



<b>sabena</b> <sup>®</sup> <b>B707</b>	Module: GENERAL	A/C Reg :	Check :	 <b>02F3000001</b>
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**AD 2009-18-10      BS600K & BS820 TERMINAL FITTING INSPECTION**

		MAINT	RII/INSP
Execution / Start Date:			
End Date:			


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**AD 2009-18-10 BS600K & BS820 TERMINAL FITTING INSPECTION**

					MAINT	RII/INSP	
Nr.	Hardtime	Task	Spec.	Related Documents			
1.		E3	INS	AD 2009-18-10 rev 0 DFW B707-53-511 rev 02/10/07 SB B707-53-3524 rev 18/09/08			
<b>Check:</b>							
<b>Zones:</b>							
<b>Access:</b>							
NRC YES <input type="radio"/> NO <input type="radio"/>		IF YES, NUMBER(S): .....					


**A. INSPECTION – BODY TERMINAL FITTINGS AT BODY STATION 600K.**

1. Get access to the body terminal fittings at STA 600K below the cabin floor level through the air conditioning equipment access doors 1124L & 1124R.
2. Remove the side wall panels, internal lining & insulation blankets at STA 600K to access the body terminal fittings above the cabin floor level.
3. Do a detailed inspection of the left body terminal fitting at STA 600K as given in Figure 3.
  - a) If any crack or corrosion is found, contact Boeing for repair instructions or for instructions to replace the body terminal fitting with a body terminal fitting made from 7075-T73 material. Provide a detailed description of any crack or corrosion to Boeing when requesting repair instructions.
  - b) If there is an existing repair, inspect the repair for any crack or corrosion.
    - 1) If no crack or corrosion is found, it is not necessary to remove the repair.
    - 2) If any crack or corrosion is found, remove the repair & do a detailed inspection of the fitting in the area covered by the repair. Send a detailed description of any crack or corrosion to Boeing & request repair instructions.
4. Do a detailed inspection of the right body terminal fitting at STA 600K as given in Figure 4.
  - a) If any crack or corrosion is found, contact Boeing for repair instructions or for instructions to replace the body terminal fitting with a body terminal fitting made from 7075-T73 material. Provide a detailed description of any crack or corrosion to Boeing when requesting repair instructions.
  - b) If there is an existing repair, inspect the repair for any crack or corrosion.
    - 1) If no crack or corrosion is found, it is not necessary to remove the repair.
    - 2) If any crack or corrosion is found, remove the repair & do a detailed inspection of the fitting in the area covered by the repair. Send a detailed description of any crack or corrosion to Boeing & request repair instructions.
5. Close the air conditioning equipment access doors 1124L & 1124R.
6. Install the insulation blankets, internal lining & side wall panels at STA 600K.

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	MAINT	RII/INSP
<p><b><u>B. INSPECTION – BODY TERMINAL FITTINGS AT BODY STATION 820 BULKHEAD.</u></b></p> <p><b>NOTE:</b> Prior or concurrent incorporation of 707 service bulletins 1966, “FUSELAGE – Station 820 Bulkhead Fitting Modification” &amp; 2912, “FUSELAGE – Station 820 Body Terminal Fitting Inspection, Modification &amp; Repair” is recommended on commonly affected airplanes due to common access.</p> <ol style="list-style-type: none"> <li>1. Get access to the body terminal fittings at STA 820 below the cabin floor level through the main landing gear wheel well.</li> <li>2. Remove the side wall panels, internal lining &amp; insulation blankets at STA 820 to access the body terminal fittings above the cabin floor level.</li> <li>3. Do a detailed inspection of the left body terminal fitting on the STA 820 bulkhead as given in Figure 5. <ol style="list-style-type: none"> <li>a) If any crack or corrosion is found, contact Boeing for repair instructions or for instructions to replace the body terminal fitting with a body terminal fitting made from 7075-T73 material. Provide a detailed description of any crack or corrosion to Boeing when requesting repair instructions.</li> <li>b) If there is an existing repair, inspect the repair for any crack or corrosion. <ol style="list-style-type: none"> <li>1) If no crack or corrosion is found, it is not necessary to remove the repair.</li> <li>2) If any crack or corrosion is found, remove the repair &amp; do a detailed inspection of the fitting in the area covered by the repair. Send a detailed description of any crack or corrosion to Boeing &amp; request repair instructions.</li> </ol> </li> </ol> </li> <li>4. Do a detailed inspection of the right body terminal fitting on the STA 820 bulkhead as given in Figure 6. <ol style="list-style-type: none"> <li>a) If any crack or corrosion is found, contact Boeing for repair instructions or for instructions to replace the body terminal fitting with a body terminal fitting made from 7075-T73 material. Provide a detailed description of any crack or corrosion to Boeing when requesting repair instructions.</li> <li>b) If there is an existing repair, inspect the repair for any crack or corrosion. <ol style="list-style-type: none"> <li>1) If no crack or corrosion is found, it is not necessary to remove the repair.</li> <li>2) If any crack or corrosion is found, remove the repair &amp; do a detailed inspection of the fitting in the area covered by the repair. Send a detailed description of any crack or corrosion to Boeing &amp; request repair instructions.</li> </ol> </li> </ol> </li> </ol>		


