

MODIFICATION LEADER VERSION
MOD No.

55760

TITLE
MP No.

D46079

RFC No.*
QUERY No.*
RFW No.*
REF No.*

M 18035

Stabilizers – Vertical Stabilizer – Delivery of complete VTP to Final Assembly Lines

ISSUE	PAGES							REASON FOR ISSUE	DATE VISA
	1	2	3	3A	4	5	6		
D 1	X	X	0-7 X		X	X	X	Airbus D – TRS	TSED, Zyrull TSES, Scheibe EALG, Ochs
D 2	X	X	X 0-7		X	X	X	Airbus D – TD	TSED, Zyrull TSES, Scheibe EALG, Ochs
D 3	X 0-1	X	X 0-7		X	X	X	Airbus D – MAS	TSED, Zyrull EALG, Ochs
D 4	X 0-1	X	X 0-5		X	X	X	Correction of Airbus D – MAS	TSED, Zyrull 9.8.08 EALG, Ochs

Signature: A-F

INVOLVED

Signature: A-D

LEADER

Signature: A-UK

NOT INVOLVED

Signature: ALENIA

NOT INVOLVED

Signature: A-E

NOT INVOLVED

MODIFICATION APPROVAL SHEET
MOD No. 55760

TITLE
MP No. D46079

Stabilizers – Vertical Stabilizer – Delivery of complete VTP to Final Assembly Lines
RFC No.*
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REF No.* M 18035

ISSUE* D 4

ATA 55–30
CLASSIFICATION
MINOR
MODEL(S) A330–200,A330–300,A340–300,A340–500,A340–600

VALIDITY * ST4, ST7, ST8, ST14(STE), ST15(STF)

CERTIF. PROJECT NUMBER80

TO BE EMBODIED BEFORE

NONE

RESTRICTIONS CANCELLED BY THIS MOD

NONE

GENERAL DESCRIPTION

To relieve the Final Assembly Lines all twin–aisle – VTPs will be pre–assembled as far as possible similar to Airbus single–aisle production.

This modification consists of 3 main parts:

- fin box with rear sparbox
- rudder
- leading edges

and the necessary electrical and hydraulic equipment

The transport of the VTP and the rudder safety device with/without actuators shall be performed analogous to minutes of meeting of Final Design Review dated 30.03.2006 :

Selection of transport securing device analogous type of VTP:

A330–200 securing device BG 82 with rudder position 37,7 degree

A330–/A340–300 securing device BG 81 with rudder position 34,34 degree

A340–500/–600 securing device BG 82 rudder position 37,7 degree

The rudder will be turned into transport position ,
hinge bearing put in actuator bearing and actuator bearing connected with hinge bearing by means of a protection bush, put in the actuator bearing.

Bolt put through protecting bushes and hinge bearing.

Nut put on bolt and secured by a splint.

*** FOR INFORMATION ONLY, NON APPROVED DATA**

21.8.7 JSD.D4		A330	A340	A340-500	A340-600	LINKED MODIFICATION(S)	ATTACHED yes SEE PAGE No D 3.0 – D 3.7
*	WT	0	0	0	0		
MWE	CG	—	—	—	—		
*	WT						
OWE	CG						
EFFECTS ON ELECTRICAL LOADS * NO							

GENERAL DESCRIPTION

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The rudder actuator installation will be unchanged by this modification

Additional minor improvements due to modified production procedure:

- Enlargement of pre-drilling holes (from dia 2,5 to dia 2.7) in the area of fin box, rudder and leading edges to reduce working steps.
- The actually used wedge washers (F553-70529) in step "skin panel riveting" (F553-71712, valid for ST04,ST07,ST08,ST14,ST15) shall be replaced by steel wedge washers due to lower need of space.

(These wedge washers are already in use in Single Aisle program)

- Modified geometry of coverfoils for inspection holes (F553-70530)

REGULATIONS INVOLVED AND JUSTIFICATIONS

ATA REGULATION MC JUSTIFICATION DOCUMENT

JAR 25.1301 1 MC1: as per drawing

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EFFECTS ON EQUIPMENT

CANCELLED

NEW

DESCRIPTION	CODE No P/N	QTY	RESP	DESCRIPTION AND DDP	CODE No P/N	QTY	RESP
HF-Coupler	822-0987-003	2	A-D	HF-Coupler	822-0987-003	2	A-D
or HF-Coupler	964-453-001	2	A-D	or HF-Coupler	964-453-001	2	A-D
VOR-Antenna	3110-89	1	A-D	VOR-Antenna	3110-89	1	A-D
<div style="border: 1px solid black; padding: 5px; text-align: center;"> No Equipment-Changes (Cancelled = New) Only change of place of installation (Stade Plant) </div>							

