ROUTINE

DEPARTMENT OF THE ARMY TECHNICAL BULLETIN

ANNOUNCEMENT OF APPROVAL AND RELEASE OF NONDESTRUCTIVE TEST EQUIPMENT INSPECTION PROCEDURE MANUAL

TM 1-1520-256-23, TECHNICAL MANUAL AVIATION UNIT MAINTENANCE (AVUM) AND AVIATION INTERMEDIATE MAINTENANCE (AVIM) MANUAL NONDESTRUCTIVE INSPECTION PROCEDURES FOR UH-1 HELICOPTER SERIES

Headquarters, Department of the Army, Washington, D. C.
1 May 1997

NOTE

THIS PUBLICATION IS EFFECTIVE UNTIL REFERENCES TO TM 1-1520-256-23, TECHNICAL MANUAL AVIATION UNIT MAINTENANCE (AVUM) AND AVIATION INTERMEDIATE MAINTENANCE (AVIM) MANUAL NONDESTRUCTIVE INSPECTION PROCEDURES FOR UH-1 HELICOPTER SERIES, HAVE BEEN INCORPORATED INTO THE TM 55-1520-210-23 (SERIES), AVIATION UNIT AND INTERMEDIATE MAINTENANCE INSTRUCTIONS ARMY MODEL UH-1 H/V/EH-1 H/X HELICOPTERS.

1. Priority Classification. Routine

2. Purpose. The purpose of this technical; bulletin (TB) is to announce the approval and release of the nondestructive test equipment inspection procedure manual, TM 1-1520-256-23, Technical Manual Aviation Unit Maintenance (AVUM) and Aviation Intermediate Maintenance (AVIM) Manual Nondestructive Inspection Procedures for UH-1 Helicopter Series. This manual shall be referred to when performing inspections on the UH-1 aircraft.

3. Description. Approved nondestructive test inspection procedures are referenced in Table 1. Refer to TM 1-1520-256-23, Technical Manual Aviation Unit Maintenance (AVUM) and Aviation Intermediate Maintenance (AVIM) Manual Nondestructive Inspection Procedures for UH-1 Helicopter Series, for safety information, part locations, inspection method descriptions, and complete procedures. Do not attempt to perform any nondestructive test inspection without first referring to TM 1-1520-256-23 as this TB does not provide adequate information to properly perform the inspections.

4. How to Use. The columns in Table 1. Approved Nondestructive Test Inspection Components/Assemblies are defined as follows:

(1) Procedure Number: references the procedure number in TM 1-1520-256-23, Technical Manual Aviation Unit Maintenance (AVUM) and Aviation Intermediate Maintenance (AVIM) Manual Nondestructive Inspection Procedures for UH-1 Helicopter Series.
(2) Component/Assembly: provides the list of parts approved for nondestructive test inspections on the UH-1 aircraft. Parts not listed have not been approved for nondestructive test inspection and shall be inspected as referenced in TM 55-1520-210-23 (Series), Aviation Unit and Intermediate Maintenance Instructions Army Model UH-1 H/V/EH-1 H/X Helicopters.
(3) Inspect For: provides the approved manner of inspection. All other types of inspection shall be performed as referenced in TM 55-1520-210-23 (Series), Aviation Unit and Intermediate Maintenance Instructions Army Model UH-1 H/V/EH-1 H/X Helicopters.
(4) Maintenance Category: details the approved maintenance level for each nondestructive test inspection.
(5) Inspection Equipment Requirements: provides the approved nondestructive inspection method/equipment to perform the inspection. Refer to Notes for the legend.
(6) Remarks: provides the approved backup method/equipment to perform the inspection. Refer to Notes for the legend.

NOTE

Legend for the nondestructive inspection methods/equipment referenced in columns (5) and (6):

001	Fluorescent Penetrant Method	004	Ultrasonic Method
002	Magnetic Particle Method	005	Bond Testing Method
003	Eddy Current Method	006	Radiographic Method

Table 1. Approved Nondestructive Test Inspection Components/Assemblies.

