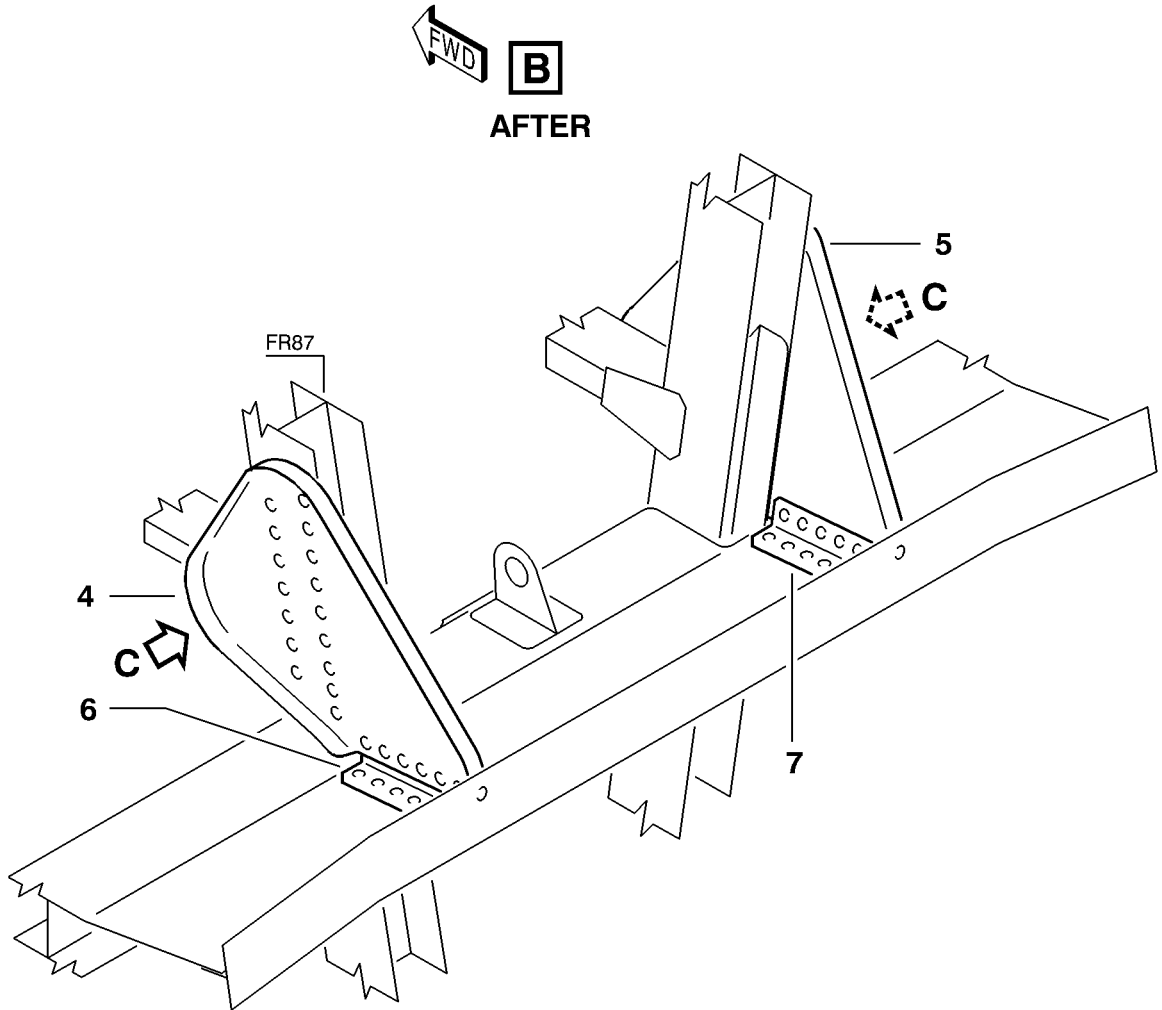
Figure 3 Sheet 1
Config. 02: Reinforcement of the Upright Support Struts at FR87