* FOR INFORMATION ONLY, NON APPROVED DATA

PROPULSION* SYSTEM AFFECTED NO	EFFECTS ON DOCUMENT						COMPLIANCE SHOWN	
	OPERATIONAL* DOCUMENT AFFECTED NO	GTR* YES	APPROVED DOCUMENTATION					
			SRM PAGE BLOCK 101/201 OR 601/701	WBM CHAPTER 1.10 LIMITATIONS	MMEL	FM	MPD Section 9.1	
			NO	NO	NO	NO	NO	
	MAINTENANCE* DOCUMENT AFFECTED NO							M-D Zyru U 9.8.07 

INDEPENDENT CHECK

APPROVED UNDER EASA
DESIGN ORGANISATION APPROVAL
No: EASA.21J.031
AIRBUS STAMP 107

M. Ochs
EALG

16.8.07

MAS
ISSUE 2

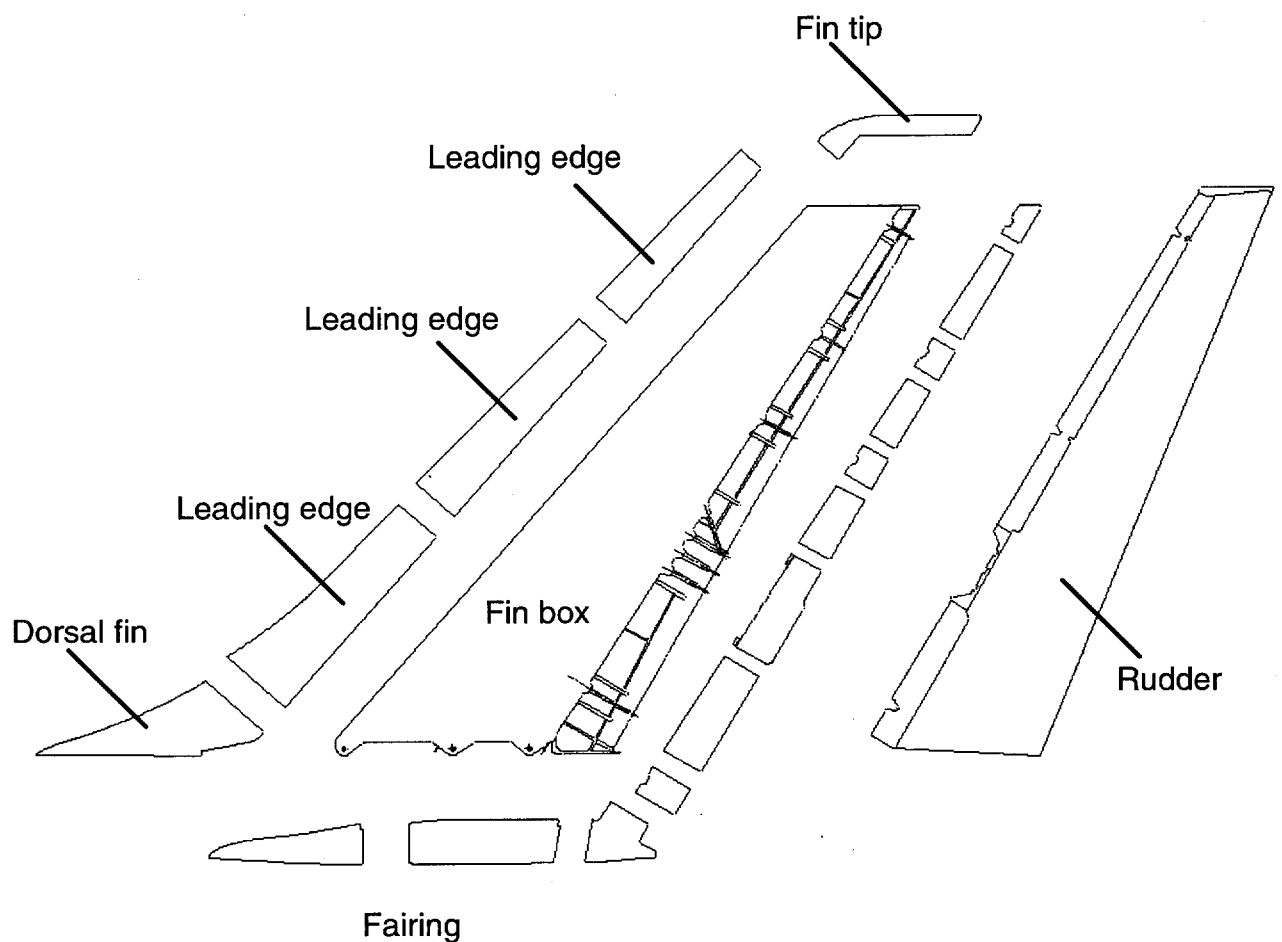
SKETCH (USE CLM WHERE POSSIBLE)

