

IMMEDIATE

* U N C L A S S I F I E D *

BT

UNCLAS

SECTION 01 OF 02

H - THIS IS A SAFETY OF FLIGHT, MAINTENANCE MANDATORY MESSAGE, RELEASED IN ACCORDANCE WITH AR 95-1B, DATED 1 MAY 1980 AND HAS NOT, REPEAT, HAS NOT BEEN TRANSMITTED TO UNITS SUBORDINATE TO ADDRESSEES. ADDRESSEES SHOULD IMMEDIATELY RETRANSMIT THIS MESSAGE TO ALL SUBORDINATE UNITS, ACTIVITIES OR ELEMENTS AFFECTED OR CONCERNED. THE RETRANSMITTAL SHALL REFERENCE THIS MESSAGE. ACTION ADDRESSEES WILL IMMEDIATELY VERIFY THIS RETRANSMISSION TO COMMANDER, AVSCOM, ATTN -

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DRSAV-MPSD.

SUBJECT : SAFETY OF FLIGHT SUPPLEMENTAL INSPECTION CRITERIA FOR PITCH

CHANGE LINK CLEVIS P/N 204-011-136-1, FSN 5340-00-839-3934, TB 55-1520-242-20-B (UH-1-A4-07), REFERENCE MESSAGE UH-1-A4-06

1. SUMMARY -

A. THIS MESSAGE PROVIDES THE PROCEDURE FOR USING X-RAY INSPECTION OF THE SUBJECT CLEVIS TO MORE ACCURATELY DETERMINE CRACK INITIATION OR PROPAGATION.

B. THIS X-RAY INSPECTION WILL BE PERFORMED ONLY ON THOSE CLEVIS WHICH HAVE PREVIOUSLY BEEN DETERMINED AS SUSPECT BASED ON THE VISUAL INSPECTION CRITERIA PROVIDED IN SAFETY OF FLIGHT MESSAGE UH-1-A4-06.

2. THE FOLLOWING PROCEDURES ARE PROVIDED -

A. EQUIPMENT - X-RAY UNIT, INDUSTRIAL, 150KV OR LARGER.

B. MATERIAL -

(1) X-RAY FILM, INDUSTRIAL, EASTMAN KODAK M, DUPONT 55 OR EQUIVALENT; SIZE 5 INCH X 7 INCH OR LARGER.

(2) X-RAY EXPOSURE HOLDER WITH .005 INCH LEAD SCREEN ON X-RAY BEAM ENTRANCE SIDE, AND .010 INCH LEAD SCREEN ON X-RAY BEAM EXIT SIDE.

C. INSPECTION PROCEDURE -

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FULL SECTION OF D2

(1) PLACE PART FLAT (THREADED SHAFT HORIZONTAL WITH FILM) ON FILM CASSETTE.

(2) LOCATE TARGET POINT FOR X-RAY BEAM ON SECOND THREAD OF SHAFT FROM YOKE VERTICAL TO FILM PLANE.

(3) POSITION X-RAY SOURCE 3/4 INCHES FROM FILM.

(4) EXPOSE FILM PER TECHNIQUE AS FOLLOWS -

SHOT NO. 1 - KILOVOLTAGE PEAK (KVP), 150

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MILLIAMPERAGE, 7.0

EXPOSURE TIME, 3.0 MINUTES

SHOT NO. 2 - ROTATE PART 90 DEGREES ON SHAFT CENTERLINE AND SUPPORT THREADED SHAFT WITH 1/2 INCH WOOD BLOCK TO HOLD SHAFT HORIZONTAL TO FILM. (EXPOSURE AND TECHNIQUE SAME AS SHOT NO. 1)

D. PROCESS FILM IAW STANDARD INSTRUCTIONS CONTAINED IN T.O. 33B-1-1 AND/OR TM 43-0103, CHAPTER 5.

NOTE

DUE TO DIFFERENCES IN EACH X-RAY MACHINE.

KVP AND MA MAY REQUIRE FINE TUNING TO

OBTAIN BEST DEFINITION IN AREA OF CONCERN.

