

REVISION TRANSMITTAL SHEET

**SERVICE BULLETIN 10015804-35-01
REVISION NO. 04 DATED NOV 09/2023**

HIGHLIGHTS

This sheet transmits Revision 04 to Service Bulletin 10015804-35-01

**SUBJECT: OXYGEN – CYLINDER – POSSIBLE MISSING COMPONENT ON OXYGEN
CYLINDER VALVE ASSEMBLY**

NOTICE: The Federal Aviation Administration (FAA) has issued Airworthiness Directive AD 2023-13-11. This airworthiness directive references Revision 3 of this SB, and for this reason, Revision 3 is now included for reference along with Revision 4 of this SB.

NOTE

This revision expands the containment period as detailed below:

- By five months, from October 2017 to May 2017 for PNs 89794077 & 89794015,
- By six months from October 2017 to April 2017 for PN 891511-14 and
- Adds, additional serial number for the period of January 2018 to November 2018 for PN 89794050.

VSB SUMMARY

Revision Changes are indicated by revision bars on the left side of the page. This revision includes changes / additions to the following paragraphs:

Highlights 1: Updated revision information.

Highlights 2: Added.

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- Page 1: Paragraph 1.A.(2), Updated MFG Dates and added PN 89794050.
- Page 2: Paragraph 1.E., revised Compliance statement.
- Page 3: Paragraph 1.K., Updated with applicable EASA and FAA AD numbers and PN.
- Page 4: Paragraph 2.B, Deleted "repair station" concept.
- Page 5: Paragraph 3. NOTE, updated appendix references.
Paragraph 3., Added new NOTE related to Appendix 3.
Paragraph 3.C.(1), updated appendix references.
Paragraph 3.C.(1), graphic, updated to show all appendices.
- Page 14: Paragraph 4., added NOTE regarding changes to Appendices.
Paragraph 4.A., updated appendix references.
Paragraph 4.A., Added appendix 3 and updated the SB revision number from "R3" to "R4".
Paragraph 4.A., Paragraph 4.A. graphic, updated to show all appendices.
Paragraph 4.B., changed "Appendix 3" to "Appendix 4".

Appendix 3 (attachment): Added to include PNs 89794077, 89794015 manufactured from May, 2017 through November 2018, and PN 891511-14 manufactured from April 2017 through Nov 2018, PN 89794050 manufactured from May 2017 to Nov 2018.

REVISION HISTORY

Original Release:	Mar 06/2019
Rev 01	Jul 09/2019
Rev 02	Oct 16/2019
Rev 03	Jun 07/2021
Rev 04	Nov 09/2023

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SERVICE BULLETIN

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SUBJECT: OXYGEN – CYLINDER – POSSIBLE MISSING COMPONENT ON OXYGEN CYLINDER VALVE ASSEMBLY

1. Planning Information

A. Effectivity

- (1) This SB applies to the following cylinder and valve assemblies installed on Airbus aircraft and held in stores as well as spares. The attached “Affected Shipments” appendices provide lists of potentially affected part numbers, serial numbers, and delivery information.
- (2) The table below provides part numbers, CMMs and MFG Dates.

PN	Description	CMM	MFG Date
89794077	Cylinder and Valve Assembly	35-21-93	May 2017 - Nov 2018
89794015	Cylinder and Valve Assembly	35-21-93	May 2017 - Nov 2018
891511-14	Cylinder and Valve Assembly	35-28-91	Apr 2017 - Nov 2018
89794050	Cylinder and Valve Assembly	35-21-93	May 2017 - Nov 2018

B. Concurrent Requirements

None

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C. Reason

Multiple instances have been reported and confirmed of a cylinder & valve with oxygen leakage from the valve assembly vent hole.

During the tear down analysis of the valve assemblies it was revealed that guide part number 10015804 was not assembled onto the stem part number 10017384. The absence of the guide creates a situation that increases the probability of significant oxygen leakage through the vent hole. This leakage will result in depletion of the oxygen cylinder and may create an oxygen enriched environment.

NOTE: The valve body vent hole is not in the normal oxygen flow path.

D. Description

This service bulletin provides instructions to inspect the cylinder & valve.

If the cylinder & valve assembly fails the inspection criteria, it should be returned to AVOX Systems for disposition.

If the cylinder & valve assembly passes the inspection, it should be identified by a blue paint dot on the valve assembly to show the SB has been accomplished. (Refer to Figure 7)

E. Compliance

Mandatory - Service Bulletin must be accomplished

The Equipment Airworthiness Directive (AD) FAA AD 2023-13-11 issued on 2023-08-11 and adopted by EASA, mandates compliance with this Service Bulletin.

