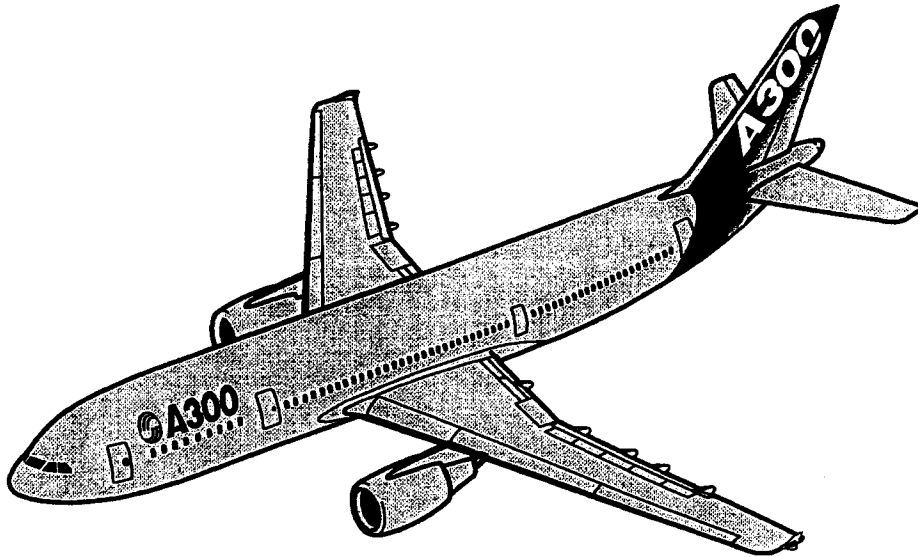


Thème support de l'étude :

Montage Servo-commande A300-



Documents ressources :

Extrait de documents techniques de Maintenance Airbus A300 page 2 et 3

Extrait de la fiche technique de montage sur chaîne Airbus A300 page 4 à 9

Extrait de documents techniques de Maintenance Airbus A300 page 10 à 12

	Session	2008	Facultatif : code	500 254 30
Examen et spécialité	CAP : MECANICIEN CELLULES D'AERONEFS			
Intitulé de l'épreuve	EP1 : PREPARATION DU TRAVAIL ET TECHNOLOGIE DES AERONEFS			
Type		Durée	Coefficient	N° de page / total
DOSSIER TECHNIQUE		2 H	4	1/12

ZONING

1. General

Zone delimitation and division is accomplished as follows :

- major zones
- major sub-zones
- sub-zones

Identification is made by a three-digit number.

A. Major Zones

(Ref. Fig. 001)

Major zones are identified by a three-digit 100 series number as follows :

- 100, Lower half of fuselage
- 200, Upper half of fuselage
- 300, Empennage
- 400, Nacelles
- 500, Left wing
- 600, Right wing
- 700, Landing gear
- 800, Doors

B. Major Sub-Zones

Division of the 100 series zone is accomplished by sub-zoning on the basis of the second digit in the zone number.

(1) Fuselage and empennage

(Ref. Fig. 002)

(2) Wing and nacelle - L and R

(Ref. Fig. 003)

C. Sub-Zones

Division of sub-zones is accomplished by use of the third digit in the zone numbers

(1) Fuselage and empennage

R **0N A/C 651-699,

(Ref. Fig. 004)

**0N A/C 601-650,

(Ref. Fig. 005)

**0N A/C ALL

(2) Wing - L and R

(Ref. Fig. 006)

