



**RUSSIAN FEDERATION
MINISTRY OF TRANSPORT OF THE RUSSIAN FEDERATION
FEDERAL AIR TRANSPORT AGENCY**

AIRWORTHINESS DIRECTIVE

09.07. 2018

№ 2018-322-01

Applicability - RRJ-95 Aircraft

Country of Origin - Russian Federation

The corrective actions prescribed by this Airworthiness Directive are mandatory. No persons may operate an aircraft to which this Airworthiness Directive applies, except in accordance with the requirements of this Airworthiness Directive.

In the course of maintenance tasks implementation on Aircraft with Manufacturer's serial numbers (MSN) 95044 and 95051 have been detected loosened and dropped hold-down screws p/n 5-16-Хим.Пас.-ОСТ 1 31574-80, which hold clamping of passenger cabin windows, as well as loss of locking features of the anchor nuts p/n 5-И OCT 1 33264-89. The defected parts were removed and sent for investigation. In the course of the investigation have been detected mechanical damages to the nuts thread caused by a sharp tool showing a violation of the installation procedure, followed in production in accordance with the job instructions for passenger cabin windows installation. JSC Sukhoi Civil Aircraft (SCAC) issued Technical Decision RRJ0000-OR-470-1975 on this matter.

THE FOLLOWING IS PROPOSED:

1. According to the Decision № RRJ0000-OR-470-1975 at the nearest Scheduled Maintenance Operation after 750 flight hours, 100 days (depending on what is the earliest) RRJ-95 Aircraft with MSN 95037, 95041, 95042, 95050, 95053, 95055, 95057, 95058, 95059, 95060, 95061, 95062, 95063, 95064, 95084 to undergo general visual inspection of passenger cabin windows for absence of play among glasses, placeholders, surround covers and fuselage. Play between parts, above mentioned, is not allowed.

2. In future, conduct general visual inspection of the passenger cabin windows for absence of the glass play with intervals of 750 flight hours, 100 days (depending on what is the earliest) of RRJ-95 Aircraft with MSN 95037, 95041, 95042, 95050, 95053, 95055, 95057, 95058, 95059, 95060, 95061, 95062, 95063, 95064, 95084 till 7500 flight hours, 6000 flight cycles, 24 months (depending on what comes the earliest).

3. At the nearest Scheduled Maintenance Operation after 7500 flight hours, 6000 flight cycles, 24 months (depending on what comes the earliest) perform replacement of the passenger cabin windows fasteners of RRJ-95 Aircraft with MSN 95037, 95041,

95042, 95050, 95053, 95055, 95057, 95058, 95059, 95060, 95061, 95062, 95063, 95064, 95084.

4. Contact SCAC as the manufacturer of the Aircraft on all the issues related to the technical content of Decision.

Attachment:

1. Decision № RRJ0000-OR-470-1975 in 4 sheets.

Deputy Head

O. G. Storcheyov

“APPROVED”
Deputy Chief Designer for Operations
SCAC

D. Omelchenko
«09» July 2018

TECHNICAL DECISION RRJ0000-OR-470-1975

on continued airworthiness of RRJ-95 type aircraft due to non-conformity in the
mounts of passenger cabin windows retainers p/n T7.92.0704.105.000.70/B

Due to identification of non-conformity in the mounts of passenger cabin windows retainers p/n T7.92.0704.105.000.70/B on AC RRJ-95B RA-89024 and RA-89026: loosen and fallen out hold-down screws 5-16-ХИМ.Пас.-ОСТ 1 31574-80, as well as loss of locking features of anchor nuts 5-Ц ОСТ 1 33264-89 the following decision has been taken:

DECISION:

1. During the next scheduled maintenance equal to 750 FH, 100 days (whichever comes first) on AC RRJ-95 MSN 95037, 95041, 95042, 95050, 95053, 95055, 95057, 95058, 95059, 95060, 95061, 95062, 95063, 95064, 95084 to perform general visual inspection of passenger cabin windows in order to check if there is a gap between outer window panel and window frame and fuselage as follows:
 - Observe Safety precautions when performing maintenance of the windows (ref. to AMM Task 56-00-00-920-801);
 - Install ladder GE-06-004 (Ladder to access to the top part of the wing) in the work area;
 - Ensure that there is no gap between outer window panel and the window frame and fuselage (see Fig. 1) by means of manual progressive physical action around the perimeter of outer window panel (along the outline) of the passenger cabin window.

