PART 6 - EDDY CURRENT

WING - NACELLE/PYLON ATTACH FITTINGS

1. Purpose

A. To find surface cracks in the holes of the inboard and outboard pitch load and side load fittings. These fittings are identified in service bulletins 767-54-0080 thru -0082, 767-57-0053 and 767-57-0063. Figure 1 shows the fitting locations.

B. It is necessary to remove the pin and the bushing to do this inspection.

C. Service Bulletin references: 767-54-0080, 767-54-0081, 767-54-0082, 767-57-0053, 767-57-0063

2. Equipment

A. General

(1) Refer to Part 1, 51-01-00 for data about the equipment manufacturers.

B. Instrument

(1) Refer to Part 1, 51-06-00 for instrument data.

(2) A rotary scanner instrument is necessary to do this procedure.

(3) The instruments that follow were used to help prepare this procedure:

(a) Phasec 2200, Hocking Krautkramer

(b) Phasec 1.1, Hocking Krautkramer

(c) Elotest B1, Rohmann

C. Probe

(1) Three adjustable diameter, rotating probes are used in this procedure.

(2) Table 1 identifies the probes that are necessary to examine the different fittings.

(3) The probes specified below were used to help prepare this procedure:

(a) Part Number BXU 128/136 - NDT Engineering Corp.

(b) Part Number BXU 136/144 - NDT Engineering Corp.

(c) Part Number BXU 144/152 - NDT Engineering Corp.

NOTE: The above part numbers are for Hocking and Elotest rotary scanners. Tell the probe manufacturer if you make a decision to use equipment that is different than that specified above.

D. Reference Standard - Make reference standards NDT650 and NDT651 as shown in Figure 2 and Figure 3.

NOTE: Table 1 identifies the reference standards that are necessary to use to examine the different fittings.

Table 1 Probes and Reference Standards

FITTING NAME	PART NUMBER	HOLE DIA. (MIN) *[1]	HOLE DIA. (MAX) *[1]	PROBE NUMBER	REFERENCE STANDARD
Pitch Load O/B Front Spar	112T7006-( )	2.1521 (54.663)	2.2565 (57.315)	BXU-136/144	NDT651
Pitch Load I/B Front Spar	112T7007-( )	2.1521 (54.663)	2.2565 (57.315)	BXU-136/144	NDT651

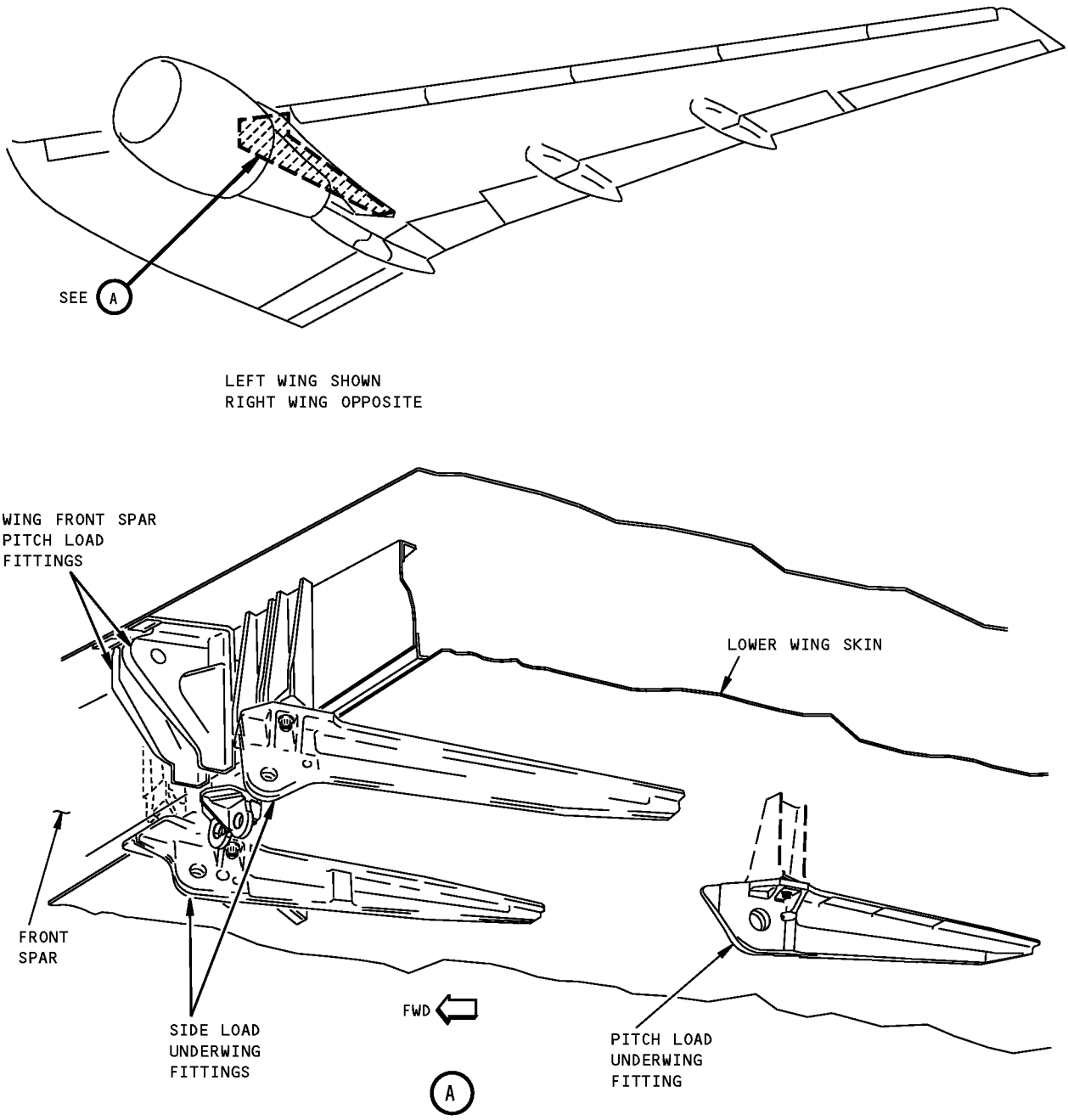
(Continued)