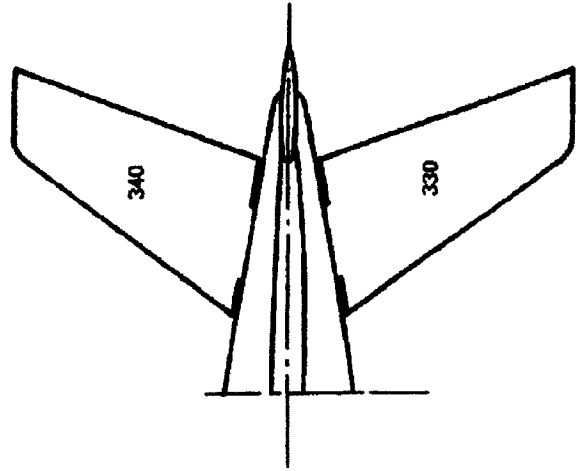
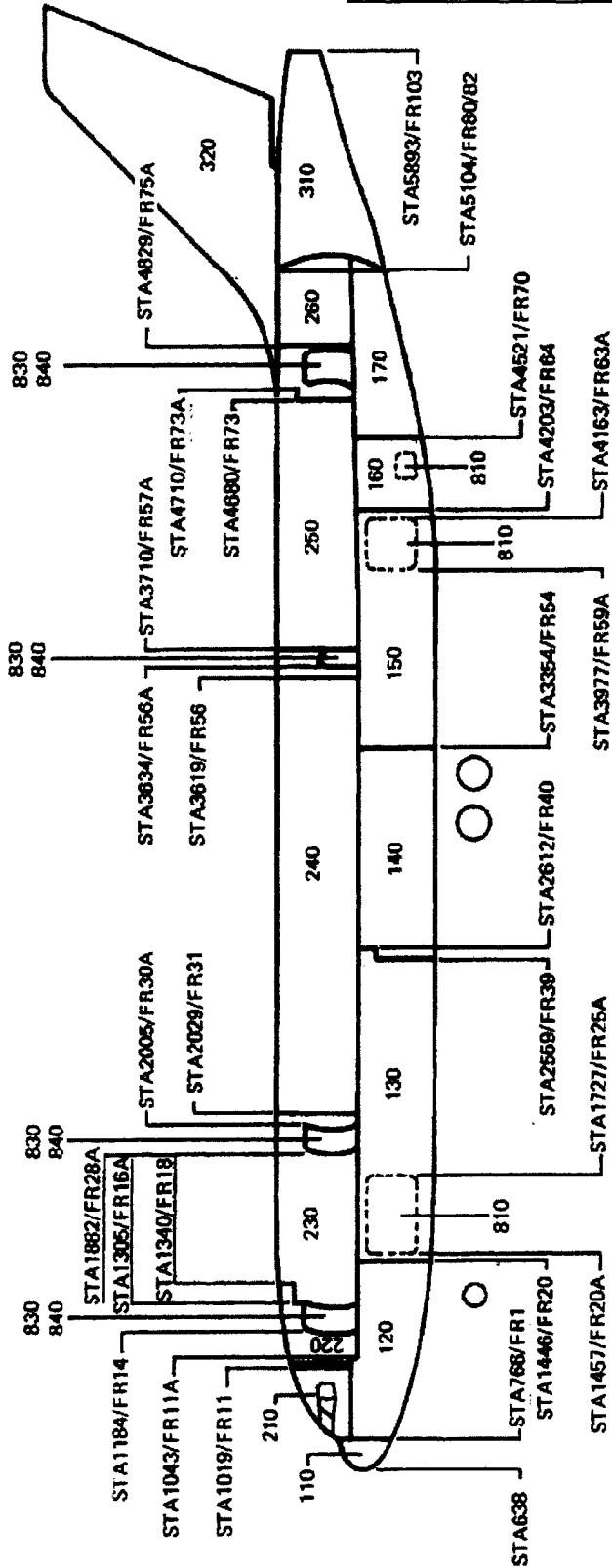
(3) Nacelles and Pylons

(Ref. Fig. 007)

(4) Landing gear (Ref. Fig. 008)