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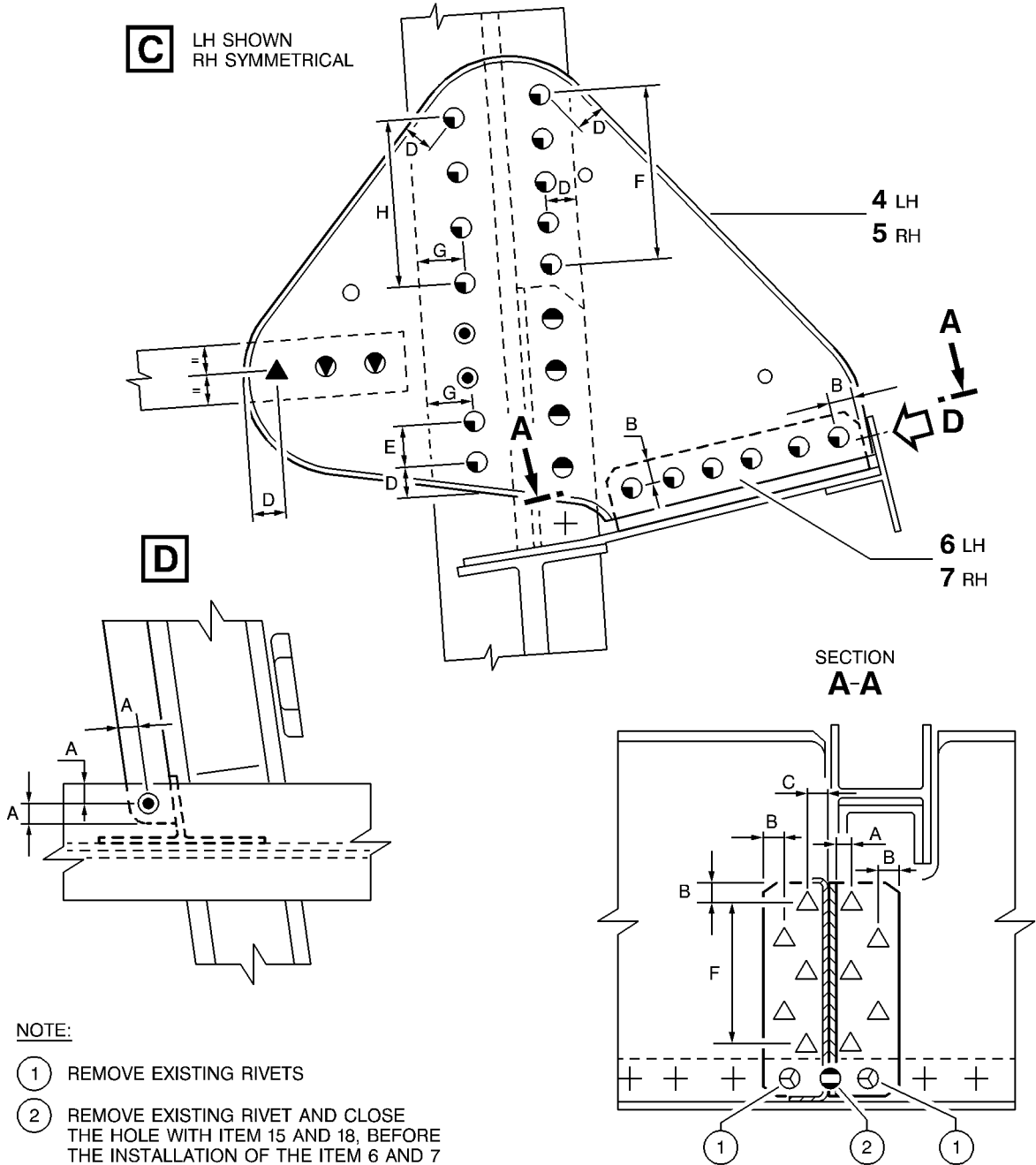
Figure 3 Sheet 2
Config. 02: Reinforcement of the Upright Support Struts at FR87

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NOTE:

- ① REMOVE EXISTING RIVETS
 - ② REMOVE EXISTING RIVET AND CLOSE THE HOLE WITH ITEM 15 AND 18, BEFORE THE INSTALLATION OF THE ITEM 6 AND 7
- FOR RIVET TABLE, REFER TO SHEET 4
FOR DIMENSION TABLE, REFER TO SHEET 4

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Figure 3 Sheet 3
Config. 02: Reinforcement of the Upright Support Struts at FR87