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**C.ULTRASONIC INSPECTION – BODY TERMINAL FITTINGS AT BODY STATION (STA) 820 BULKHEAD.**


1. If the airplane has not been changed by Boeing Service Bulletin 707-2912 R01 Paragraph II., Accomplishment Instructions, PART II. PREVENTIVE MODIFICATION DATA or PART III. REPAIR DATA, no inspections are required by this service bulletin.
2. For airplanes that have been changed by Boeing Service Bulletin 707-2912 R01 Paragraph II., Accomplishment Instructions, PART II. PREVENTIVE MODIFICATION DATA or PART III. REPAIR DATA, do the following:
  - (1) Get access to the body terminal fittings at STA 820 below the cabin floor level through the main landing gear wheel well.
  - (2) Do an ultrasonic inspection for any internal crack in the left body terminal fitting on the STA 820 bulkhead as given in Figure 9.
    - (a) If no crack is found:
      - 1) If the modification is not in accordance with Boeing Service Bulletin 707-2912 R01 Accomplishment Instructions, PART II. PREVENTIVE MODIFICATION DATA, remove the modification, contact Boeing for repair instructions and do the work instructed by Boeing.
      - 2) If the modification is in accordance with Boeing Service Bulletin 707-2912 R01 Accomplishment Instructions, PART II. PREVENTIVE MODIFICATION DATA, no more work is necessary.
    - (b) If any crack is found:
      - 1) If the modification or repair was installed as given in Boeing Service Bulletin 707-2912 R01, inspect the crack to verify that the modification or repair still meets the requirements of Boeing Service Bulletin 707-2912 R01.
        - a) If the crack is within the repair limits of the modification or repair as given in Boeing Service Bulletin 707-2912 R01, no more work is necessary.
        - b) If the crack has grown beyond the repair limits of the modification or repair as given in Boeing Service Bulletin 707-2912 R01, but is still within the repair limits of Boeing Service Bulletin 707-2912 R01, Accomplishment Instructions, PART III. REPAIR DATA, repair the crack as given in Boeing Service Bulletin 707-2912 R01, Accomplishment Instructions, PART III. REPAIR DATA.
        - c) If the crack has grown beyond the repair limits of Boeing Service Bulletin 707-2912 R01, contact Boeing for new repair instructions and do the work instructed by Boeing.
      - 2) If the modification or repair was not installed as given in Boeing Service Bulletin 707-2912 R01, remove the modification or repair and do the ultrasonic inspection. Contact Boeing for new repair instructions and do the work instructed by Boeing.

