



STANDARD OVERHAUL PRACTICES MANUAL

HOW TO APPLY TAMPER-PROOF PUTTY

**PART NUMBER
NONE**

BOEING PROPRIETARY, CONFIDENTIAL, AND/OR TRADE SECRET

Copyright © 1995 The Boeing Company
Unpublished Work - All Rights Reserved

Boeing claims copyright in each page of this document only to the extent that the page contains copyrightable subject matter. Boeing also claims copyright in this document as a compilation and/or collective work.

This document includes proprietary information owned by The Boeing Company and/or one or more third parties. Treatment of the document and the information it contains is governed by contract with Boeing. For more information, contact The Boeing Company, P.O. Box 3707, Seattle, Washington 98124.

Boeing, the Boeing signature, the Boeing symbol, 707, 717, 727, 737, 747, 757, 767, 777, 787, Dreamliner, BBJ, DC-8, DC-9, DC-10, KC-10, KDC-10, MD-10, MD-11, MD-80, MD-88, MD-90, P-8A, Poseidon and the Boeing livery are all trademarks owned by The Boeing Company; and no trademark license is granted in connection with this document unless provided in writing by Boeing.

PUBLISHED BY BOEING COMMERCIAL AIRPLANES GROUP, SEATTLE, WASHINGTON, USA
A DIVISION OF THE BOEING COMPANY
PAGE DATE: Jul 01/2009

20-50-26

Page 1
Jul 01/2009



STANDARD OVERHAUL PRACTICES MANUAL

Revision No. 1
Jul 01/2009

To: All holders of HOW TO APPLY TAMPER-PROOF PUTTY 20-50-26.

Attached is the current revision to this STANDARD OVERHAUL PRACTICES MANUAL

The STANDARD OVERHAUL PRACTICES MANUAL is furnished either as a printed manual, on microfilm, or digital products, or any combination of the three. This revision replaces all previous microfilm cartridges or digital products. All microfilm and digital products are reissued with all obsolete data deleted and all updated pages added.

For printed manuals, changes are indicated on the List of Effective Pages (LEP). The pages which are revised will be identified on the LEP by an R (Revised), A (Added), O (Overflow, i.e. changes to the document structure and/or page layout), or D (Deleted). Each page in the LEP is identified by Chapter-Section-Subject number, page number and page date.

Pages replaced or made obsolete by this revision should be removed and destroyed.

ATTENTION

IF YOU RECEIVE PRINTED REVISIONS, PLEASE VERIFY THAT YOU HAVE RECEIVED AND FILED THE PREVIOUS REVISION. BOEING MUST BE NOTIFIED WITHIN 30 DAYS IF YOU HAVE NOT RECEIVED THE PREVIOUS REVISION. REQUESTS FOR REVISIONS OTHER THAN THE PREVIOUS REVISION WILL REQUIRE A COMPLETE MANUAL REPRINT SUBJECT TO REPRINT CHARGES SHOWN IN THE DATA AND SERVICES CATALOG.

20-50-26

TRANSMITTAL LETTER

Page 1

Jul 01/2009

PART NUMBER NONE



STANDARD OVERHAUL PRACTICES MANUAL

Location of Change

Description of Change

NO HIGHLIGHTS

20-50-26

HIGHLIGHTS

Page 1

Jul 01/2009



STANDARD OVERHAUL PRACTICES MANUAL

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
TITLE PAGE					
O 1	Jul 01/2009				
2	BLANK				
20-50-26 TRANSMITTAL LETTER					
O 1	Jul 01/2009				
2	BLANK				
20-50-26 HIGHLIGHTS					
O 1	Jul 01/2009				
2	BLANK				
20-50-26 EFFECTIVE PAGES					
1	Jul 01/2009				
2	BLANK				
20-50-26 CONTENTS					
1	Mar 01/2009				
2	BLANK				
20-50-26 REVISION RECORD					
1	Mar 01/2009				
2	Mar 01/2009				
20-50-26 RECORD OF TEMPORARY REVISIONS					
1	Mar 01/2009				
2	Mar 01/2009				
20-50-26 INTRODUCTION					
1	Mar 01/2009				
2	BLANK				
20-50-26 SUBJECT					
1	Mar 01/2009				
2	Mar 01/2009				
3	Mar 01/2009				
4	BLANK				

A = Added, R = Revised, D = Deleted, O = Overflow

20-50-26

EFFECTIVE PAGES

Page 1

Jul 01/2009



STANDARD OVERHAUL PRACTICES MANUAL

TABLE OF CONTENTS

<u>Paragraph Title</u>	<u>Page</u>
HOW TO APPLY TAMPER-PROOF PUTTY	1
INTRODUCTION	1
BACKGROUND	1
APPLICATION	1

All revisions to this manual will be accompanied by transmittal sheet bearing the revision number. Enter the revision number in numerical order, together with the revision date, the date filed and the initials of the person filing.

[illegible]

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

[illegible]

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

When the temporary revision is incorporated or cancelled, and the pages are removed, enter the date the pages are removed and the initials of the person who removed the temporary revision.