(1) PROCEDURE NUMBER	(2) COMPONENT/ASSEMBLY	(3) INSPECT FOR	(4) MAINTENANCE CATEGORY			(5) INSPECTION EQUIPMENT REQUIREMENT	(6) REMARKS
			AVUM	AVIM	DEPOT		
2.2	Main Rotor Hub Grip	Cracks		√		003	
2.3	Main Rotor Hub Pillow Block	Cracks		√		003	
2.4	Main Rotor Pitch Horn	Cracks		√		003	
2.5	Main Rotor Drag Brace Assembly	Cracks		√		002	
2.6	Main Rotor Blade Bolt	Cracks		√		002	
2.7	Main Rotor Hub Plate Assembly	Cracks		√		003	
2.8	Grip Retention Nut	Cracks		√		002	
2.9	Main Rotor Hub Shield Assembly	Cracks		√		002	
2.10	Yoke	Cracks		√		002	
2.11	Trunnion	Cracks		√		002	
2.12	Strap Fitting	Cracks		√		002	
2.13	Main Rotor Blade (Metal)	Cracks		√		003	
2.14	Main Rotor Blade (Metal)	Voids		√		005	
2.15	Main Rotor Blade (Metal)	Water		√		006	
2.16	Composite Main Rotor Blade	Voids		√		005	

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			AVUM	AVIM	DEPOT		
2.17	Stabilizer Bar Center Frame	Cracks		√		003	Backup 001
2.18	Stabilizer Bar Support	Cracks		√		003	Backup 001
2.19	Stabilizer Bar Lever	Cracks		√		003	Backup 001
2.20	Stabilizer Bar Tube Assembly	Cracks		√		002	
2.21	Damper Lever Arms	Cracks		√		003	
2.22	Rotor Mast Adapter Set	Cracks		√		003	
2.23	Damper Wingshaft Splines	Cracks		√		002	
2.24	Swashplate Inner Ring	Cracks		√		003	
2.25	Swashplate Outer Ring	Cracks		√		003	
2.26	Support Assembly	Cracks		√		003	
2.27	Collective Levers	Cracks		√		003	Backup 001
2.28	Scissors Assembly	Cracks		√		003	Backup 001
2.29	Drive Link	Cracks		√		003	Backup 001
2.30	Collective Sleeve Assembly	Cracks		√		002	
2.31	Nut, Retainer	Cracks		√		002	Backup 001
2.32	Nut, Collective Sleeve Bearing Retention	Cracks		√		002	
2.33	Scissors and Sleeve Hub	Cracks		√		002	
2.34	Tail Rotor Hub Grip Assembly	Cracks		√		003	Backup 001
2.35	Tail Rotor Hub Retainer Nut	Cracks		√		002	
2.36	Tail Rotor Hub Retainer Ring	Cracks		√		001	
2.37	Adapter Nut	Cracks		√		002	
2.38	Tail Rotor Hub Yoke	Cracks		√		002	
2.39	Tail Rotor Hub Trunnion	Cracks		√		002	
2.40	Tail Rotor Crosshead	Cracks		√		003	Backup 001
2.41	Tail Rotor Blade	Cracks		√		003	

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			AVUM	AVIM	DEPOT		
2.42	Tail Rotor Blade	Voids		√		005	
2.43	Tail Rotor Blade	Water		√		006	
3.2	Main Driveshaft Inner Couplings	Cracks		√		002	
3.3	Main Driveshaft Outer Couplings	Cracks		√		002	
3.4	Main Driveshaft Splined Nuts	Cracks		√		002	
3.5	Main Driveshaft Clamp Sets	Cracks		√		002	
3.6	Main Driveshaft Grease Retainers	Cracks		√		001	
3.7	Main Driveshaft	Cracks		√		002	
3.8	Adapter Bolt	Cracks		√		002	
3.9	Main Driveshaft Engine Adapter	Cracks		√		002	
3.10	Transmission Case (Top)	Cracks		√		003	
3.11	Ring Gear Case	Cracks		√		002	
3.12	Main Transmission Case	Cracks		√		003	
3.13	Transmission Support Case	Cracks		√		003	
3.14	Lift Link Bushing Hole	Cracks		√		001	
3.15	Threaded Fittings	Cracks		√		001	
3.16	Input Drive Quill Wear Sleeve	Cracks		√		001	
3.17	Generator Drive Quill Case	Cracks		√		003	
3.18	Hydraulic Pump and Tachometer Quill Case	Cracks		√		003	
3.19	Hydraulic Pump and Tachometer Gear Teeth	Cracks		√		001	
3.20	Tail Rotor Drive Quill Sleeve Assembly	Cracks		√		003	