(5) Access doors

BM5 06.21 00 0 BDMO - 00

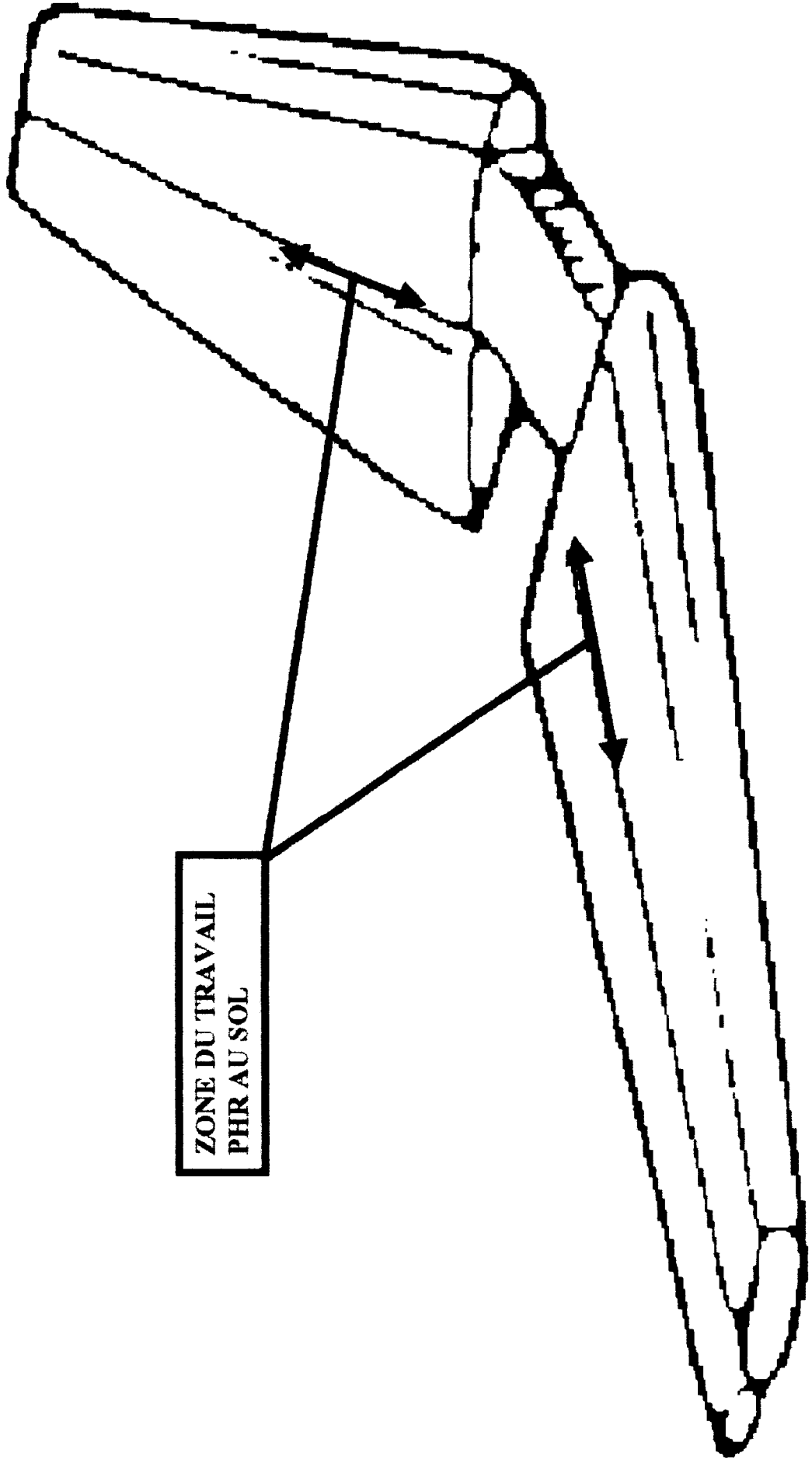


Fuselage and Empennage Major Sub-Zones

Fiche Technique

Désignation :

MONTER, REGLER SERVOCOMMANDES PROFONDEUR



MONTER, REGLER SERVOCOMMANDES PROFONDEUR

Ident. :