Further to the FAA equipment AD issuance, the Airworthiness Directive (AD) EASA AD 2021-0180-CN issued on 05 Sep 2023 cancelled the existing EASA AD 2021-0180R2 issued on 29 Aug 2022.

F. Approval

The inspection procedures described in this SB are reviewed and technically accepted by Airbus to apply to the Airbus fleet affected.

This SB does not contain any change information that revises the equipment definition covered by Airbus approved modifications.

G. Manpower

Approximately 0.05 man-hour for inspection of each cylinder & valve assembly or body & gage assembly is required.

H. Weight and Balance

Not Changed

I. Electrical Load Data

Not Changed

J. Software Accomplishment Summary

None

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K. References

EASA AD 2021-0180R2

EASA AD 2021-0180-CN

FAA AD 2023-13-11

Airbus Alert Operators Transmission:

- AOT A35W014-19 (A300/A310)
- AOT A35L013-19 (A330/A340)
- AOT A35N012-19 (A318 thru A321)

Avox Systems Inc. Component Maintenance Manuals

- CMM 35-21-93 for PN 89794077, 89794050 and PN 89794015
- CMM 35-28-91 for PN 891511-14

L. Publications Affected

Avox Systems Inc. Component Maintenance Manuals 35-28-91 and 35-21-93 will be revised to incorporate the intent of this service bulletin.

M. Interchangeability

Not Applicable

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2. Material Information

A. Material - Price and Availability

None

B. Industry Support Information

Contact sao.avx.customerservice@safrangroup.com to return units that fail inspection and to report the results of units that pass inspection.

Contact tech-support.sao@safrangroup.com for technical inquiries.

Units that fail the inspection process in this service bulletin are to be returned to Safran Aerosystems.

- If the inspection rejection is confirmed, a FOC replacement will be provided.
- If the inspection rejection is not confirmed, the unit may be subject to no-fault-found (NFF) fees.

C. List of Components

Oil-based, blue paint permanent marker of local supply.

D. Subcomponents to be Reidentified

Inspected and acceptable cylinder & valve assembly will be identified with a blue paint dot on the valve assembly.

E. Tooling

Standard shop tools may be required.

F. Special Tools

Pin gauge 0.079" or 2mm Ø required to accomplish this inspection.

Pin vise to accommodate 0.079" or 2mm inspection pin. (Optional)

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3. Accomplishment Instructions

NOTE: See Appendix 1 thru 3 for Affected Serial Numbers.
Inspect only serial numbers found in the Appendix 1 thru 3 “Affected Shipments” lists.

NOTE: Appendix 1 has not been changed since the initial release of this SB.

NOTE: Appendix 2 was added with revision 3 to this SB. If you have applied Appendix 1 previously, only inspect serial numbers on Appendix 2.

NOTE: Appendix 3 was added at revision 4 to this SB, if you have applied appendix 1 and 2 previously, only inspect serial numbers in Appendix 3.

A. General

Inspection of the cylinder & valve assembly may be performed while the unit is in-service or removed from the aircraft.