<b>MAINT</b>	<b>RII/INSP</b>
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	MAINT	RII/INSP
<p>(3) Do an ultrasonic inspection for any internal crack of the right body terminal fitting on the STA 820 bulkhead as given in Figure 10.</p> <p>(a) If no crack is found:</p> <p>1) If the modification is not in accordance with Boeing Service Bulletin 707-2912 R01 Accomplishment Instructions, PART II. PREVENTIVE MODIFICATION DATA, remove the modification, contact Boeing for repair instructions and do the work instructed by Boeing.</p> <p>2) If the modification is in accordance with Boeing Service Bulletin 707-2912 R01 Accomplishment Instructions, PART II. PREVENTIVE MODIFICATION DATA, no more work is necessary.</p> <p>(b) If any crack is found:</p> <p>1) If the modification or repair was installed as given in Boeing Service Bulletin 707-2912 R01, inspect the crack to verify that the modification or repair still meets the requirements of Boeing Service Bulletin 707-2912 R01.</p> <p>a) If the crack is within the repair limits of the modification or repair as given in Boeing Service Bulletin 707-2912 R01, no more work is necessary.</p> <p>b) If the crack has grown beyond the repair limits of the modification or repair as given in Boeing Service Bulletin 707-2912 R01, but is still within the repair limits of Boeing Service Bulletin 707-2912 R01, Accomplishment Instructions, PART III. REPAIR DATA, repair the crack as given in Boeing Service Bulletin 707-2912 R01, Accomplishment Instructions, PART III. REPAIR DATA.</p> <p>c) If the crack has grown beyond the repair limits of Boeing Service Bulletin 707-2912 R01, contact Boeing for new repair instructions and do the work instructed by Boeing.</p> <p>2) If the modification or repair was not installed as given in Boeing Service Bulletin 707-2912 R01, remove the modification or repair and do the ultrasonic inspection. Contact Boeing for new repair instructions and do the work instructed by Boeing.</p>		
(4) Install the insulation blankets, internal lining & side wall panels at body station (STA) 820.		
(5) Put the airplane back to a serviceable condition.		

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FIGURE 3: GROUP 2 - LEFT BODY TERMINAL FITTING INSPECTION - BODY STATION 600K.