ATA 55-30 VERTICAL STABILIZER
ATA 55-40 RUDDER

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PRE – MOD A330/A340-300

(45 F553-70600 VTP-Structure for A330/A340-300 (ST4,ST8))



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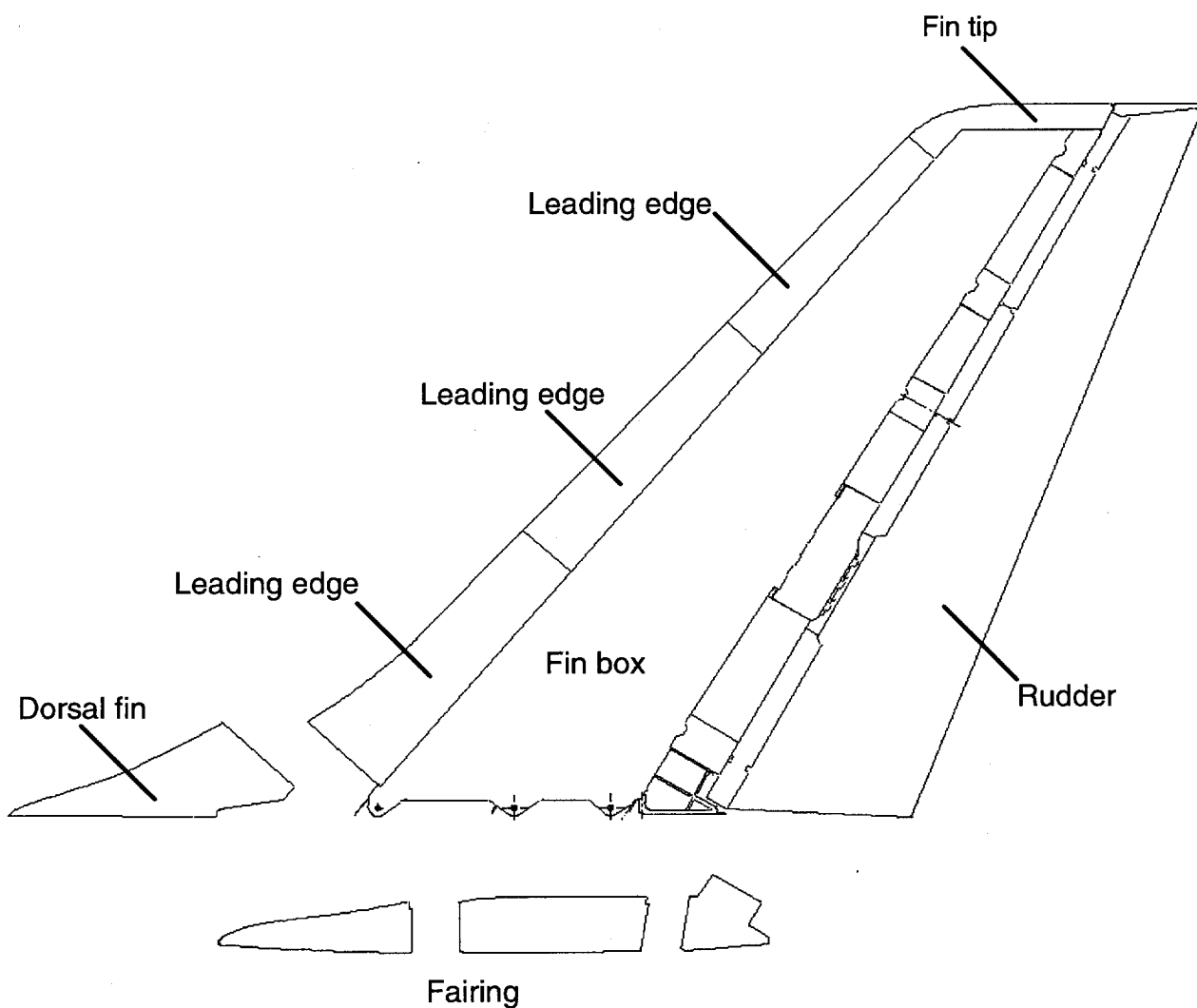
SKETCH (USE CLM WHERE POSSIBLE)

ATA 55-30 VERTICAL STABILIZER
ATA 55-40 RUDDER

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POST – MOD
A330/A340-300 (ST4,ST8)

(new Drawings)