FITTING NAME	PART NUMBER	HOLE DIA. (MIN) *[1]	HOLE DIA. (MAX) *[1]	PROBE NUMBER	REFERENCE STANDARD
Pitch Load under/wing	112T7005-( )	2.2981 (58.369)	2.3990 (60.934)	BXU-144/152	NDT651
Side Load O/B under/ wing	112T7003-( )	2.0822 (52.887)	2.1810 (55.577)	BXU-128/136	NDT650
Side Load I/B under/ wing	112T7004-( )	2.0822 (52.887)	2.1810 (55.577)	BXU-128/136	NDT650

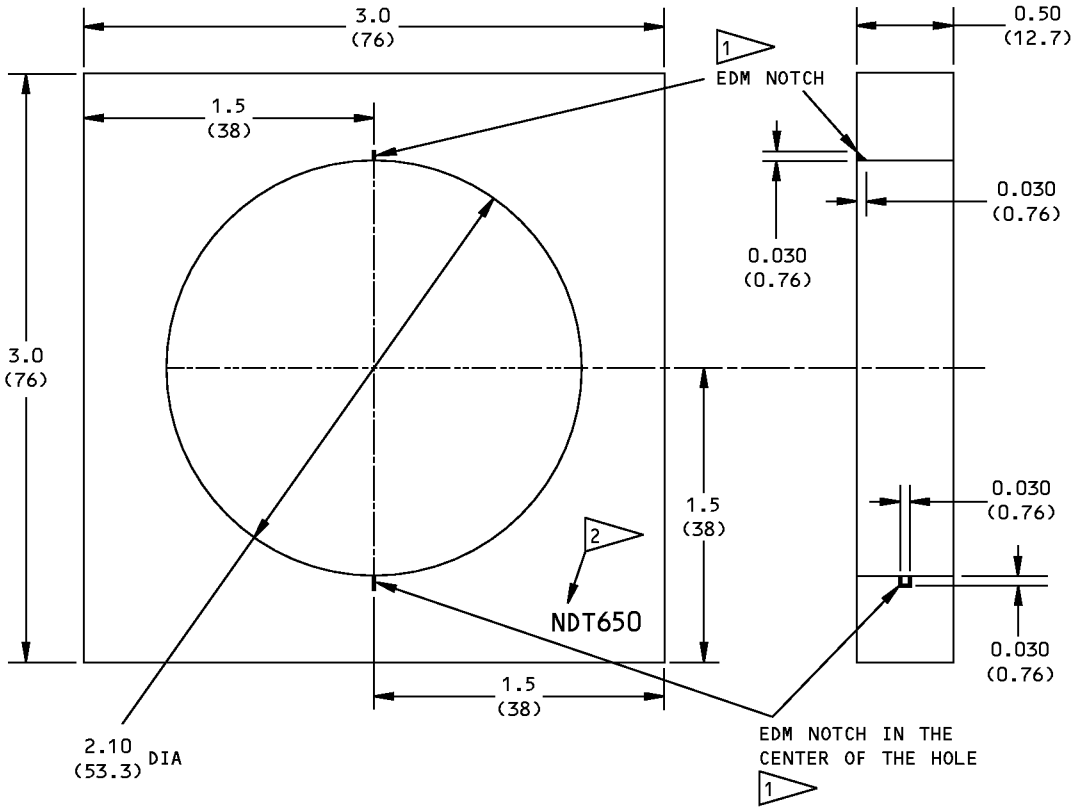
*[1] DIMENSIONS ARE IN INCHES. (MILLIMETERS ARE IN PARENTHESES).

3. **Preparation for Inspection**
   A. Get access to the inspection area and make sure the pins and the bushings are removed from the fittings.
   B. Make sure the holes in the fittings are clean and free from grease and dirt.
   C. For most of the fittings, you can only access the holes with a rotary scanner from one side. Remove clamps and move the electrical or hydraulic lines, if necessary, to get access.
   D. Measure the diameter of the hole to be examined and refer to Table 1 to make sure the correct probe and reference standard are used.
4. **Instrument Calibration**
   A. Refer to Table 1 to identify the probe and the reference standard to use for the fitting to be examined.
   B. Set the instrument frequency to 300 kHz.
   C. Calibrate the equipment as specified in Part 6, 51-00-16.