Phase	REFERENCE DEBIT	Qté	REP.		Plans-IPDA-IF
			Plan	MC-OUTILLAGES	
MONTER SERVO-COMMANDES PROFONDEUR					
M10	Pour l'accès aux logements des servo-commandes, ouvrir les panneaux extrados et intrados côtés droit et gauche				NT A 007 10153
	Récupérer la visserie et l'attacher aux panneaux pour montage ultérieur en poste 25				NT A 007 10175
<u>MISE EN PLACE DES SERVO-COMMANDES COTE CAISSON</u>					
1- S'assurer que les bagues épaulées, montées par CASA sont dans le bon sens					
	2- Présenter servos	EQ 271160	1	82	A27373016
		EQ 272160	1	84	
		EQ 273160	1	80	
		EQ 271161	1	82	A27373017
		EQ 272161	1	84	
		EQ 273161	1	80	
Fixer, torquer et goupiller les axes équipés					
-Clés pour écrous sta-lok					
			1		498000A2760800800
			1		498000A2740801400
			1		498000A2740801200
			1		WB 465701A4371
			1		WB 465702A4371
			6	26	A55179980
	Rondelle	MS20002C14			
	Goupille	MS24665310	12	28	
	Ecroû	NSA5063-12	12	38	
	Rondelle	NSA5064-12	12	44	
NOTA: NE PAS OUBLIER : LE GRAISSAGE DES AXES AVEC					
LE REPERE DE TORQUAGE					
3- Coller les étiquettes sur servos					
		A27374760220	1	58	A27373654
		A27374760222	1	60	A27373654
		A27374760224	1	56	A27373654

MONTER, REGLER SERVOCOMMANDES PROFONDEUR

Ident. :