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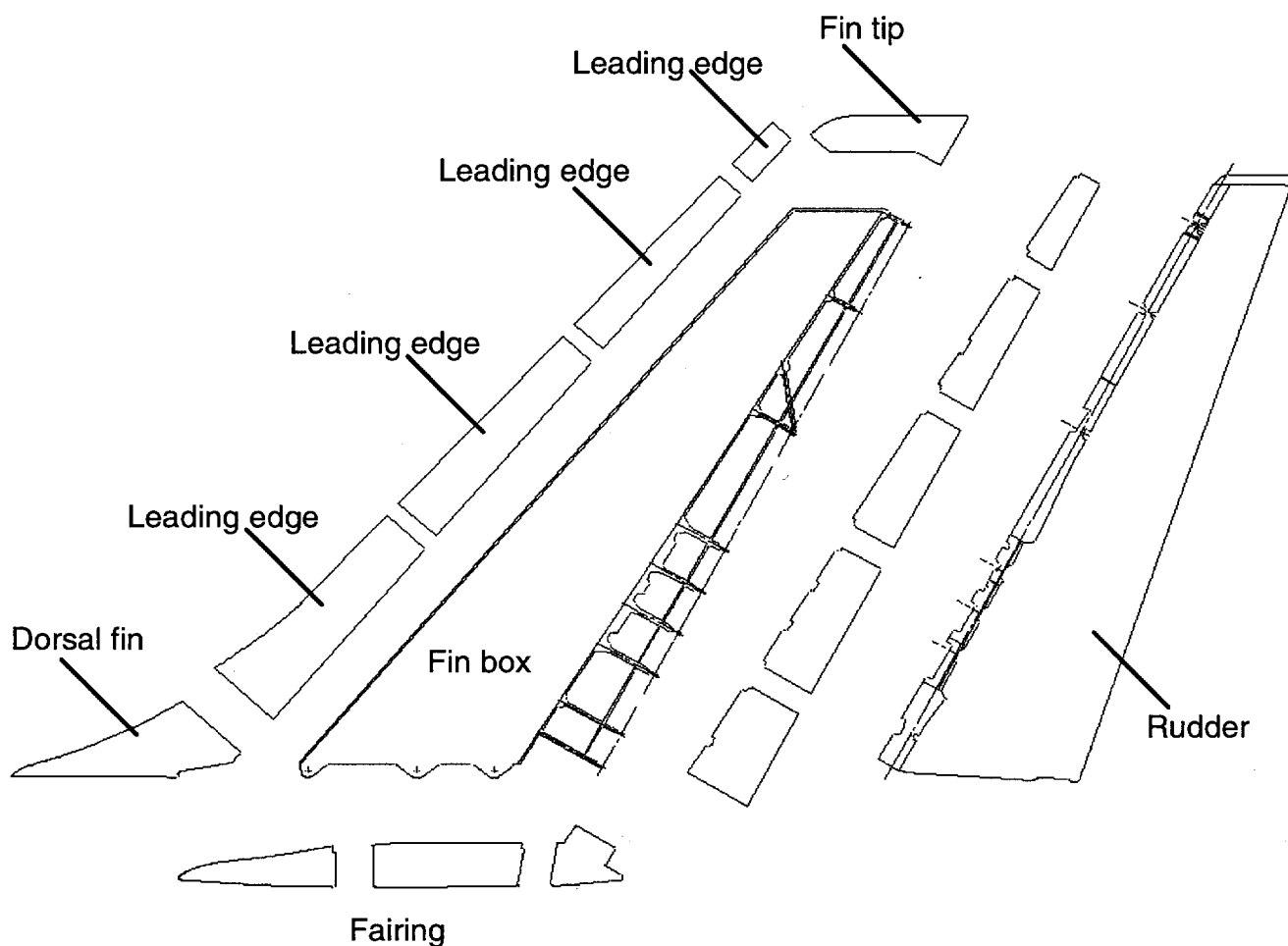
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SKETCH (USE CLM WHERE POSSIBLE)

ATA 55-30 VERTICAL STABILIZER
ATA 55-40 RUDDER

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PRE - MOD A340-500/-600 A330-200
(45 F553-71700 VTP-Structure for ST7,STA,STB,STE,STF)



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SKETCH (USE CLM WHERE POSSIBLE)

