

BOEING 
COMMERCIAL JET
NONDESTRUCTIVE TEST

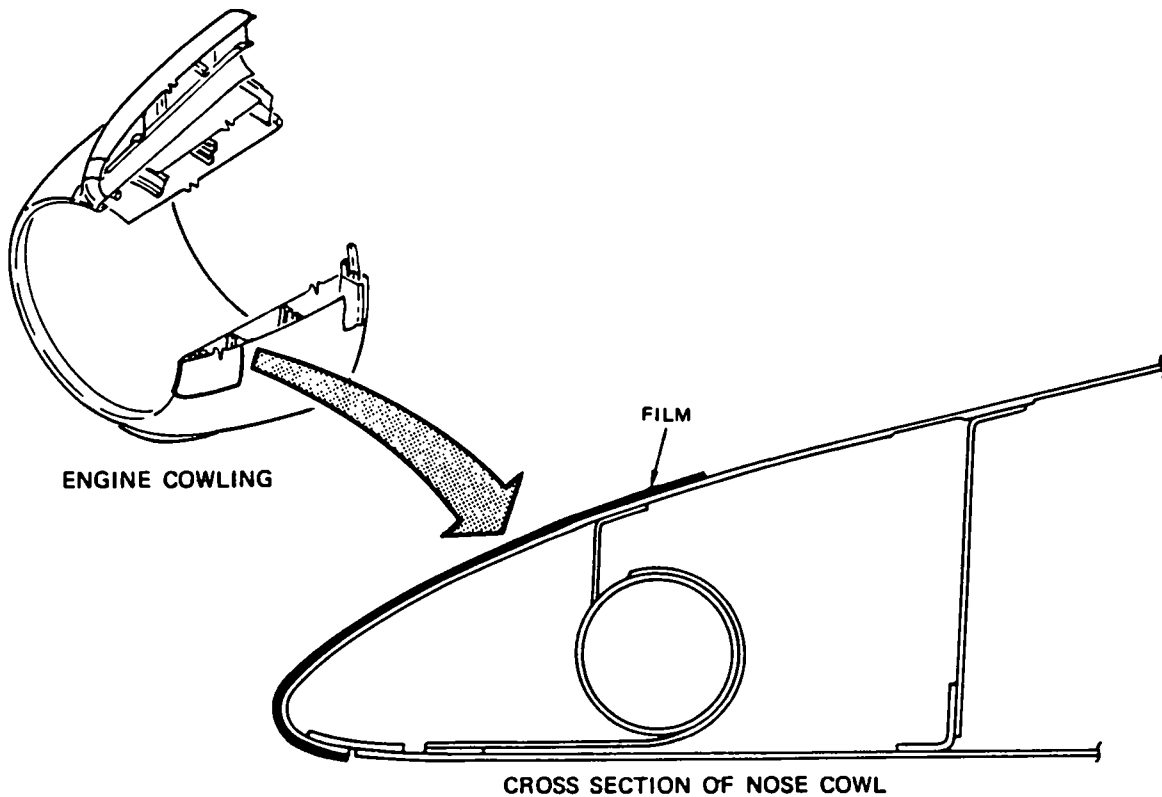
PART 2 - X-RAY

POWER PLANT

Purpose

Service experience shows that brackets which support anti-icing duct in nose cowl of JT4D engines fail after some service life. The following procedure is suggested for detecting failed brackets.

1. Remove nose cowl as directed in Maintenance Manual, Subject 71-02-01.
2. Tape film on leading edge of cowl as shown with centerline 45 degrees from vertical centerline of cowl (as viewed looking forward).
3. Orient cowl with leading edge down. Set X-ray machine to shoot down at 45 degree angle, offset 20 degrees to preclude superimposition of interfering parts on film.
4. Repeat procedure at 90-degree intervals from first exposure which is located at about 4:30 o'clock position.



EXPOSURE NUMBER	FILM			SFD	GENERATOR SETTINGS	
	POSITION	ASTM CLASS	SIZE		KV	MAS
1 THRU 4	1 THRU 4	III	8 x 10	36	80	180

Nose Cowl - JT4D Engine
 Figure 1

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