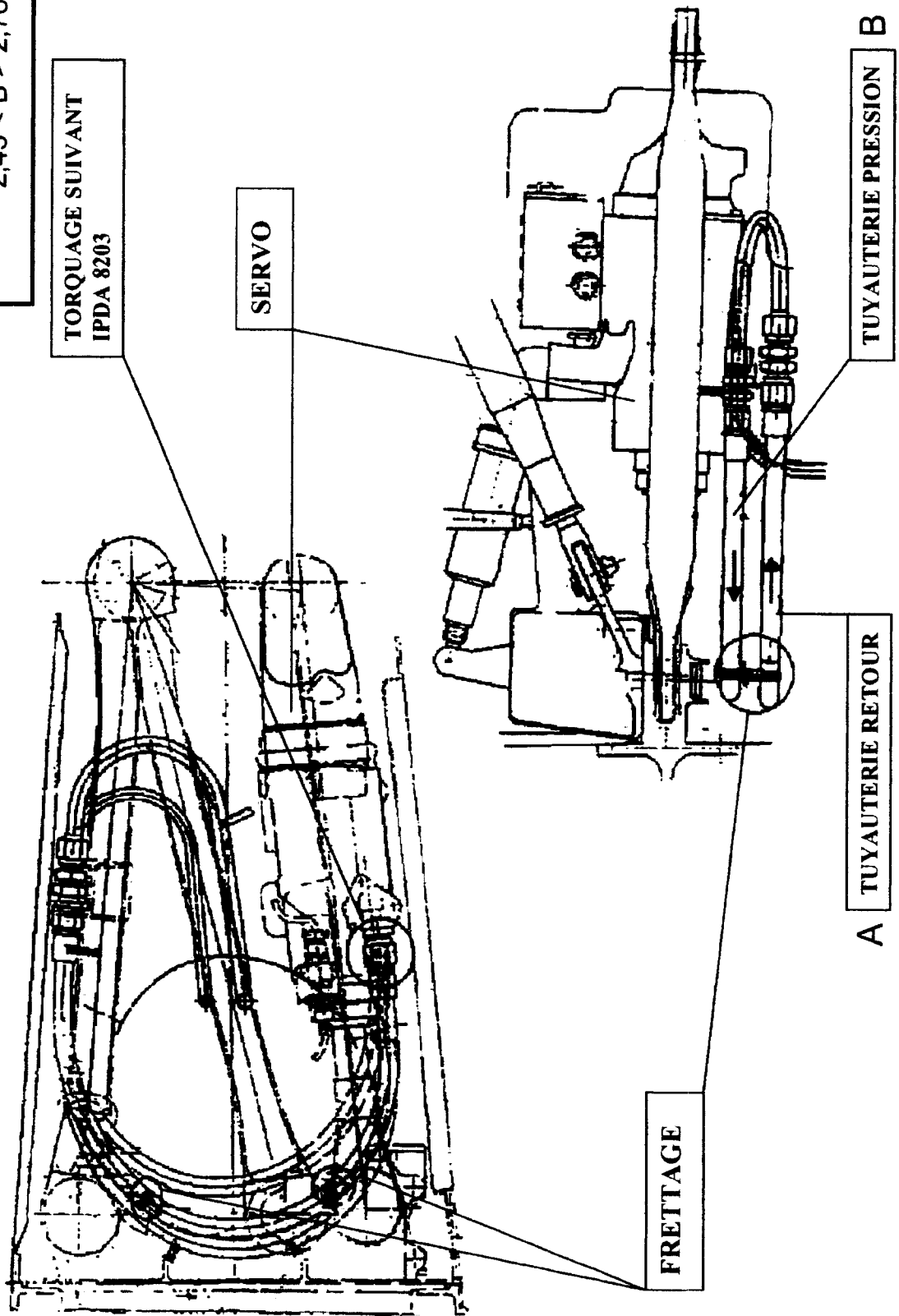
Phase	REFERENCE DEBIT	Qté	REP.		Plans-IPDA-IF
			Plan	MC-OUTILLAGES	
M10	A27374760226	1	58		A27373655
	A27374760228	1	60		A27373655
	A27374760230	1	56		A27373655
4- Vider les servos de l'huile de stockage.					
5- Raccorder les tuyauteries hydrauliques (HP 206 bars, BP 3.5 bars) sur servos, lorquer, les fretter ensemble pour éviter tout contact entre elles ou structure (voir page 8)					IPDA8203
Faire repère de lorquage					
6- Fixer les prises électriques sur leurs supports, les freiner et connecter les prises mobiles. (s'assurer de la bonne connection et orientation du cablage)			31		A92292200
			50		A92292198
7- Maintenir les servos horizontalement à l'aide de l'outillage		1			465000A27373655000
8- Présenter et monter les bielles à l'iror côté caisson et côté volet. Torquer et goupiller (ne pas oublier de graisser les axes)	A27374600004	6	30		A27373654
	PQ1000601500				IPDA7103
MISE EN PLACE DES SERVO-COMMANDES COTE VOLET, APRES MONTAGE DE CELUI-CI (OP.453.3100.001.XXXXX)					
1- Présenter servos, fixer, lorquer et goupiller les axes équipés					A27373654
					A27373655
					IPDA7113
		1			498000A2760800800
		1			498000A2740801200
		1			498000A2740801400
		1			WB465701A4371
		1			WB465702A4371

MONTER, REGLER SERVOCOMMANDES PROFONDEUR

Ident. :