NOTE 1: Discrepancy (gap) between the outer window panel and the window frame is not allowed.

After the visual inspection is completed:

- Clean the work area (if required), ensure that no foreign objects are left;
- Remove the ladder.

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2. In case non-conformity is revealed, upon the results of cl.1 of this Decision – to perform replacement of defective mount of passenger cabin window in accordance with the procedure described below:
 - 2.1. To perform preparatory activities in order to open the access areas IAW cl.3 Б. of AMM 56-21-01-900-801 “Removal/Installation of passenger cabin window”;
 - 2.2. Remove seats units in the area of passenger cabin window removal (see activity AMM 25-21-01-900-801);
 - 2.3. Remove side panels in the area of passenger cabin window removal (see activity AMM 25-23-05-900-801);
 - 2.4. Perform replacement of retainers p/n T7.92.0704.105.000.70/B;

NOTE 2: During retainers installation instead of previously installed hold-down screws p/n 5-16-Хим.Пас-ОСТ 1 31574-80 to perform installation of new screws with hexagon head p/n 5-16-Хим.Пас-ОСТ 1 31503-80.

To perform tightening of screws IAW AMM 56-21-01-900-801. To perform tightening of screws 6 (clause 4 "Б (6)", page 402) as per the following procedure: removing one-by-one each screw on the opposite sides of the strip until the gap appearance, again tighten the screws until they contact with the retaining strip. After contact to turn the screw for 1.5 of the turn, at that deformation (bending) of the corner for 1.5 mm is allowed.

NOTE 3: Installation of retainers p/n T7.92.0704.105.000.70/B with the bolts p/n 5-12-Ц-ОСТ 1 31158-80 to be performed with application of a thin layer of paste LU-052 or sealer IS-069 on a threaded part of screws after preliminary cleaning of the contacting surface of the retainer and retaining strip (see Fig.1) with a cleaning rug soaked in solvent.