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(1) PROCEDURE NUMBER	(2) COMPONENT/ASSEMBLY	(3) INSPECT FOR	(4) MAINTENANCE CATEGORY			(5) INSPECTION EQUIPMENT REQUIREMENT	(6) REMARKS
			AVUM	AVIM	DEPOT		
3.21	Tail Rotor Drive Quill Bevel Gear Teeth	Cracks		√		002	
3.22	Tail Rotor Drive Quill Sleeve Spacer	Cracks		√		002	
3.23	Pylon Mount Bolts	Cracks		√		002	
3.24	Fifth Mount Support Fitting	Cracks		√		001	
3.25	Friction Damper	Cracks		√		002	
3.26	Main Rotor Mast Nut	Cracks		√		002	
3.27	Oil Pump Driveshaft	Cracks		√		002	
3.28	Oil Jets	Cracks		√		001	
3.29	Tail Rotor Driveshaft	Cracks		√		003	Backup 001
3.30	Tail Rotor Driveshaft Clamps	Cracks		√		002	
3.31	Tail Rotor Driveshaft Hangers	Cracks		√		002	Backup 001
3.32	Tail Rotor Driveshaft Inner (Spherical) Coupling	Cracks		√		002	
3.33	Tail Rotor Driveshaft Forward Coupling	Cracks		√		002	
3.34	Tail Rotor Driveshaft Rear Coupling	Cracks		√		002	
3.35	Tail Rotor Driveshaft Coupling Shaft	Cracks		√		002	
3.36	Tail Rotor Driveshaft Hanger Support Fittings	Cracks		√		003	
3.37	Intermediate Gearbox Case	Cracks		√		003	Backup 001
3.38	Intermediate Gearbox Inner Coupling	Cracks		√		002	
3.39	Intermediate Gearbox Outer Coupling	Cracks		√		002	
3.40	Intermediate Gearbox Sleeve	Cracks		√		002	
3.41	Intermediate Gearbox Pinion Shaft	Cracks		√		002	

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(1) PROCEDURE NUMBER	(2) COMPONENT/ASSEMBLY	(3) INSPECT FOR	(4) MAINTENANCE CATEGORY			(5) INSPECTION EQUIPMENT REQUIREMENT	(6) REMARKS
			AVUM	AVIM	DEPOT		
3.42	Tail Rotor Gearbox Case	Cracks		√		003	
3.43	Tail Rotor Gearbox Inner Coupling	Cracks		√		002	
3.44	Tail Rotor Gearbox Outer Coupling	Cracks		√		002	
3.45	Tail Rotor Gearbox Sleeve	Cracks		√		002	
3.46	Transmission Lift Link	Cracks		√		002	
4.2	Honeycombed Structures with Metallic Covering	Voids		√		005	
4.3	Honeycomb Structures with Non-Metallic Covering	Voids		√		005	
4.4	Forward Fuselage Metal Structures	Cracks		√		003	
4.5	Center Service Deck Panel	Voids		√		005	
4.6	Center Service Deck, Hanger Bearing Brace Assembly, and Main Beam Caps	Cracks		√		003	
4.7	Aft Fuselage Structural Tube	Cracks		√		003	
4.8	Reinforced Floor Mounting Plates and Base Assembly	Cracks		√		003	
4.9	Transmission and Engine Cowling	Cracks		√		003	
4.10	Anti-Collision Light Mount	Cracks		√		003	
4.11	Lift Beam Cap and Adjacent Structure	Cracks		√		003	
4.12	Friction Damper Support, Clip, Retaining Clip, and Mount Assembly	Cracks		√		003	

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			AVUM	AVIM	DEPOT		
4.13	Friction Damper Mount Assembly	Cracks		√		003	
4.14	Aft Landing Gear Attachments	Cracks		√		003	Backup 001
4.15	Crew Door Hinges	Cracks		√		003	
4.16	Hinged Panel and Hinges	Cracks		√		003	Backup 001
4.17	Hinged Panel Assembly Hardware	Cracks		√		001	
4.18	Cargo Door	Cracks		√		003	
4.19	Cargo Door Retainers and Retainer Strap	Cracks		√		003	
4.20	Passenger Step	Cracks		√		001	
4.21	Paratroop Static Line Fitting and Compression Tube	Cracks		√		003	
4.22	Jack and Mooring Fittings	Cracks		√		002	
4.23	Standard Crew Seat	Cracks		√		003	Backup 001
4.24	Mission Operator Seats	Cracks		√		003	Backup 001
4.25	Engine Mounts	Cracks		√		002	
4.26	Engine Mount Fittings	Cracks		√		002	
4.27	Engine Deck Fittings	Cracks		√		002	
4.28	Pillow Blocks	Cracks		√		002	
4.29	Exhaust Tailpipe and Duct Assemblies	Cracks		√		001	
4.30	Bolts, Rod Ends, Turnbuckles, Rods, and Pins	Cracks		√		002	
4.31	Tailboom and Fuselage Attach Fittings	Cracks		√		003	
4.32	Elevator Assembly Support Fittings	Cracks		√		003	Backup 001
4.33	Elevator Horn Assembly	Cracks		√		003	Backup 001