M10

Couples de Torquage en mdaN :
2,60 < A < 2,94
2,43 < B < 2,76

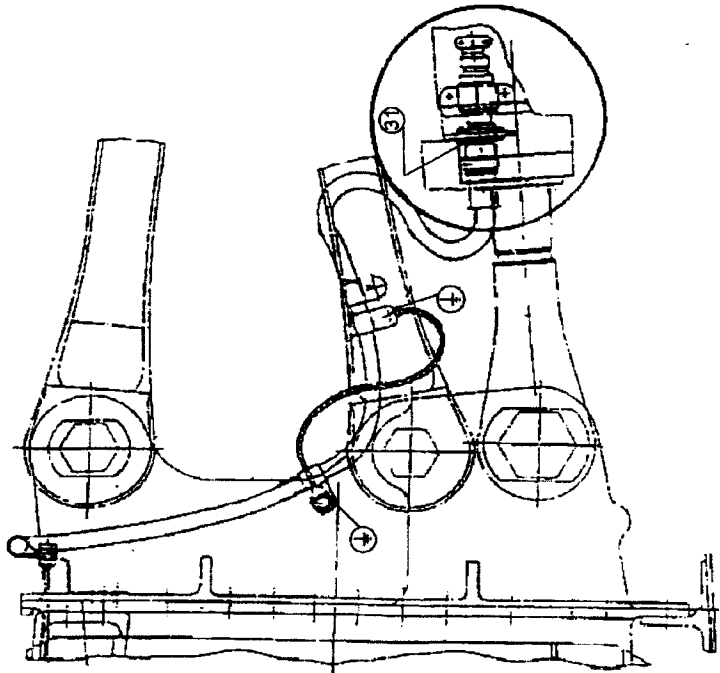


MONTER, REGLER SERVOCOMMANDES PROFONDEUR

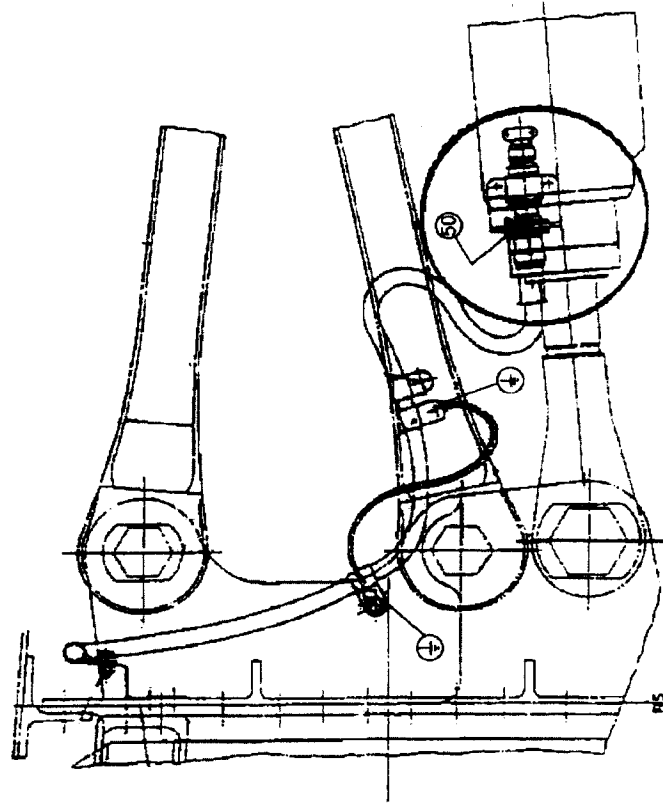
Ident. :

M10

FREINER LES PRISES ELECTRIQUES
SUIVANT PLAN A92292200 REP 31



FREINER LES PRISES ELECTRIQUES
SUIVANT PLAN A92292198 REP 50



**** ON ELEVATOR SERVO CONTROL P/N 30504**

CAUTION : SERVO CONTROL WEIGHS APPROX. 11 kg (25 lb.).

**** ON ELEVATOR SERVO CONTROL P/N 31043**

CAUTION : SERVO CONTROL WEIGHS APPROX. 8.5 kg (19 lb.).

**** ON ALL ELEVATOR SERVO CONTROLS**

- (13) Remove servo control (10) and bush (2).
- (14) Remove washers (8, 14) and bushes (7, 13).