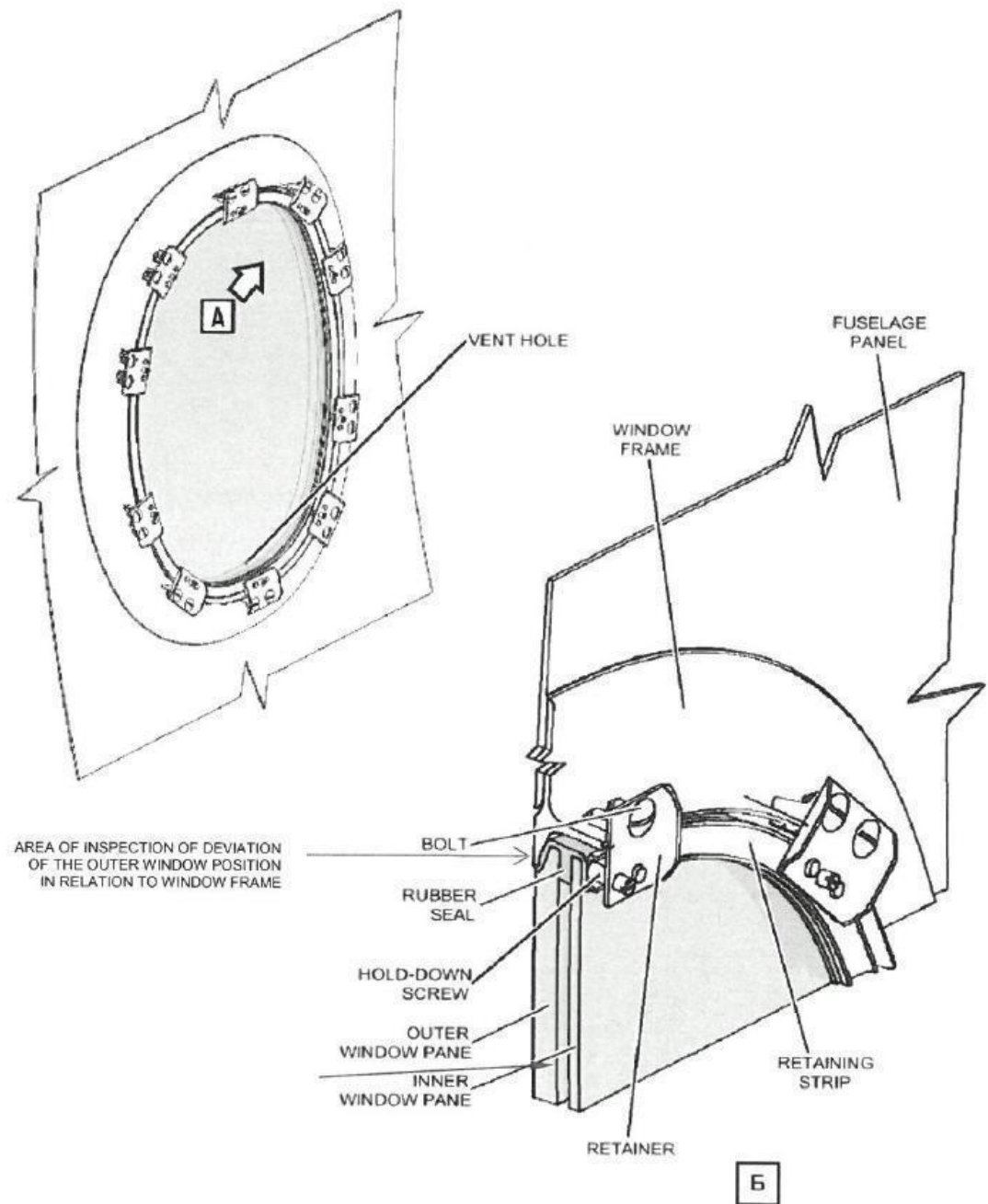
- 2.5. To apply paint-and-lacquer coating (primer ЭП-076) on the head and visible threaded part of the screw p/n 5-16-Хим.Пас-ОСТ 1 31503-80 after installation.
- 2.6. To perform test IAW AMM 21-31-00-780-801 “Test of Leakage of the Pressurized Cabin”;
- 2.7. To perform final activities IAW cl.5 А. of AMM 56-21-01-900-801 “Removal/Installation of passenger cabin window”.

3. Further intermediate inspections to be performed through one inspection, but one scheduled maintenance equal to 750 FH, 100 days (whichever comes first) prior to occurrence of requirements of cl. 4. In case non-conformity is revealed after the inspection – to follow cl. 2.

NOTE 4: No actions are required with replaced retainers p/n T7.92.0704.105.000.70/B and screws p/n 5-16-Хим.Пас-ОСТ 1 31503-80.

4. During upcoming scheduled maintenance equal to 7,500 FH, 6,000 flights, 24 months (whichever comes first), but not earlier than 31.07.2018, to perform replacement of the mounts of passenger cabin windows on AC RRJ-95 MSN 95037, 95041, 95042, 95050, 95053, 95055, 95057, 95058, 95059, 95060, 95061, 95062, 95063, 95064, 95084 as per the procedure described in cl. 2.

NOTE 5: No actions are required with retainers p/n T7.92.0704.105.000.70/B replaced during performance of cl. 1-3, and screws p/n 5-16-Хим.Пас-ОСТ 1 31503-80.



Passenger Cabin Window
Figure 1

Fig.1. Passenger Cabin Window.