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| HOLE SYMBOL | ITEM | P/N | DESCRIPTION | KIT | HOLE DIAMETER | | REMARKS |
|-------------|------|--------------|-------------|-----|----------------------|----------------------|--------------------------------|
| | | | | | MIN | MAX | |
| ● | 14 | DAN7-6-6X | PIN | D03 | 5.11mm (0.201in.) | 5.15mm (0.203in.) | 1ST OVERSIZE TRANSITION FIT |
| | 15 | DAN12-6X | COLLAR | | | | |
| ◐ | 20 | DAN7-5A-4 | PIN | D03 | 4.12mm (0.162in.) | 4.16mm (0.164in.) | NOMINAL SIZE TRANSITION FIT |
| | 21 | DAN12-5 | COLLAR | | | | |
| ◑ | 16 | HL1012VDF6-4 | PIN | D03 | 4.78mm (0.188in.) | 4.82mm (0.190in.) | NOMINAL SIZE TRANSITION FIT |
| | 3 | DAN12-6 | COLLAR | | | | |
| △ | 17 | DAN7-5A-3 | PIN | D03 | 4.12mm (0.162in.) | 4.16mm (0.164in.) | NOMINAL SIZE TRANSITION FIT |
| | 21 | DAN12-5 | COLLAR | | | | |
| ⊕ | 19 | DAN7-6-5X | PIN | D03 | 5.11mm (0.201in.) | 5.15mm (0.203in.) | 1ST OVERSIZE TRANSITION FIT |
| | 15 | DAN12-6X | COLLAR | | | | |
| ◓ | 18 | DAN8-6-4X | PIN | D03 | 5.11mm (0.201in.) | 5.15mm (0.203in.) | 1ST OVERSIZE TRANSITION FIT |
| | 15 | DAN12-6X | COLLAR | | | | |
| ▲ | 22 | ASNA0082A302 | BOLT | D03 | 4.83mm (0.190in.) | 4.88mm (0.192in.) | NOMINAL SIZE TRANSITION FIT |
| ● | 23 | NAS1671-3L2 | FASTENER | D03 | 4.83mm (0.190in.) | 4.88mm (0.192in.) | NOMINAL SIZE TRANSITION FIT |

| DIMENSIONS | | |
|------------|-------------|---------------|
| | mm | (in.) |
| A | 9.0 | 0.354 |
| B | 10.0 | 0.394 |
| C | 11.0 | 0.433 |
| D | 12.0 | 0.472 |
| E | 16.0 | 0.630 |
| F | 4x18.0=72.0 | 4x0.709=2.835 |
| G | 20.0 | 0.787 |
| H | 3x23.0=69.0 | 3x0.906=2.717 |

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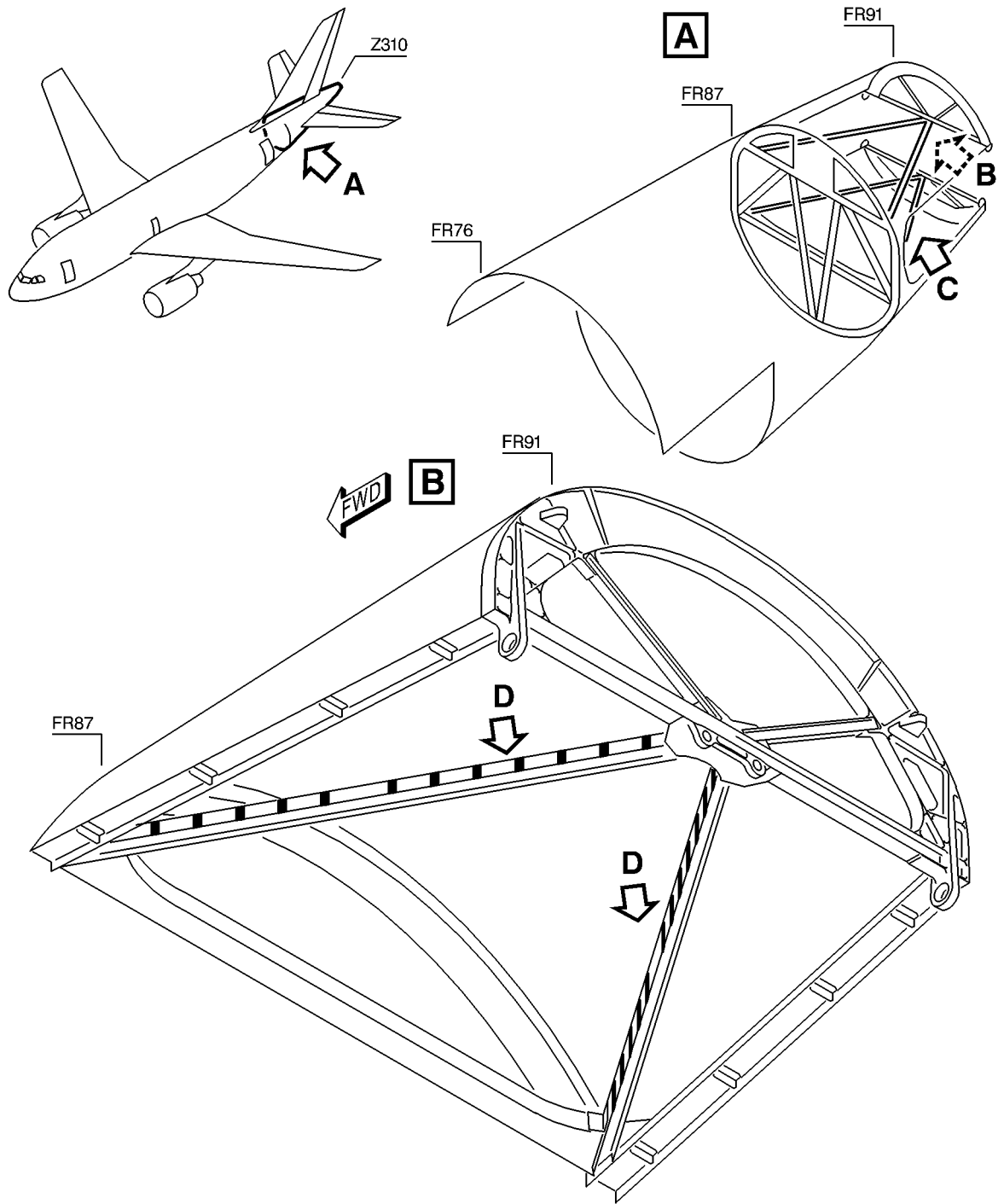
Figure 3 Sheet 4
Config. 02: Reinforcement of the Upright Support Struts at FR87