3. ACCEPTANCE/REJECTION CRITERIA - USING 5X MAGNIFIER, ANY INDICATION OF A CIRCUMFERENTIAL CRACK IS CAUSE FOR REJECTION.

PARTICULAR ATTENTION SHALL BE GIVEN TO THE BOTTOM OF THE DRILLED HOLE WHEN CROSS SECTIONAL AREA CHANGES.

4. MARKING INSTRUCTIONS - FOR ACCEPTABLE PARTS VIBRO ETCH A CIRCLED //X// ON FLAT SURFACE OF YOKE, (FACE AREA JUST ABOVE SHAFT), TO INDICATE PERFORMANCE OF X-RAY INSPECTION.

5. DISPOSITION INSTRUCTIONS FOR REJECTED CLEVIS -

ATTACH COMPLETE DA FORM 1577-2 AND COPY OF X-RAY TO REJECTED

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CLEVIS AND SHIP TO - CORPUS CHRISTI ARMY DEPOT

SDSCC-0MT

ATTN - LEROY PATTON (AV 861-2208)

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18597-NPSD.

SUBJECT - SAFETY OF FLIGHT SUPPLEMENTAL INSPECTION CRITERIA FOR PITCH
WING LINK CLEVIS P/N 204-011-136-1. FSN 5340-00-839-3934, TB
1520-242-20-8 (UH-1-A4-07). REFERENCE MESSAGE UH-1-84-06

1. SUMMARY -

A. THIS MESSAGE PROVIDES THE PROCEDURE FOR USING X-RAY
INSPECTION OF THE SUBJECT CLEVIS TO MORE ACCURATELY DETERMINE CRACK
INITIATION OR PROPAGATION.

B. THIS X-RAY INSPECTION WILL BE PERFORMED ONLY ON THOSE CLEVIS
WHICH HAVE PREVIOUSLY BEEN DETERMINED AS SUSPECT BASED ON THE VISUAL
INSPECTION CRITERIA PROVIDED IN SAFETY OF FLIGHT MESSAGE UH-1-84-06.

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B. MATERIAL -

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EQUIVALENT; SIZE 5 INCH X 7 INCH OR LARGER.

(2) X-RAY EXPOSURE HOLDER WITH .005 INCH LEAD SCREEN ON
X-RAY BEAM ENTRANCE SIDE, AND .010 INCH LEAD SCREEN ON X-RAY BEAM
EXIT SIDE.

C. INSPECTION PROCEDURE -

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MILLIAMPERAGE, 7.0

EXPOSURE TIME, 3.0 MINUTES

2. SHOT NO. 2 - ROTATE PART 90 DEGREES ON SHAFT CENTERLINE
SUPPORT THREADED SHAFT WITH 1/2 INCH WOOD BLOCK TO HOLD SHAFT
HORIZONTAL TO FILM. (EXPOSURE AND TECHNIQUE SAME AS SHOT NO. 1)
D. PROCESS FILM IAW STANDARD INSTRUCTIONS CONTAINED IN T.O.
33B-1-1 AND/OR TM 43-0103, CHAPTER 5.

NOTE

DUE TO DIFFERENCES IN EACH X-RAY MACHINE.

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CLEVIS AND SHIP TO - CORPUS CHRISTI ARMY DEPOT

SDSCC-OMT

ATTN - LEROY PATTON (AV 861-2208)

CORPUS CHRISTI, TEXAS 78419

6. REPORTING AND RECORDING - NONE

7. FOREIGN MILITARY SALES/FMS RECIPIENTS REQUIRING CLARIFICATION OF
THIS MESSAGE SHOULD CONTACT USAVSCOM, DRSAV-I, CW4 KYLE STEPHENSON,
AUTOVON 693-2813 OR COMMERCIAL 314-263-2813.

8. AVSCOM TECHNICAL POINT OF CONTACT IS MR. MIKE BEHNER, DRSAV-9E,
AUTOVON 693-1525 OR COMMERCIAL 314-263-1525.

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