**** ON ELEVATOR SERVO CONTROL LS WITH STA-LOK LOKING SYSTEM****B. Removal****** ON ELEVATOR SERVO CONTROL P/N 30504**

(Ref. Fig. 401)

**** ON ELEVATOR SERVO CONTROL P/N 31043**

(Ref. Fig. 402)

**** ON ALL ELEVATOR SERVO CONTROLS**

CAUTION : IT IS ESSENTIAL TO IDENTIFY BOLTS, BUSHES AND SIMILAR SMALL COMPONENTS AT EACH CONNECTION, TO ENSURE INSTALLATION IN ORIGINAL POSITIONS.

- (1) Remove control bellcrank (Ref. 27-31-22, P. Block 401) and servo control actuating spring rod (15) (Ref. 27-31-23, P. Block 401).
- (2) Position container for hydraulic fluid spillage.
- (3) Disconnect hydraulic hoses (11) and drain residual hydraulic fluid into container.
- (4) Cap and plug hydraulic hoses and servo control ports.
- (5) Remove nut (9) and disconnect electrical connector (12) from jamming detection microswitch and install blanking caps.

**** ON ELEVATOR SERVO CONTROL P/N 30504**

- (6) Remove nut (18), washer (17) and disconnect bonding strap (16).

**** ON ELEVATOR SERVO CONTROL P/N 31043**

- (6) Remove screw (18), washer (17) and disconnect bonding strap (16).

**** ON ALL ELEVATOR SERVO CONTROLS**

- (7) Remove cotter pins (3, 22).
- (8) Remove retaining ring (36, 45) using STA-LOK extractor

P/N SL90.314-0.7500

- (9) Remove ring nuts using notched wrench P/N SL90.374-0.7500.
- (10) Remove cupwashers (4, 23).
- (11) Support servo controls (10).
- (12) Remove bolts (1, 19) and washer (20).

**** ON ELEVATOR SERVO CONTROL P/N 30504**

CAUTION : SERVO CONTROL WEIGHS APPROX. 11 kg (25 lb.).

**** ON ELEVATOR SERVO CONTROL P/N 31043**

CAUTION : SERVO CONTROL WEIGHS APPROX. 8.5 kg (19 lb.).

**** ON ALL ELEVATOR SERVO CONTROLS**

- (13) Remove servo control (10) and bush (2).
- (14) Remove washer (8, 14) and bushes (7, 13).

C. Preparation for Installation

- (1) Check identification placards on servo controls:

LH side:

- 3160 - For Yellow hydraulic system - inboard servo control.
- 1160 - For Green hydraulic system - middle servo control.
- 2160 - For Blue hydraulic system - outboard servo control.

RH side:

- 3161 - For Yellow hydraulic system - inboard servo control.
- 1161 - For Green hydraulic system - middle servo control.
- 2161 - For Blue hydraulic system - outboard servo control.

- (2) Check condition of all bolts, bushes etc.

- (3) Apply grease (Mat. No. 04-004) or special material (Mat. No 05-002) to all bolts and threaded fasteners.

**** ON ELEVATOR SERVO CONTROL WITH SHUR-LOK LOCKING SYSTEM**

D. Installation

**** ON ELEVATOR SERVO CONTROL P/N 30504**

(Ref. Fig. 401)

**** ON ELEVATOR SERVO CONTROLS P/N 31043**

(Ref. Fig. 402)