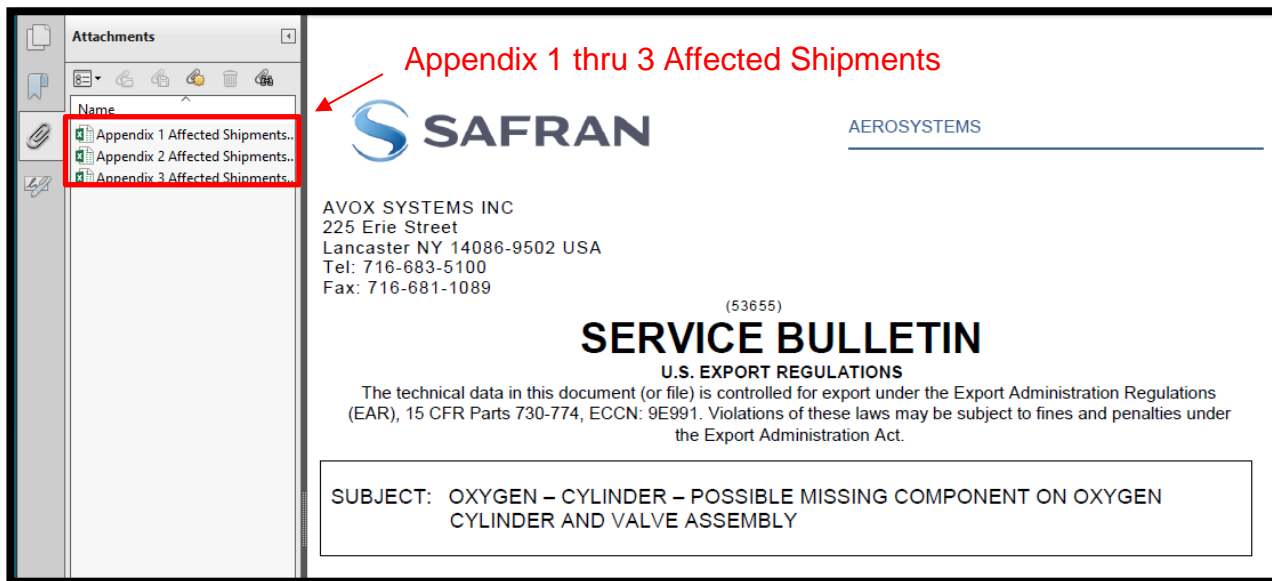
B. Preparation

A Pin gauge 0.079” or 2mm Ø is required to accomplish this inspection.

C. Procedure.

(1) Verify the Serial Number is listed in the Affected Shipments list.

NOTE: See Appendix 1 thru 3 “Affected Shipments” for lists of serial numbers.



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- (a) Check if unit is marked with a blue paint dot. If the unit is marked with a blue paint dot, the unit has already been inspected per this SB. (Refer to Figure 7 for blue paint dot location.)
 - (b) If the unit is not marked with a blue paint dot, or, if a doubt exists that the inspection was performed on the unit, proceed with step (2).
- (2) Gain access to the cylinder & valve assembly.
Figures 1 through 6 show the inspection location on the cylinder & valve assembly



FIGURE 1
OVERVIEW OF CYLINDER AND VALVE ASSEMBLY

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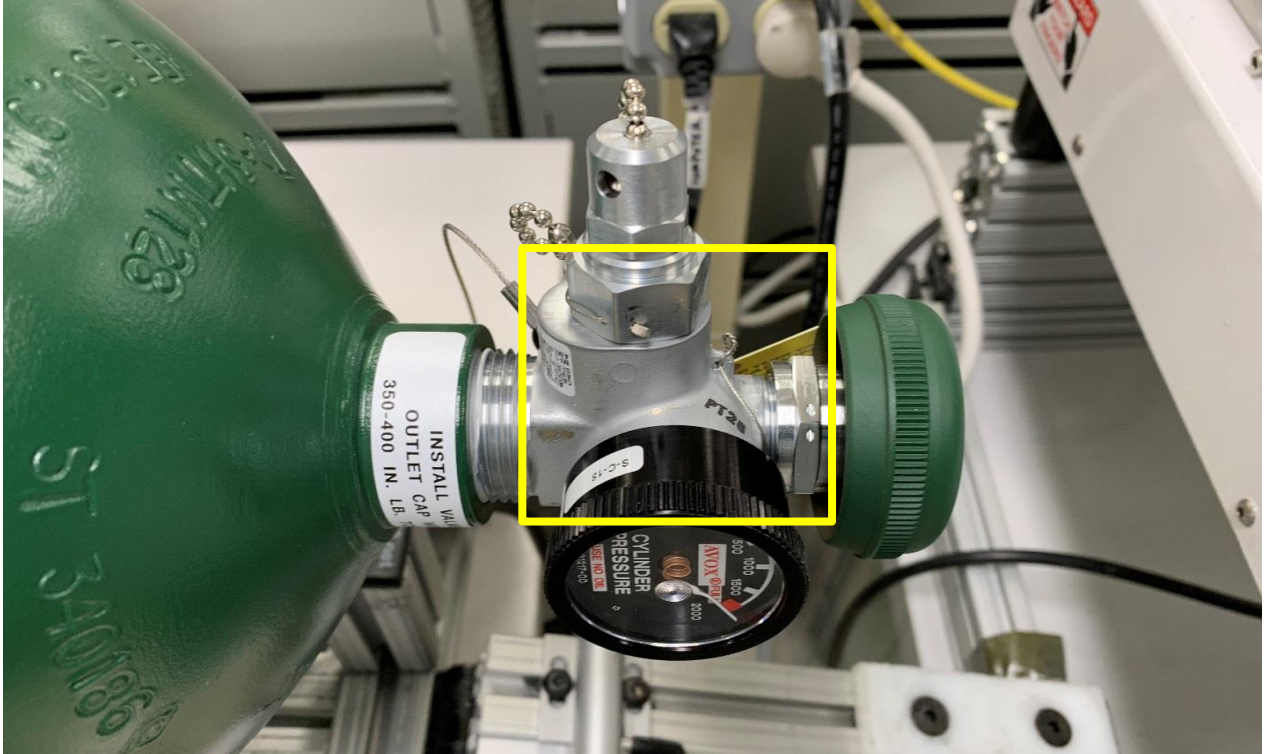
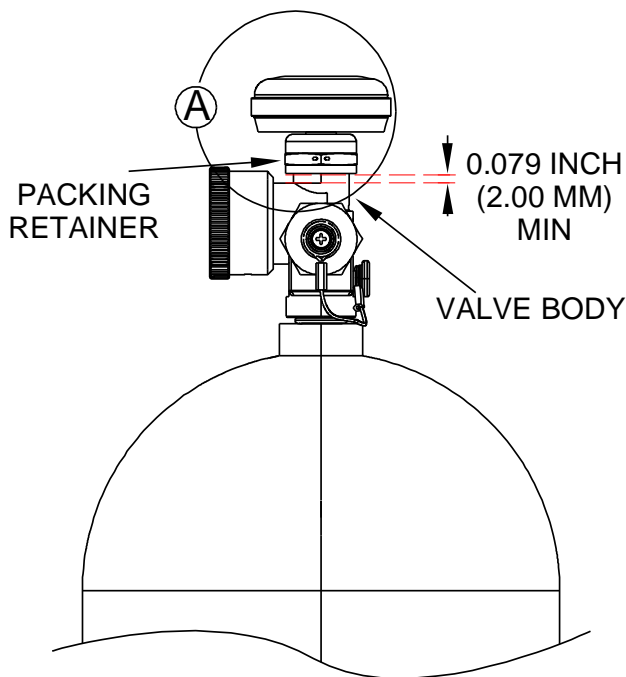