ATA 92 ELECTRIC AND ELECTRONIC INSTALLATION

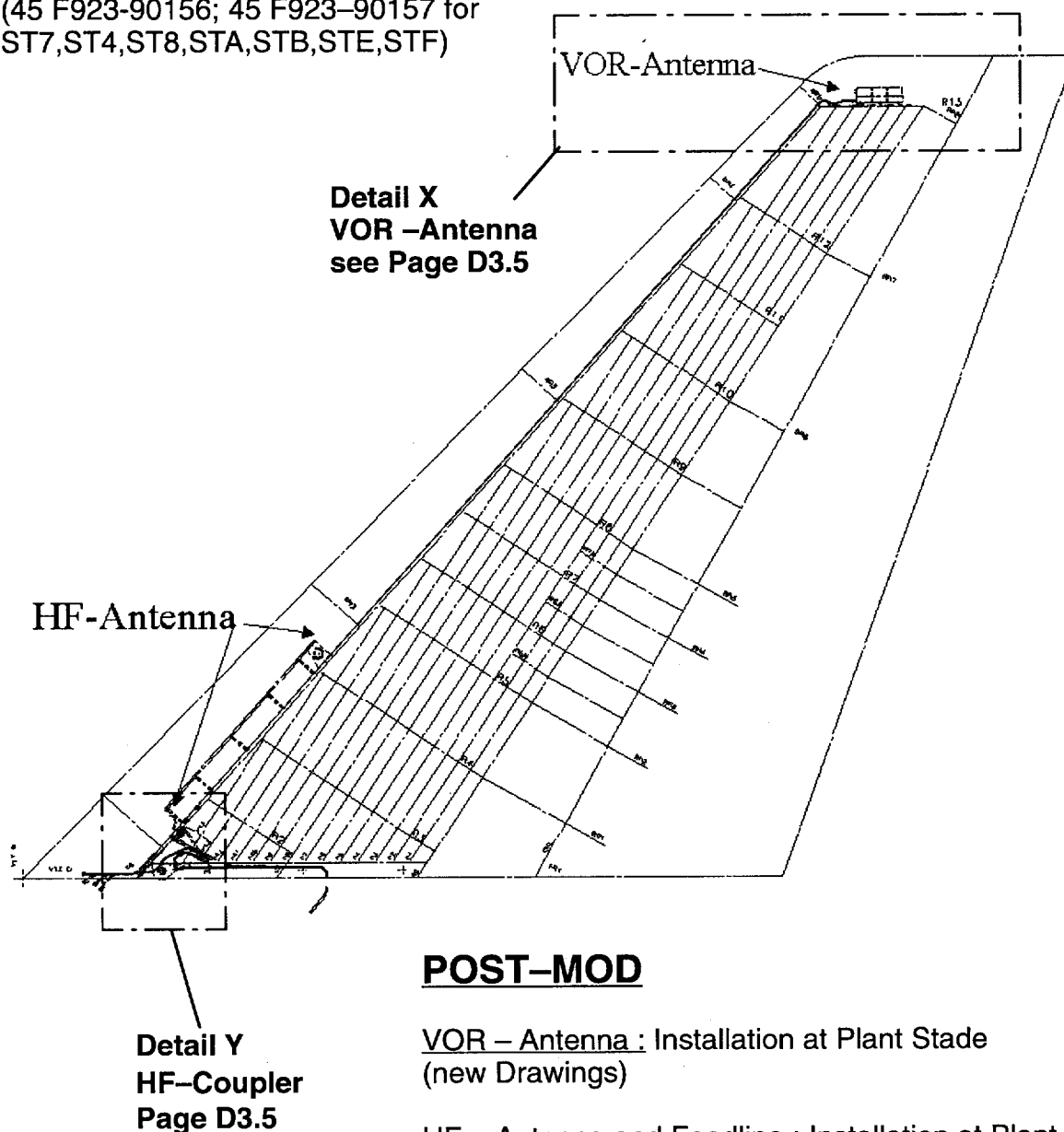
PRE-MOD

VOR – Antenna : Installation at FAL Toulouse
(45 F923-90159 for ST7,ST4,ST8)
(45 G923-90159 for STA,STB,STE,STF)

HF – Antenna and Feedline : Installation at FAL Toulouse
(45 F923-90158 for ST7,ST4,ST8,STA,STB,STE,STF)

HF – Coupler : Installation at FAL Toulouse
(45 F923-90156; 45 F923-90157 for
ST7,ST4,ST8,STA,STB,STE,STF)

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POST-MOD

VOR – Antenna : Installation at Plant Stade
(new Drawings)

HF – Antenna and Feedline : Installation at Plant Stade
(new Drawings)

HF – Coupler : Installation at Plant Stade
(new Drawings)