      NOTE: You must get a satisfactory crack signal from the two notches in the reference standard as shown in Fig. 5, 6 and 7 of Part 6, 51-00-16.
5. **Inspection Procedure**
   A. Examine the holes of the pitch load and the side load fittings Figure 1 for cracks as specified in Part 6, 51-00-16.
      (1) If a cleanup ream is necessary, get approval from your engineering personnel.
6. **Inspection Results**
   A. Refer to Part 6, 51-00-16 for instructions that will help to make an analysis of the inspection results.
   B. Fastener holes must be rejected if they cause crack signals to occur that are 50% or more of the crack signal from the reference standard.



Inspection Location
Figure 1



NOTES

- ALL DIMENSIONS ARE IN INCHES (MILLIMETERS ARE IN PARENTHESES)
- TOLERANCE (UNLESS SPECIFIED DIFFERENTLY):

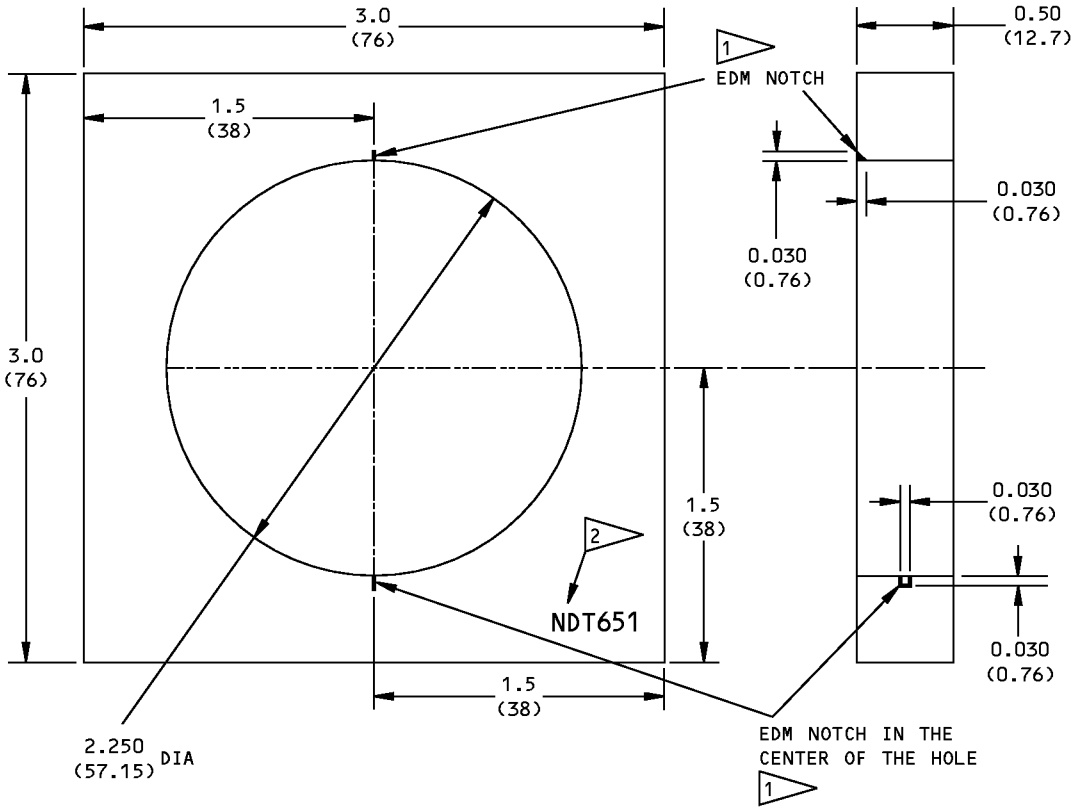
INCHES	MILLIMETERS
X.XXX = ± 0.005	X.XX = ± 0.10
X.XX = ± 0.025	X.X = ± 0.5
X.X = ± 0.050	X = ± 1

- MATERIAL: ALUMINUM 7075-T6 OR EQUIVALENT

1 THE MAXIMUM EDM NOTCH WIDTH IS 0.005 (0.13)

2 ETCH OR STEEL STAMP THE REFERENCE STANDARD NUMBER NDT650 AT APPROXIMATELY THIS LOCATION

Reference Standard NDT650
Figure 2



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X.XX = ± 0.025	X.X = ± 0.5
X.X = ± 0.050	X = ± 1

- MATERIAL: ALUMINUM 7075-T6 OR EQUIVALENT

1 THE MAXIMUM EDM NOTCH WIDTH IS 0.005 (0.13)

2 ETCH OR STEEL STAMP THE REFERENCE STANDARD NUMBER NDT651 AT APPROXIMATELY THIS LOCATION

Reference Standard NDT651
Figure 3