FIGURE 2
CLOSE-UP OF VALVE ASSEMBLY

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FIGURE 3
CLOSE-UP ILLUSTRATION OF VALVE ASSEMBLY, PIN GAUGE MUST BE INSERTED BETWEEN THE
BOTTOM OF THE PACKING RETAINER AND FLAT SURFACE OF THE VALVE BODY ABOVE THE
PRESSURE GAUGE

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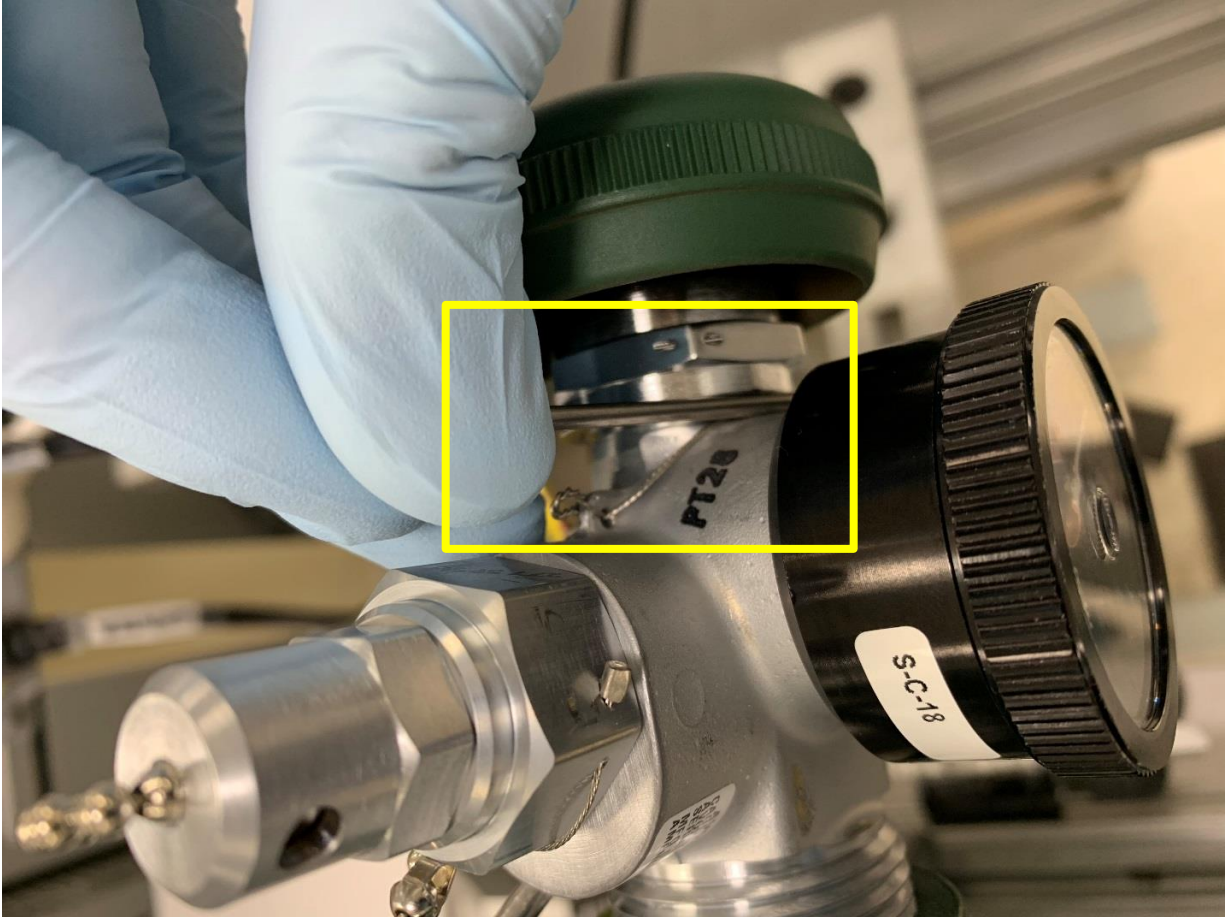