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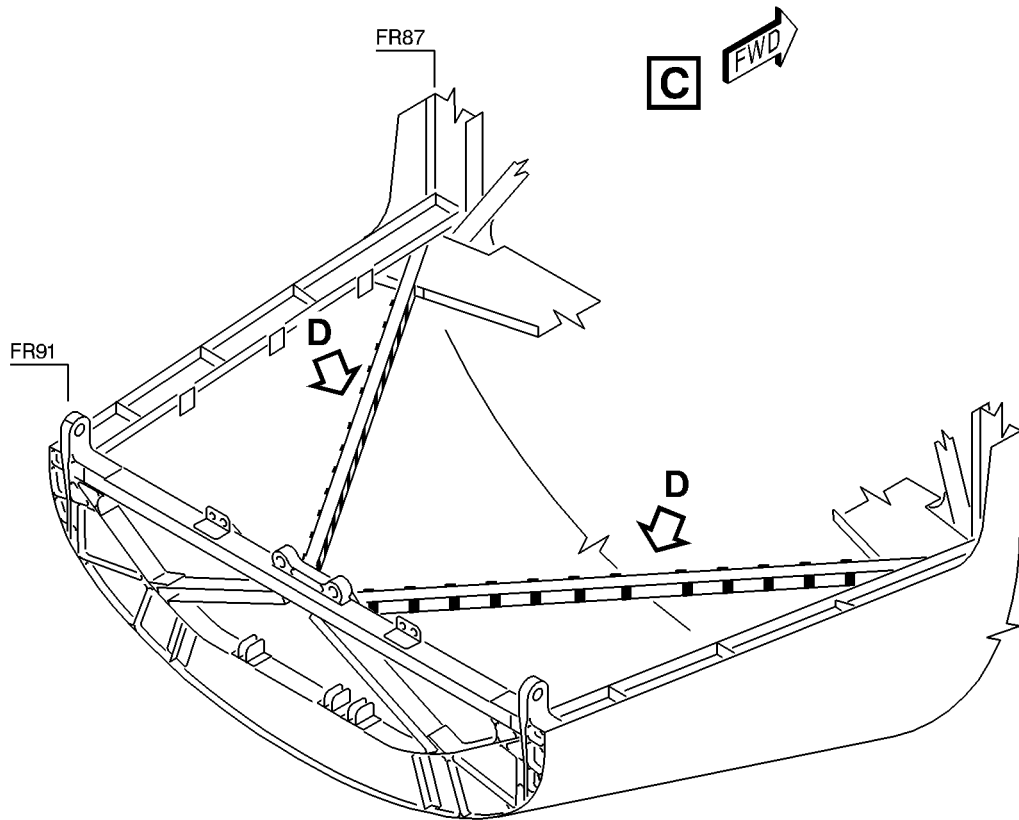
Figure 4 Sheet 1
Config. 02: Reinforcement of the Diagonal Support Struts between FR87 and FR91