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			AVUM	AVIM	DEPOT		
4.34	Intermediate Gearbox Support Installation	Cracks		√		003	
4.35	Tailboom Structure	Cracks		√		003	
4.36	Ninety Degree Gearbox Support Fitting	Cracks		√		003	
4.37	Vertical Fin	Cracks		√		001	
4.38	Landing Gear Cross Tubes	Cracks		√		004	Backup 001
4.39	Skid Tube Saddles	Cracks		√		003	
5.2	Non-Self-Purging Particle Separator - Air Induction System	Cracks		√		001	
5.3	Inlet Screen Latch Assembly Self-Purging - Air Induction System	Cracks		√		001	
5.4	Air Particle Separator Self-Purging - Air Induction System	Cracks		√		001	
5.5	Improved Particle Separator (IPS) Air Induction System	Cracks		√		001	
5.6	Exhaust System Clamp	Cracks		√		001	
5.7	Tailpipe and Heatshield	Cracks		√		001	
5.8	Oil System - Metal Lines and Fittings	Cracks		√		001	
5.9	Engine Oil Tank Support	Cracks		√		001	
5.10	Engine Oil Cooler	Cracks		√		001	
5.11	Engine Oil Cooler Turbo Blower	Cracks		√		001	
5.12	Oil Separator	Cracks		√		001	
5.13	Engine External Oil Filter Head and Bowl	Cracks		√		001	
5.14	Power Lever Control Rods	Cracks		√		002	
5.15	Power Lever Torque Tube	Cracks		√		002	

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			AVUM	AVIM	DEPOT		
5.16	Power Lever Controls	Cracks		√		003	
5.17	Cambox Assembly	Cracks		√		003	
5.18	Power Lever Control Mounting Brackets and Plates	Cracks		√		001	
6.2	Hydraulic System Components	Cracks		√		001	
6.3	Hydraulic Pump Assembly	Cracks		√		003	
6.4	Ground Test Connections	Cracks		√		001	
6.5	Relief Valve, Bolt, and Fitting	Cracks		√		001	
6.6	Pressure Switch	Cracks		√		001	
6.7	Solenoid Valves	Cracks		√		001	
6.8	Hydraulic Servo Cylinder Assembly (Cyclic Control) Clevis	Cracks		√		002	
6.9	Hydraulic Servo Cylinder Tube Assembly (Cyclic Control)	Cracks		√		001	
6.10	Hydraulic Servo Cylinder Assembly (Cyclic Control) Housing	Cracks		√		001	
6.11	Hydraulic Servo Cylinder (Cyclic Control) Cylinder Caps	Cracks		√		001	
6.12	Hydraulic Servo Cylinder Assembly (Cyclic Control)	Cracks		√		001	
6.13	Hydraulic Servo Cylinder Assembly (Collective Control) Clevis	Cracks		√		002	
6.14	Hydraulic Servo Cylinder (Collective Control) Tube Assembly	Cracks		√		001	

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			AVUM	AVIM	DEPOT		
6.15	Hydraulic Servo Cylinder Assembly (Collective Control) Piston Rod	Cracks		√		002	
6.16	Hydraulic Servo Cylinder Assembly (Collective Control) Bearing Housing	Cracks		√		001	
6.17	Collective Control System Bellcrank	Cracks		√		003	
6.18	Collective Control. System Lever Assembly	Cracks		√		003	
6.19	Collective Control System Support	Cracks		√		003	
6.20	Collective Control System Control Tubes	Cracks		√		003	
6.21	Tube and Lever Assembly	Cracks		√		003	
6.22	Support Assembly, Hydraulic Cylinder Assembly (Starboard)	Cracks		√		003	Backup 001
6.23	Support Assembly, Hydraulic Cylinder Assembly (Port)	Cracks		√		003	Backup 001
6.24	Mixing Lever Assembly - Cyclic Controls	Cracks		√		003	
6.25	Cyclic Control System Control Tubes	Cracks		√		003	
6.26	Cyclic Control System Bellcranks and Levers	Cracks		√		003	
6.27	Cyclic Control System Supports	Cracks		√		003	
6.28	Adjuster Assembly	Cracks		√		003	
6.29	Tail Rotor Control Quadrant	Cracks		√		003	
6.30	Tail Rotor Control Tube and Quill - Sprocket Guard	Cracks		√		001	
6.31	Tail Rotor Control Tube and Quill - Control Tube	Cracks		√		002	