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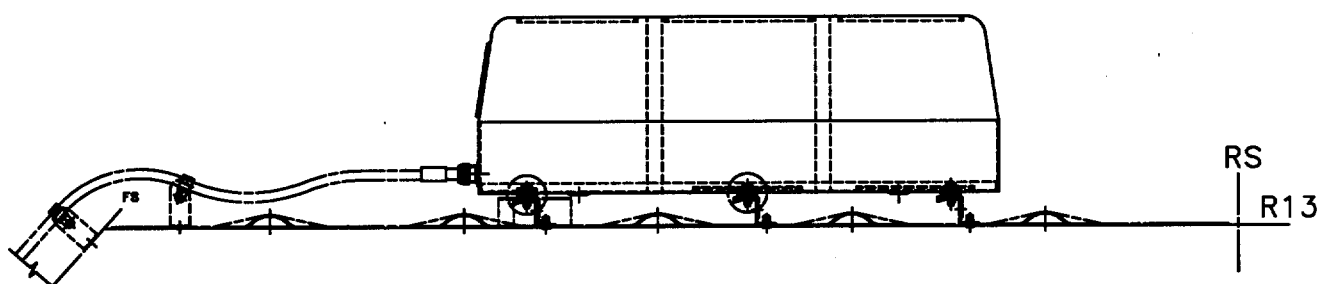
SKETCH (USE CLM WHERE POSSIBLE)

ATA 92 ELECTRIC AND ELECTRONIC INSTALLATION

Detail X

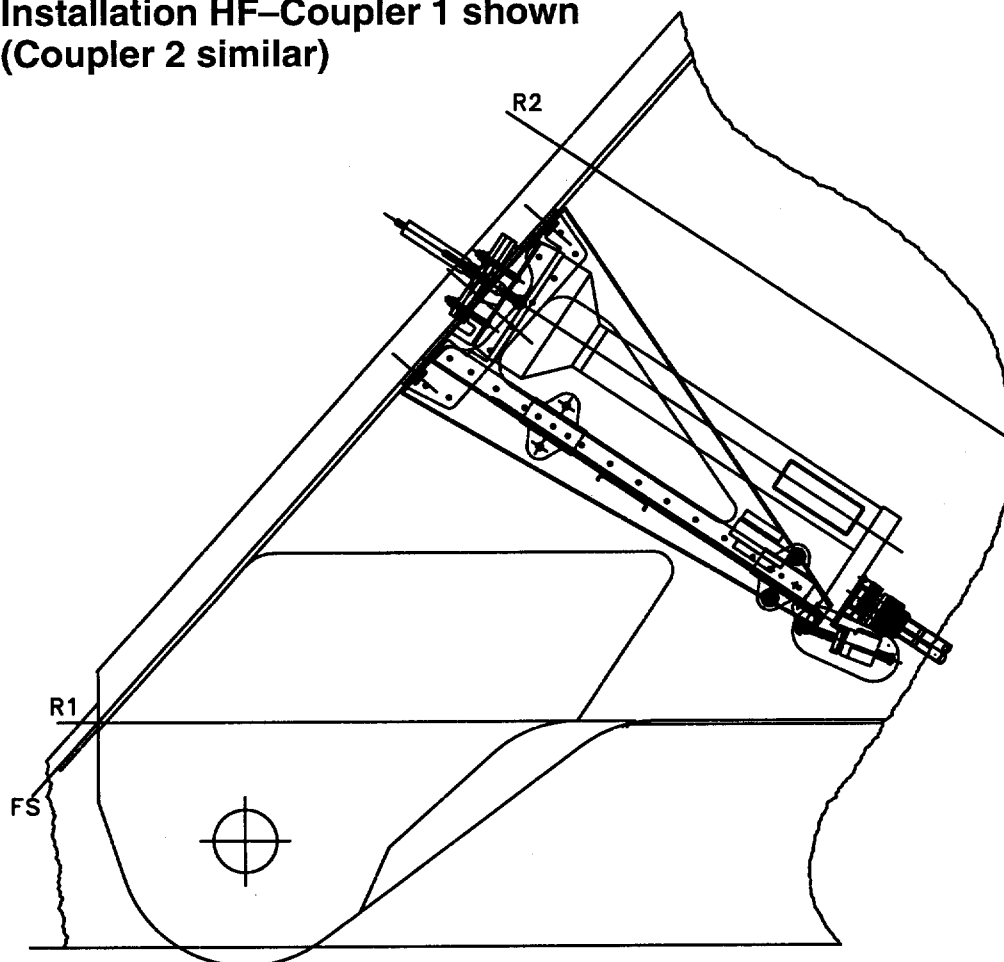
Installation VOR – Antenna

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Detail Y

Installation HF-Coupler 1 shown (Coupler 2 similar)