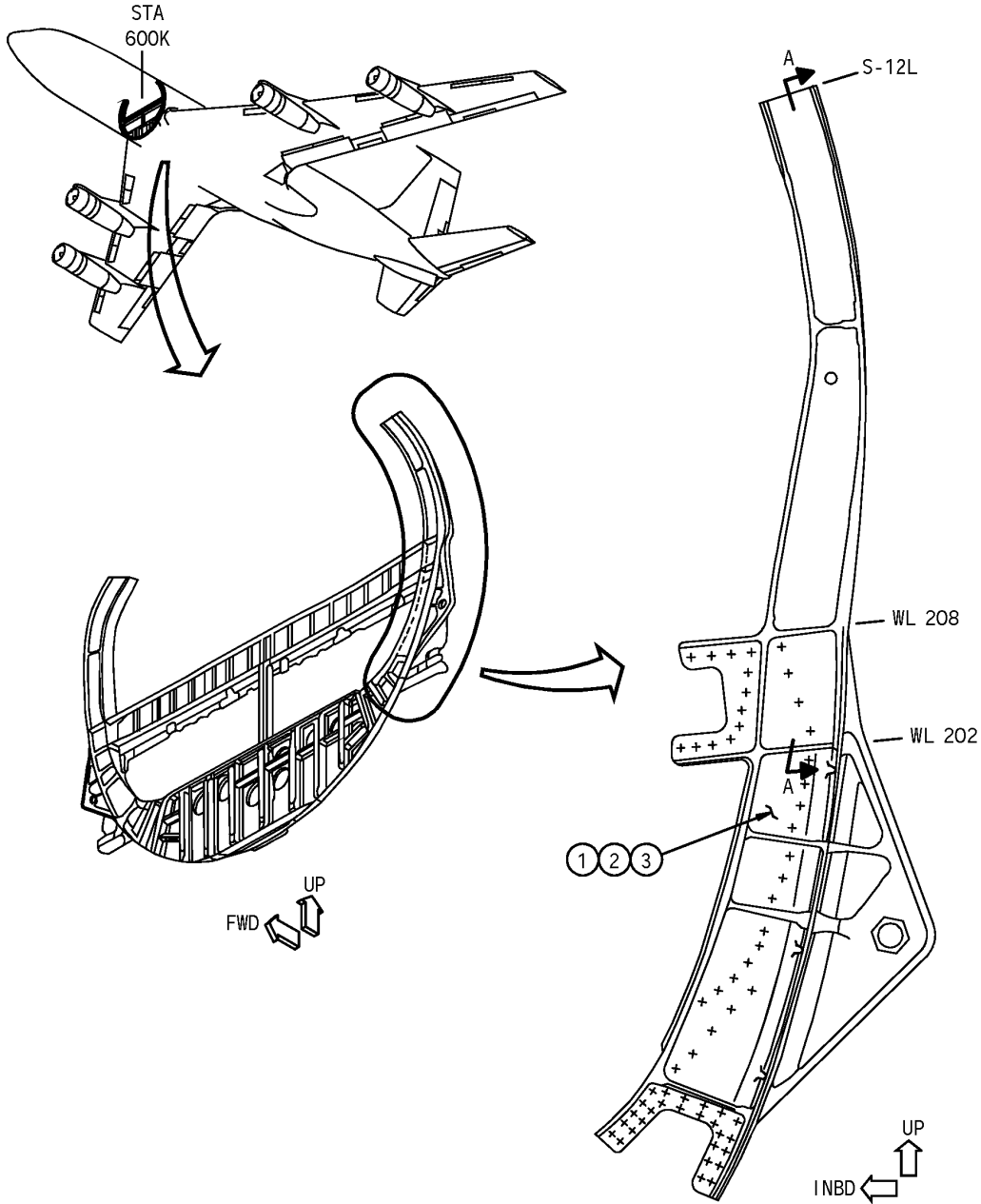

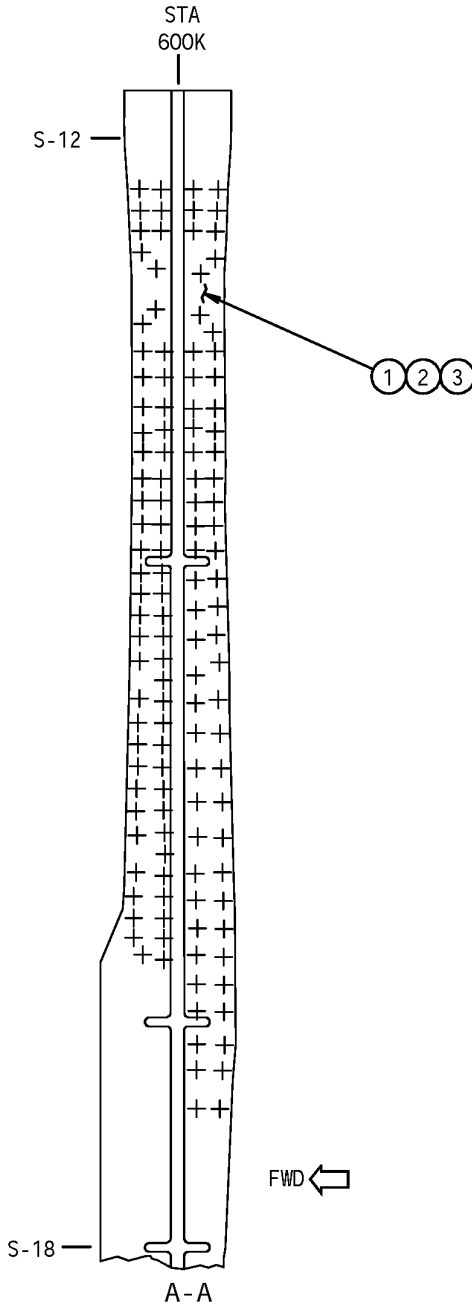



FIGURE 3: GROUP 2 - LEFT BODY TERMINAL FITTING INSPECTION - BODY STATION 600K.  
(SHEET 1 OF 3)

MAINT	RII/INSP

<b>sabena</b> B707	Module: GENERAL	A/C Reg :	Check :	 <b>02F3000001</b>
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	MAINT	RII/INSP
 <p>STA 600K</p> <p>S-12</p> <p>S-18</p> <p>A-A</p> <p>FWD ←</p> <p>① ② ③</p> <p>FIGURE 3: GROUP 2 - LEFT BODY TERMINAL FITTING INSPECTION - BODY STATION 600K. (SHEET 2 OF 3)</p>		

<b>sabena</b> <b>B707</b>	Module: GENERAL	A/C Reg :	Check :	
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The step numbers shown below agree with the numbers shown in the circle symbols in the figure. The QTY numbers shown below are the number of parts necessary for one side of the airplane.

STEP	TASK	NAME	IDENTIFICATION	QTY	MORE DATA
1	Remove	Corrosion Inhibiting Compound	BMS 3-23, Type II	-	If present to enable detection of any crack or corrosion on the surface. Refer to SOPM 20-41-05 as an accepted procedure.
2	Inspect	Body Terminal Fitting	50-5345-3 or 50-5345-11	1	Do a Detailed Inspection of the visible surfaces of the entire fitting, including the web, flanges, ribs and all repairs on it for any crack or corrosion. (a)
3	Apply	Corrosion Inhibiting Compound	BMS 3-23, Type II	-	To the entire fitting after inspection if no crack or corrosion is found. Refer to SOPM 20-41-05 as an accepted procedure.