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			AVUM	AVIM	DEPOT		
6.32	Tail Rotor Control Tube and Quill - Housing	Cracks		√		001	
6.33	Tail Rotor Control Tube and Quill - Retaining Nut	Cracks		√		002	
6.34	Tail Rotor Control Tube and Quill - Sprocket	Cracks		√		001	
6.35	Tail Rotor Control Tube and Quill - Bearing Retainer	Cracks		√		001	
6.36	Tail Rotor Control Tube and Quill - Spacer	Cracks		√		002	
6.37	Tail Rotor Control Tube and Quill - Control Nut	Cracks		√		001	
6.38	Tail Rotor Control Tubes	Cracks		√		003	
6.39	Tail Rotor Hydraulic Power Cylinder - Piston Rod	Cracks		√		002	
6.40	Tail Rotor Hydraulic Power Cylinder Adapter	Cracks		√		002	
6.41	Tail Rotor Support Assembly	Cracks		√		003	Backup 001
6.42	Tail Rotor Arm Assemblies	Cracks		√		003	Backup 001
6.43	Tail Rotor Bellcrank Assembly	Cracks		√		003	Backup 001
6.44	Tail Rotor Cylinder and Support Assembly - Hardware	Cracks		√		002	
6.45	Tail Rotor Control System - Bellcranks	Cracks		√		003	
6.46	Tail Rotor Control System - Levers	Cracks		√		003	
6.47	Elevator Control System - Control Tubes	Cracks		√		003	
6.48	Elevator Control System - Bellcranks	Cracks		√		003	

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			AVUM	AVIM	DEPOT		
6.49	Elevator Control System - Levers	Cracks		√		003	
6.50	Elevator Control System - Supports	Cracks		√		003	
6.51	Elevator Control System - Bellcranks, Levers, and Supports - Bearing Replacement	Cracks		√		003	Backup 001

5. Points of Contact.

a. Technical point of contact for this TB is Mr. Wayne Suchman, AGSE-PM, AMSAT-D-WAG, DSN 693-1924 or commercial (314)263-1924, e-mail: wsuchman@emh4.wsmd.stl.army.mil.

b. Nondestructive Test Inspection technical point of contact for this TB is Mr. Scott Huddleston, DSN 693-1923 or commercial (314)263-1923, e-mail: shuddles@emh4.wsmd.stl.army.mil.

6. Reporting of Errors and Recommending Improvements. You can help improve this TB. If you find any mistakes or if you know of a way to improve these procedures, please let us know. Mail your letter or DA Form 2028 (Recommended Changes to Publications and Blank Forms) directly to: Commander, US Army Aviation and Troop Command, ATTN: AMSAT-I-MP, 4300 Goodfellow Blvd., St. Louis, MO 63120-1798. A reply will be furnished to you. You may also submit your recommended changes by E-mail directly to <mpmt%avma28@st-louis-emh7.army.mil>. A reply will be furnished directly to you. Instructions for sending an electronic 2028 may be found at the back of this manual.

By Order of the Secretary of the Army.

Official

JOEL B HUDSON
Administrative Assistant to the
Secretary of the Army
03432

DENNIS J. REIMER
General, United States Army
Chief of Staff

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PREVIOUS EDITIONS ARE OBSOLETE.

P.S.--IF YOUR OUTFIT WANTS TO KNOW ABOUT YOUR RECOMMENDATION MAKE A CARBON COPY OF THIS AND GIVE IT TO YOUR HEADQUARTERS.