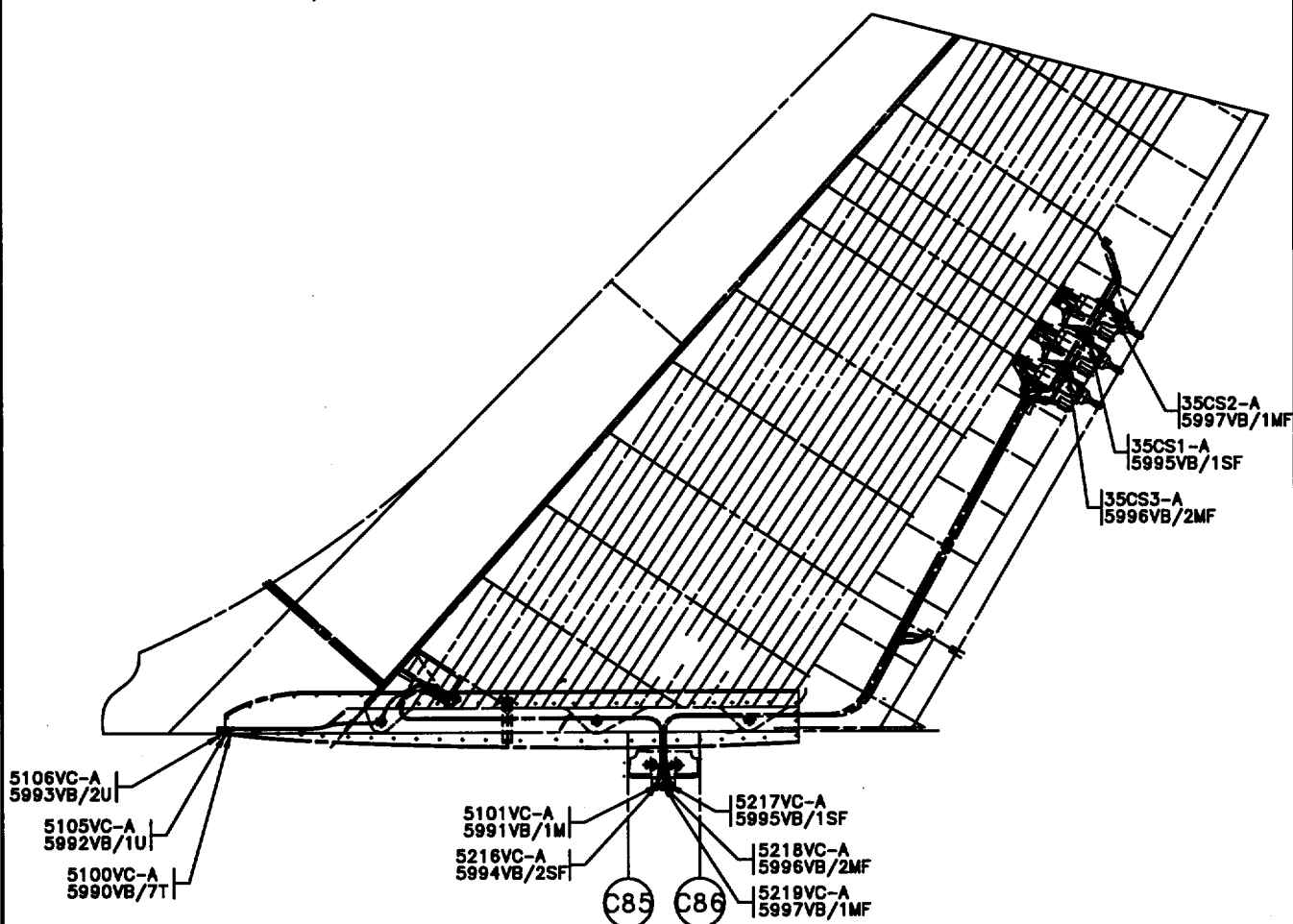
SKETCH (USE CLM WHERE POSSIBLE)

ATA 92 ELECTRIC AND ELECTRONIC INSTALLATION

ELECTRICAL INTERFACES

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General View, A330/A340-300 shown



PRE – MOD

Electrical Interfaces : Installation at FAL – Toulouse

45 F928 90499 (A330/A340-300)

45 G928 90499 (A330-200, A340-500/600)

POST – MOD

Electrical Interfaces : Installation at Stade
Plant

(new drawings)
* FOR INFORMATION ONLY, NON APPROVED DATA

MAS
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OTHER REPERCUSSION					MOD No.	55760
STAT. TEST	FAT. TEST	LAB. TEST	GROUND TEST	FLIGHT TEST	MP No.	D46079
NO	NO	NO	NO	NO	RFC No.*	
MAINTENANCE	IPC	ICY DRWG	MOD COST BENEFIT	STD SPEC	QUERY No.*	
NO	NO	NO	NO	NO	RFW No.*	
					REF No.*	M 18035
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IS THE MODIFICATION RETROFITABLE?

WITH PRODUCTION SOLUTION?

YES

WITH SPECIAL SOLUTION?

NO

DETAILED DESCRIPTION OF THE MODIFICATION INCLUDING THE WORK TO BE DONE TO EMBODY ON AIRCRAFT BEFORE DELIVERY

Spares Interchangeability: 200

A-D – Part

ATA 55–30 Stabilizers – Vertical Stabilizers –

ATA 55–40 Stabilizers – Rudder –

In order to change the location of the VTP–final assembly, the adaptation of existing drawings and the preparation of new drawings are necessary.
Also the GTR must be adapted.