(a) Pay particular attention to fastener locations. Removal of fasteners or structure is not required.

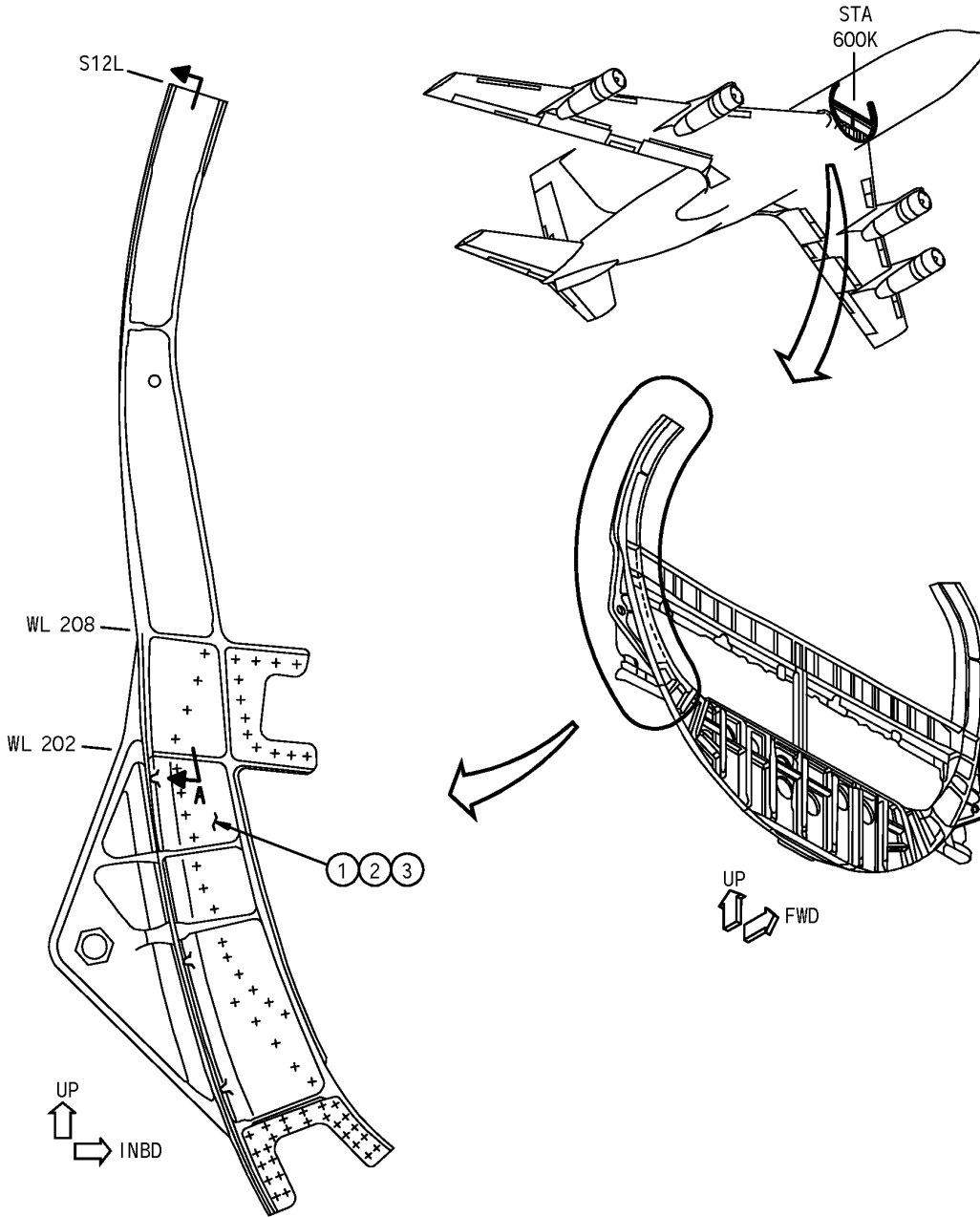
**MAINT RII/INSP**

**FIGURE 3: LEFT BODY TERMINAL FITTING INSPECTION - BODY STATION 600K.  
(SHEET 3 OF 3)**

<b>sabena</b> <b>B707</b>	Module: GENERAL	A/C Reg :	Check :	 <b>02F3000001</b> <b>Page 9 of 25</b>
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**FIGURE 4: GROUP 2 - RIGHT BODY TERMINAL FITTING INSPECTION - BODY STATION 600K.**