FIGURE 4
CLOSE-UP OF INSPECTION PROCEDURE LOCATION ON VALVE ASSEMBLY

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- (3) Perform the following inspection procedure on the cylinder and valve assembly.
- (a) Use a pin gauge, 0.079" or 2mm Ø, to determine if the cylinder and valve assembly meets the criteria for an acceptable unit.
- NOTE:** The inspection criteria is applicable for all valve assembly configurations
- NOTE:** It may be necessary to move safety cable to facilitate inspection
- (b) Slide the pin gauge between the bottom of the packing retainer and the top of the valve body above where the pressure gauge is mounted.
- NOTE:** Failure to perform the inspection in exactly the location depicted may result in rejection of conforming product.
- (c) Perform visual inspection comparing the "Acceptable" or "Unacceptable" of the pin gauge.
- (Refer to Figure 5 for identification of acceptable cylinder and valve assembly)
 (Refer to Figure 6 for identification of unacceptable cylinder and valve assembly)

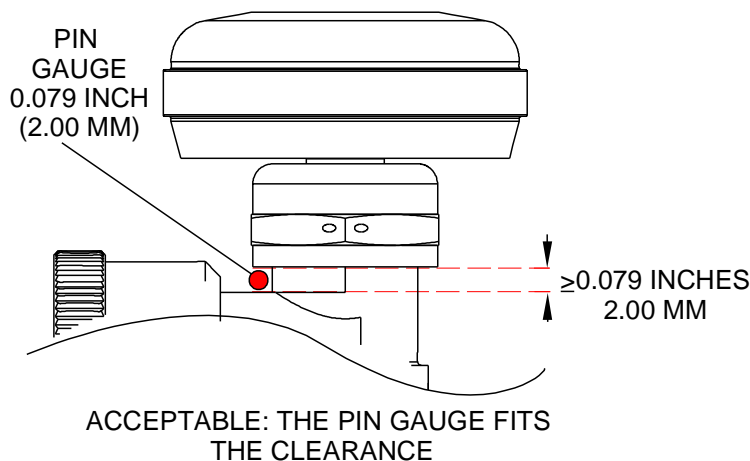
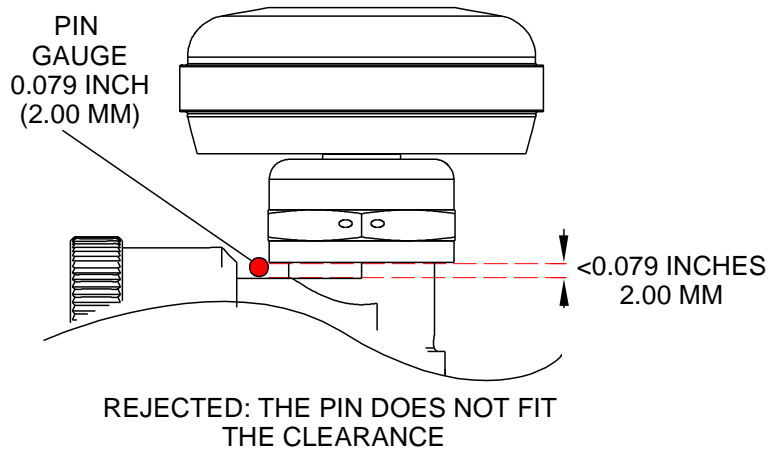