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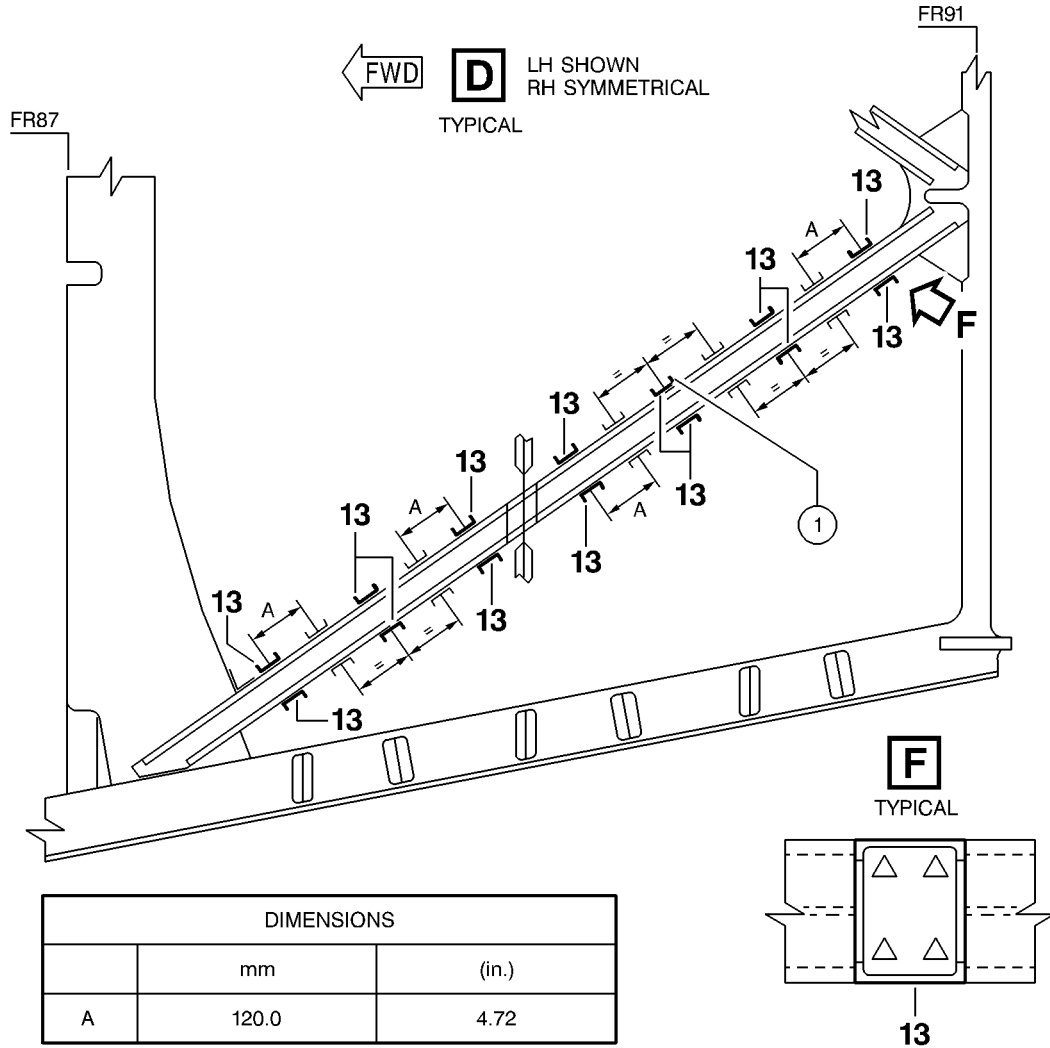
Figure 4 Sheet 2
Config. 02: Reinforcement of the Diagonal Support Struts between FR87 and FR91