THE METRIC SYSTEM AND EQUIVALENTS

'NEAR MEASURE

. Centimeter = 10 Millimeters = 0.01 Meters = 0.3937 Inches
1 Meter = 100 Centimeters = 1000 Millimeters = 39.37 Inches
1 Kilometer = 1000 Meters = 0.621 Miles

'VEIGHTS

Gram = 0.001 Kilograms = 1000 Milligrams = 0.035 Ounces
1 Kilogram = 1000 Grams = 2.2 lb.
1 Metric Ton = 1000 Kilograms = 1 Megagram = 1.1 Short Tons

LIQUID MEASURE

1 Milliliter = 0.001 Liters = 0.0338 Fluid Ounces
1 Liter = 1000 Milliliters = 33.82 Fluid Ounces

SQUARE MEASURE

1 Sq. Centimeter = 100 Sq. Millimeters = 0.155 Sq. Inches
1 Sq. Meter = 10,000 Sq. Centimeters = 10.76 Sq. Feet
1 Sq. Kilometer = 1,000,000 Sq. Meters = 0.386 Sq. Miles

CUBIC MEASURE

1 Cu. Centimeter = 1000 Cu. Millimeters = 0.06 Cu. Inches
1 Cu. Meter = 1,000,000 Cu. Centimeters = 35.31 Cu. Feet

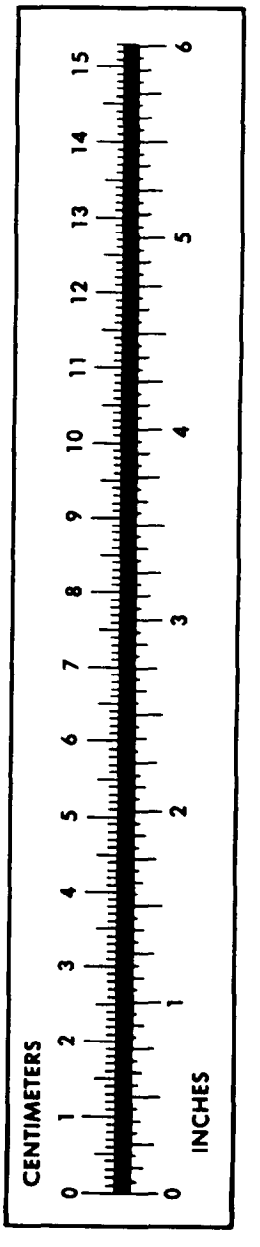
TEMPERATURE

5/9(°F - 32) = °C
212° Fahrenheit is evuivalent to 100° Celsius
90° Fahrenheit is equivalent to 32.2° Celsius
32° Fahrenheit is equivalent to 0° Celsius
9/5C° + 32 =°F

APPROXIMATE CONVERSION FACTORS

TO CHANGE	TO	MULTIPLY BY
Inches	Centimeters	2.540
Feet	Meters	0.305
Yards	Meters	0.914
Miles	Kilometers	1.609
Square Inches	Square Centimeters	6.451
Square Feet	Square Meters	0.093
Square Yards	Square Meters	0.836
Square Miles	Square Kilometers	2.590
Acres	Square Hectometers	0.405
Cubic Feet	Cubic Meters	0.028
Cubic Yards	Cubic Meters	0.765
Fluid Ounces	Milliliters	29.573
ıts	Liters	0.473
arts	Liters	0.946
allons	Liters	3.785
Ounces	Grams	28.349
Pounds	Kilograms	0.454
Short Tons	Metric Tons	0.907
Pound-Feet	Newton-Meters	1.356
Pounds per Square Inch	Kilopascals	6.895
Miles per Gallon	Kilometers per Liter	0.425
Miles per Hour	Kilometers per Hour	1.609

TO CHANGE	TO	MULTIPLY BY
Centimeters	Inches	0.394
Meters	Feet	3.280
Meters	Yards	1.094
Kilometers	Miles	0.621
Square Centimeters	Square Inches	0.155
Square Meters	Square Feet	10.764
Square Meters	Square Yards	1.196
Square Kilometers	Square Miles	0.386
Square Hectometers	Acres	2.471
Cubic Meters	Cubic Feet	35.315
Cubic Meters	Cubic Yards	1.308
Milliliters	Fluid Ounces	0.034
Liters	Pints	2.113
Liters	Quarts	1.057
ers	Gallons	0.264
ms	Ounces	0.035
ograms	Pounds	2.205
Metric Tons	Short Tons	1.102
Newton-Meters	Pounds-Feet	0.738
Kilopascals	Pounds per Square Inch	0.145
lometers per Liter	Miles per Gallon	2.354
meters per Hour	Miles per Hour	0.621



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