The affected drawings, now in use for the assembly in Toulouse are :

45 F553-71700 valid for A330–200, A340–500 and A340–600

45 F553-70600 valid for A330–300 and A340–300

Note: The transport of the VTP and the rudder safety device with/without actuators shall be performed analogous to minutes of meeting of Final Design Review of the transport jig by Claas Fertigungstechnik GmbH dated 30.03.2006, that means on the transport without actuators the actuator connection points will be used.

Additional minor improvements due to modified production procedure:

- Enlargement of pre–drilling holes (from dia 2.5 to dia 2.7) in the area of Fin Box, Rudder and leading edges to reduce working steps.
- The actually used wedge washers (F553–70529) in step "skin panel riveting" (F553–71712, valid for ST07,ST10,ST11,ST14,ST15) shall be replaced by steel wedge washers due to lower need of space.

(These wedge washers are already in use in Single Aisle program)

- Modified geometry of coverfoils for inspection holes (F553–70530)

SPECIAL SUPPLY REFERENCE

DETAILED DESCRIPTION OF THE MODIFICATION INCLUDING THE WORK TO BE DONE TO EMBODY ON A/C BEFORE DELIVERY

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ATA 92 Electric and Electronic common installation

Preparation of new Installation-drawings for the VOR-antenna .

The affected drawings, now in use for the assembly in Toulouse are :

45 F923-90159 for A330-200, A330-300 and A340-300

45 G923-90159 for A340-500 and A340-600

Preparation of new Installation-drawings for the HF-antenna-feedline and the HF-coupler.

The affected drawings, now in use for the assembly in Toulouse are:

45F923-90158; 45F923-90156 for A330-200, A330-300, A340-300, A340-500, A340-600

Preparation of new Installation drawings for the electrical interfaces

The affected drawings, now in use for the assembly in Toulouse, are :

45 F928-90499 for A330-300 and A340-300

45 G928-90499 for A330-200 , A340-600 and A340-500

TARGET DATE FOR MODIFICATION DECISION:
MOD No.

55760

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D46079

DESIGN OFFICE
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QUERY No.*
DEPT. : TSL4

RFW No.*
PHONE : +49 4141 60 3928

REF No.*

M 18035

ISSUE*

D 4

SYSTEM AFFECTED
ESTIMATED ISSUE (WEEKS)
COD
ATA
**FUNCTIONAL
REFERENCE (F.I.N.)**
**CONST.
ASSEM.**
**EQUIPMT.
SPECIF.**
**SCHEMES/WORK.
DRAWINGS**

55
000
92

FV 000
FV 000
FV 000

REMARKS:

AFFECTED CHAPTER		MOD No.	55760
1 DESIGN	13 SALES & PRODUCT SUP.	MP No.	D46079
2 WIND TUNNEL & MOCKUP	14 MISCELLANEOUS	RFC No.*	
3 STRUCTURE TESTS		QUERY No.*	
4 SYSTEMS TESTS		RFW No.*	
5 SIMULATOR	RESP. / EXEC.:	REF No.*	M 18035
6 EQUIPMENT DEVELOP.	A AIRBUS CENTRAL ENTITY	ISSUE*	D 4
7 TOOLING & MOCKUP	B BELAIRBUS		
8 MANUFACTURE	C AIRBUS ESPANA		
9 FLIGHT TESTS	D AIRBUS DEUTSCHLAND		
10	H AIRBUS UK		
11 GROUND EQUIPMENT	S AIRBUS FRANCE		
12 SPARES	V ALENIA		
CH.	DEFINITION OF WORK	RESP.	EXEC.
1.0	<u>Design</u>		
1.1	System diagrams and equipment lists (mechn./elt.)	D	D
1.2	New detail and installation drawings	D	D
1.3	Determination of weights	D	D
1.4	Stress check	D	D
1.5	Approval of system	D	D
1.6	General services and miscellaneous – Airworthiness	D	D
1.7	Preparation and confirmity check of TD/MAS	D	D
7.0	<u>Tooling and Mock-up</u>		
7.1	Definition of new toolings	D	D
7.2	Manufacture of new toolings	D	D
7.3	Modification of toolings	D	D
8.0	<u>Manufacture</u>		
8.1	Manufacture of new parts (mechn.)	D	D
8.2	Installation of parts	D	D/S
8.3	Check of system	D	D/S
12.0	<u>Spares</u>		
12.1	Amendment of spare parts list	D/A	D/A
13.0	<u>Sales and product support</u>		
13.1	Amendment of a/c manuals	D	D