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| DIMENSIONS | | |
|------------|-------|-------|
| | mm | (in.) |
| A | 120.0 | 4.72 |

| HOLE SYMBOL | ITEM | P/N | DESCRIPTION | KIT | HOLE DIAMETER | | REMARKS |
|-------------|-----------|-----------|-------------|-----|----------------------|----------------------|--------------------------------|
| | | | | | MIN | MAX | |
| △ | 17 | DAN7-5A-3 | PIN | D03 | 4.12mm (0.162in.) | 4.16mm (0.164in.) | NOMINAL SIZE TRANSITION FIT |
| | 21 | DAN12-5 | COLLAR | | | | |

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NOTE:

- ① THE PLATE, ITEM 13 IS NOT REQUIRED AT THIS LOCATION ON THE LOWER STRUTS

Figure 4 Sheet 3
Config. 02: Reinforcement of the Diagonal Support Struts between FR87 and FR91

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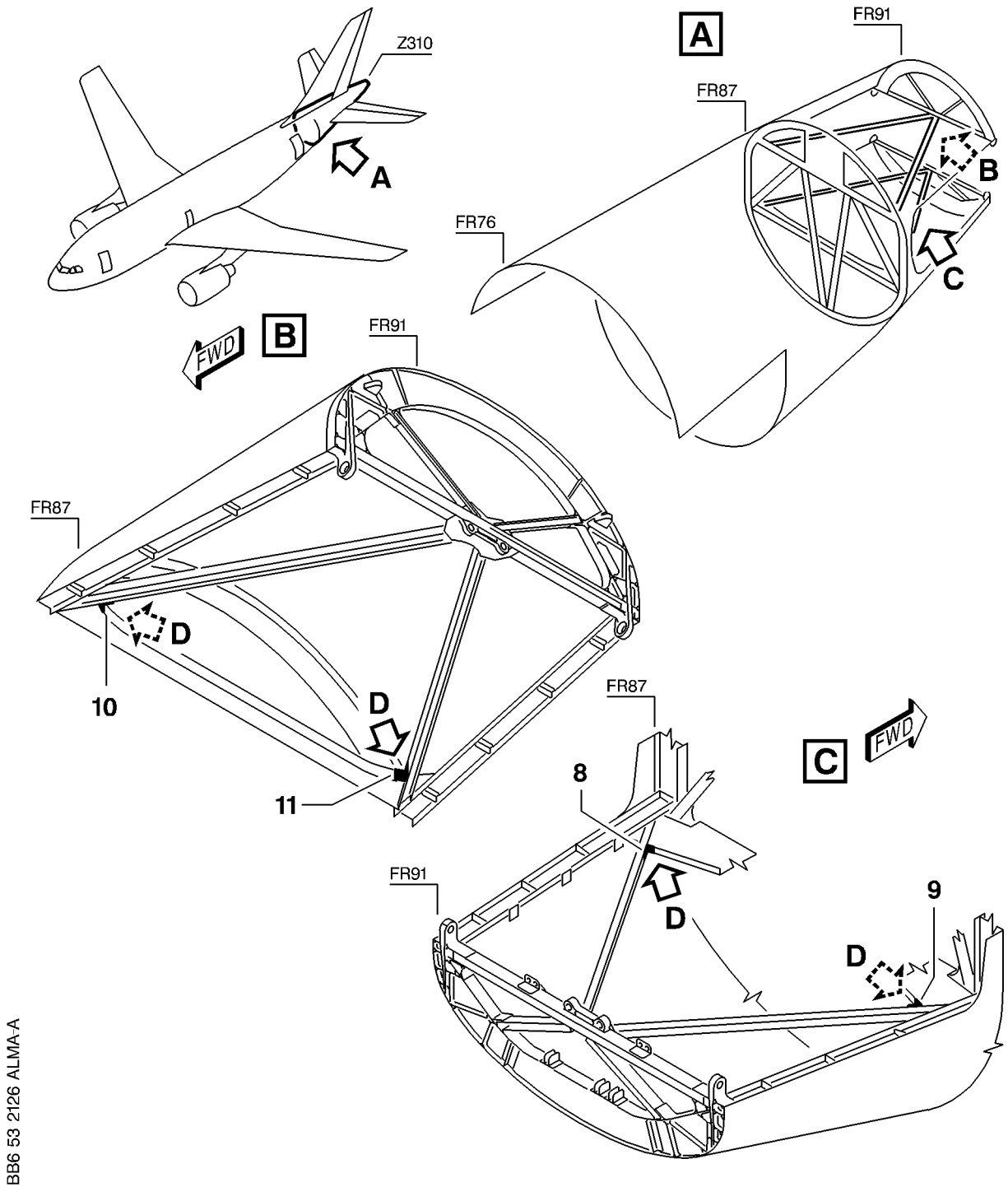