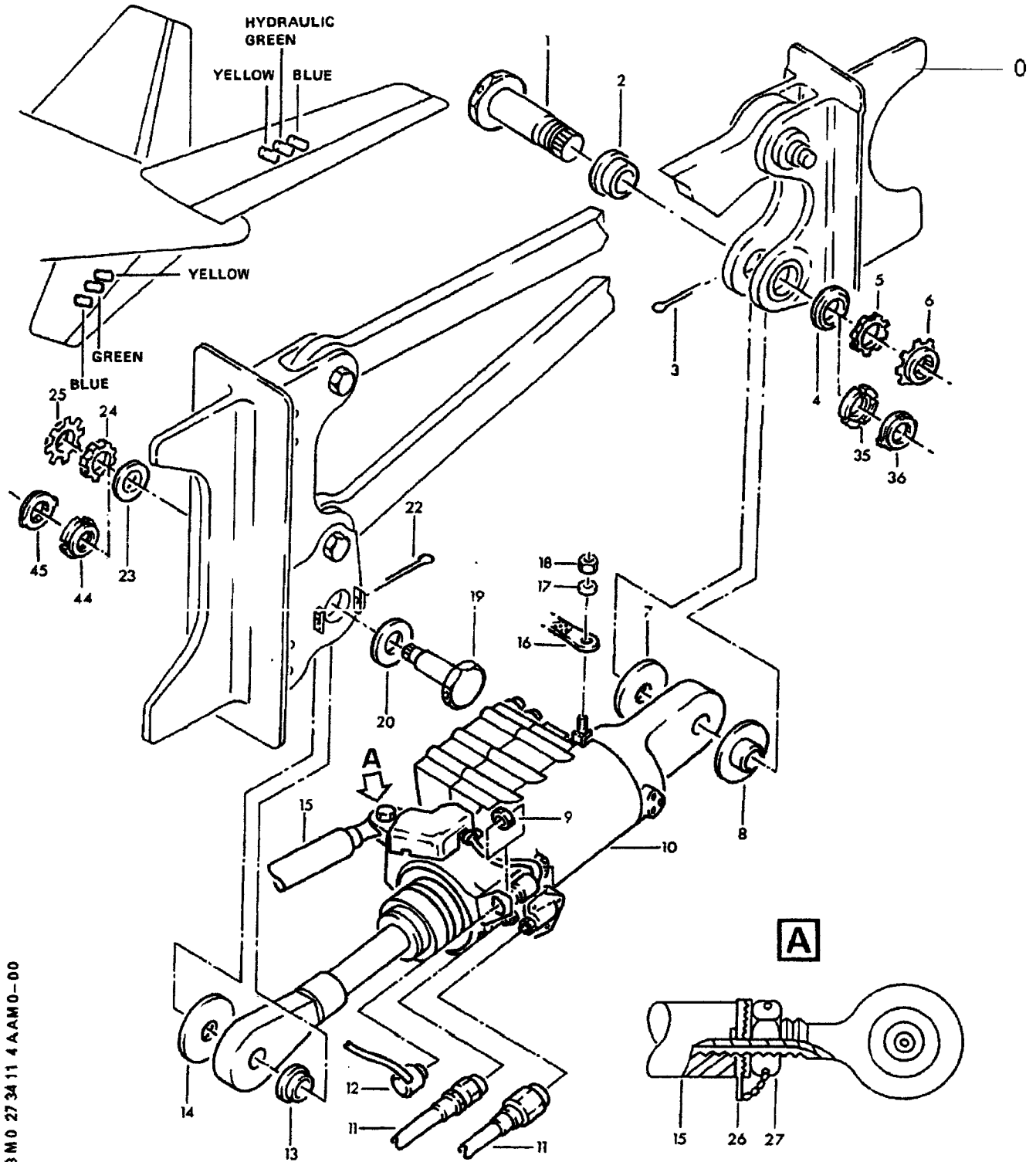
**** ON ALL ELEVATOR SERVO CONTROLS**

- (1) Apply sealant (Mat. No. 09-013) to washer (8).
- (2) Install bushes (7, 13) and washer (8, 14).
- (3) Position servo control (10).
- (4) Install bush (2) and bolt (1).
- (5) Install washer (20) and bolt (19).

A300-600

Extrait de document technique de maintenance

- (6) Install cupwashers (4, 23) and slotted ring nuts (5, 24).
- (7) TORQUE slotted ring nuts (5, 24) to between 2.21 and 2.70 m.daN (16.30 and 20.0 lbf.ft.) using socket wrench set P/N 98A27408018000.
- (8) Install lockwashers (6, 25) using SHUR-LOK tool set P/N 98A27907509000.
- (9) Install cotter pins (3, 22).



8 M O 27 34 11 4 A A M O - 00

Fig 401