[illegible]

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

[illegible]

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details



STANDARD OVERHAUL PRACTICES MANUAL

INTRODUCTION

1. General

- A. The instructions in this manual tell how to do standard shop procedures during maintenance functions from simple checks and replacement to complete shop-type repair.
- B. This manual is divided into separate sections:
 - (1) Title Page
 - (2) Transmittal Letter
 - (3) Highlights
 - (4) Effective Pages
 - (5) Contents
 - (6) Revision Record
 - (7) Record of Temporary Revisions
 - (8) Introduction
 - (9) Procedures
- C. Refer to SOPM 20-00-00 for a definition of standard industry practices, vendor names and addresses, and an explanation of the True Position Dimensioning symbols used.
- D. The data is general. It is not about all situations or specific installations. Use it as a guide to help you write minimum standards.
- E. If the component overhaul instructions are different from the data in this subject, use the component overhaul instructions.

20-50-26

INTRODUCTION

Page 1

Mar 01/2009



STANDARD OVERHAUL PRACTICES MANUAL

HOW TO APPLY TAMPER-PROOF PUTTY

1. INTRODUCTION

- A. The data in this subject comes from Boeing Process Specification BAC5459. The airline has a copy of the Boeing Process Specification Manual.
- B. The data is general. It is not about all situations or specific installations. Use this data to help you write minimum requirements.
- C. Refer to SOPM 20-00-00 for a list of all the vendor names and addresses.

2. BACKGROUND

- A. Tamper-proof putty is applied to some assembled parts to prevent adjustment or disassembly of the sealed component unless the putty is broken.
- B. The component overhaul instructions will tell you when and where to use this putty.
- C. To show that an approved person applied the putty, you can apply an inspector's stamp to the putty.

3. APPLICATION

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00226	Compound - Tamper-Proof Putty	BMS8-45
B00083	Solvent - Aliphatic Naphtha (For Acrylic Plastics)	TT-N-95 Type II, ASTM D-3735 Type III
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B00316	Solvent - Aliphatic Naphtha (For Organic Coatings)	TT-N-95 Type I, ASTM D-3735 Type I

- B. References

Reference	Title
SOPM 20-60-01	CLEANING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure

NOTE: For cleaning materials, refer to SOPM 20-60-01. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Clean the surfaces, and remove all dirt and grease, with aliphatic naphtha (solvent, B00083 or solvent, B00316).
- (2) Mix the putty (compound, A00226), if necessary.
- (3) Apply the putty to a minimum thickness of 0.02 inch. Apply the putty to prevent disconnection, adjustment or disassembly of the joint or component unless this will break the putty. Examples are shown in Figure 1.
- (4) Let the putty air dry for a minimum of 20 seconds before you apply an inspector's stamp to the surface of the putty.

20-50-26

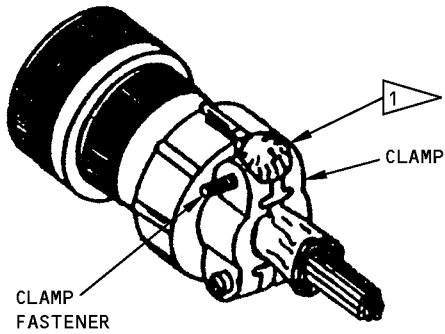


STANDARD OVERHAUL PRACTICES MANUAL

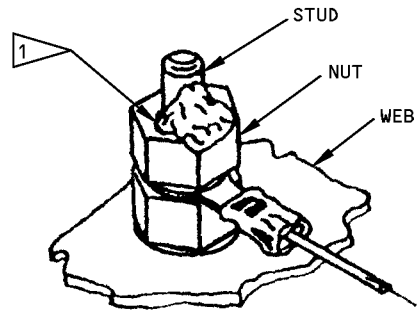
- (5) Remove unwanted putty with methyl ethyl ketone (solvent, B00148).

20-50-26

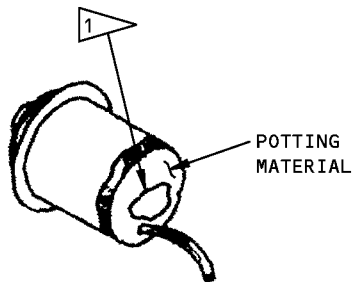
STANDARD OVERHAUL PRACTICES MANUAL



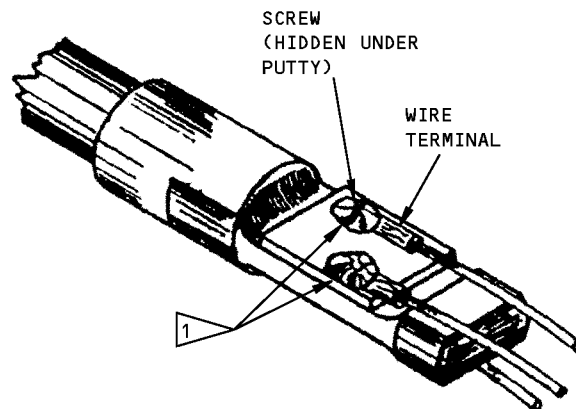
CONNECTOR




STUD AND LOCK NUT



POTTED COMPONENT



SCREW AND TERMINAL

 TAMPER-PROOF PUTTY

1737836 S0000314162_V1

Typical Tamper-Proof Putty Applications
Figure 1

20-50-26