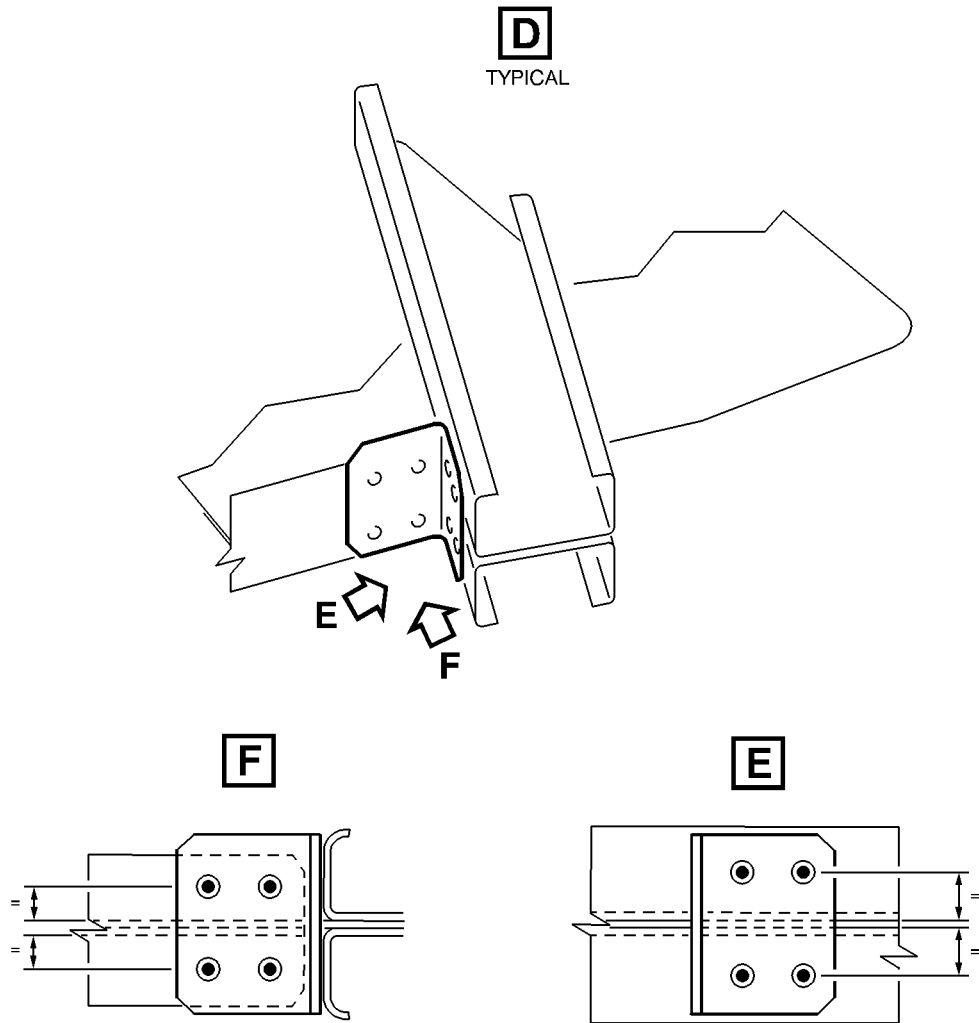
Figure 5 Sheet 1
Config. 02: Installation of the Reinforcing Angles

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| HOLE SYMBOL | ITEM | P/N | DESCRIPTION | KIT | HOLE DIAMETER | | REMARKS |
|-------------|-----------|--------------|-------------|-----|----------------------|----------------------|--------------------------------|
| | | | | | MIN | MAX | |
| ● | 16 | HL1012VDF6-4 | PIN | D03 | 4.78mm (0.188in.) | 4.82mm (0.190in.) | NOMINAL SIZE TRANSITION FIT |
| | 3 | DAN12-6 | COLLAR | | | | |

Figure 5 Sheet 2
Config. 02: Installation of the Reinforcing Angles

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TITLE : FUSELAGE - FUSELAGE AFT SECTION - CHANGE FASTENER AT FR91

MODIFICATION No. : 13011D23063

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