FIGURE 5

ACCEPTABLE ILLUSTRATION TO SHOW CLEARANCE BETWEEN PACKING RETAINER AND VALVE BODY

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FIGURE 6
REJECTED VALVE ASSEMBLY

- (4) If cylinder and valve assembly is identified as "Acceptable", the cylinder and valve assembly may remain or can be used in service.
- D. Re-identification of equipment
- (1) Physically identify the acceptable cylinders after inspection by using an oil-based, blue paint permanent marker of local supply, to mark the valve with a blue paint dot as shown in Figure 7.

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FIGURE 7
MARK ACCEPTABLE Cylinder & Valve Assembly (CVA) WITH A BLUE PAINT DOT

- (a) Please fill out the report form in Appendix 4 and send a copy to sao.avx.customerservice@safrangroup.com.

WARNING: DO NOT OPEN OR CLOSE THE VALVE HANDLE IF A CVA IS REJECTED BASED ON THE INSPECTION. A CVA THAT IS IDENTIFIED AS UNACCEPTABLE AND IS PRESSURIZED CAN CAUSE SERIOUS INJURY TO PERSONNEL.

- (2) If CVA is installed on an aircraft with the valve in the open position, and it is identified as "Unacceptable" (the gap is too small to accommodate the pin gauge), do the following steps:
- Follow aircraft manufacturer's documentation to completely bleed down the CVA through the appropriate aircraft systems.
 - Close the Valve Assembly.
 - Remove the CVA from service.
 - Clearly identify the CVA as non-conforming product / not-for-service.
 - Package CVA.

NOTE: Alternate reaction plans may be advised at the discretion of the aircraft OEM based on additional system-level safety analysis.

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- (f) Contact (sao.avx.customerservice@safrangroup.com) for instructions for shipping cylinders.

WARNING: DO NOT OPEN OR CLOSE THE VALVE HANDLE IF A CVA IS REJECTED BASED ON THE INSPECTION. A CVA THAT IS IDENTIFIED AS UNACCEPTABLE AND IS PRESSURIZED CAN CAUSE SERIOUS INJURY TO PERSONNEL.

- (3) If CVA is installed on an aircraft or is in storage with the valve in the closed position and it is identified as “Unacceptable” (the gap is too small to accommodate the pin gauge) do the following steps:
- (a) Remove the cylinder and valve assembly from service (if applicable).
 - (b) Clearly identify the CVA as non-conforming product / not-for-service.
 - (c) Package cylinder and valve assembly securely in a box that is compliant with HM224B.
 - (d) Contact (sao.avx.customerservice@safrangroup.com) for instructions for shipping cylinders.
- E. Test
No Test is required after the inspection
- F. Close-up
None.

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4. Appendix

NOTE: Appendix 1 has not been changed since the initial release of this SB. Appendix 2 was added with revision 3 of this SB.

NOTE: Appendix 2 has not been changed since revision 3 of this SB. Appendix 3 was added with revision 4 of this SB.

A. Appendix 1 thru 3 - Excel files with the suspect SN lists.

“Appendix 1 Affected Shipments 10015804-35-01 R4.xlsx”

“Appendix 2 Affected Shipments 10015804-35-01 R4.xlsx”

“Appendix 3 Affected Shipments 10015804-35-01 R4.xlsx”

Appendix 1 thru 3 Affected Shipments

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SUBJECT: OXYGEN – CYLINDER – POSSIBLE MISSING COMPONENT ON OXYGEN CYLINDER AND VALVE ASSEMBLY

B. Appendix 4 – Inspection Form. (See page 15)

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INSPECTION OF MISSING GUIDE FROM CYLINDER AND VALVE ASSEMBLY FORM

Company Name:	Email:
	Phone:
Service Bulletin Number: 10015804-35-01	Date:
Company Address:	

CYLINDER & VALVE ASSY PART NUMBER:	CYLINDER & VALVE ASSY SERIAL NO:	VALVE ASSY PART NUMBER	VALVE ASSY SERIAL NUMBER	MANUFACTURE DATE:	ACCEPTABLE: (YES/NO)

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