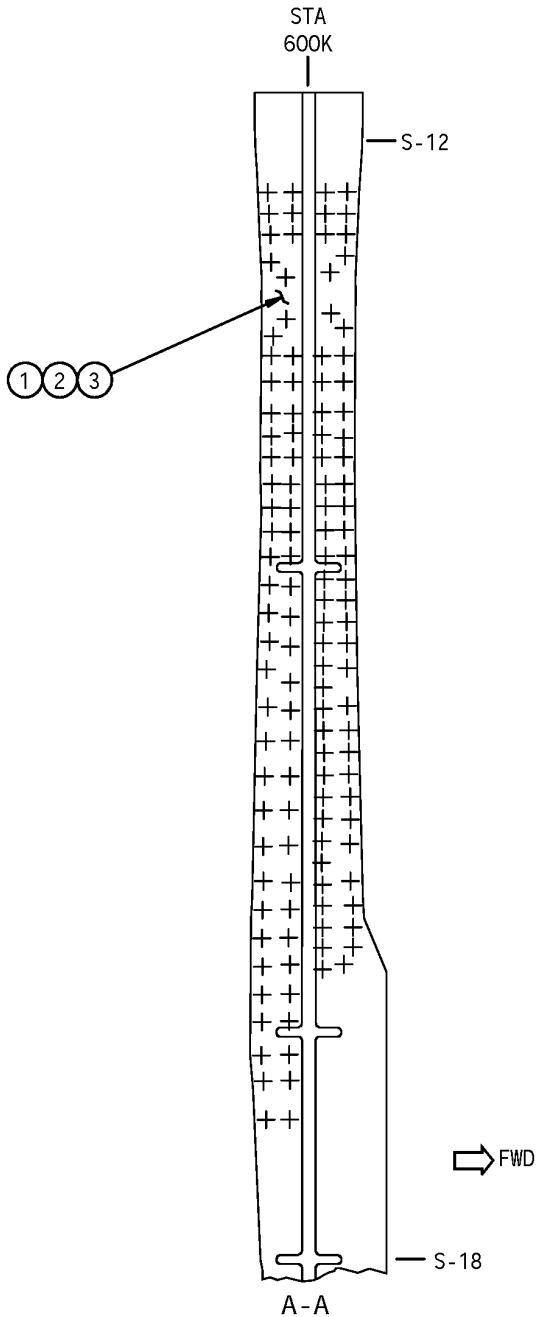


**FIGURE 4: GROUP 2 - RIGHT BODY TERMINAL FITTING INSPECTION - BODY STATION 600K.**  
(SHEET 1 OF 3)

MAINT	RII/INSP


<b>sabena</b> B707	Module: GENERAL	A/C Reg :	Check :	 <b>02F3000001</b>
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FIGURE 4: GROUP 2 - RIGHT BODY TERMINAL FITTING INSPECTION - BODY STATION 600K.  
(SHEET 2 OF 3)

<b>sabena</b> <b>B707</b>	Module: GENERAL	A/C Reg :	Check :	
	Oper. : RT-MP HT			
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The step numbers shown below agree with the numbers shown in the circle symbols in the figure. The QTY numbers shown below are the number of parts necessary for one side of the airplane.

STEP	TASK	NAME	IDENTIFICATION	QTY	MORE DATA
1	Remove	Corrosion Inhibiting Compound	BMS 3-23, Type II	-	If present to enable detection of any crack or corrosion on the surface. Refer to SOPM 20-41-05 as an accepted procedure.
2	Inspect	Body Terminal Fitting	50-5345-4 or 50-5345-12	1	Do a Detailed Inspection of the visible surfaces of the entire fitting, including the web, flanges, ribs and all repairs on it for any crack or corrosion. (a)
3	Apply	Corrosion Inhibiting Compound	BMS 3-23, Type II	-	To the entire fitting after inspection if no crack or corrosion is found. Refer to SOPM 20-41-05 as an accepted procedure.

(a) Pay particular attention to fastener locations. Removal of fasteners or structure is not required.

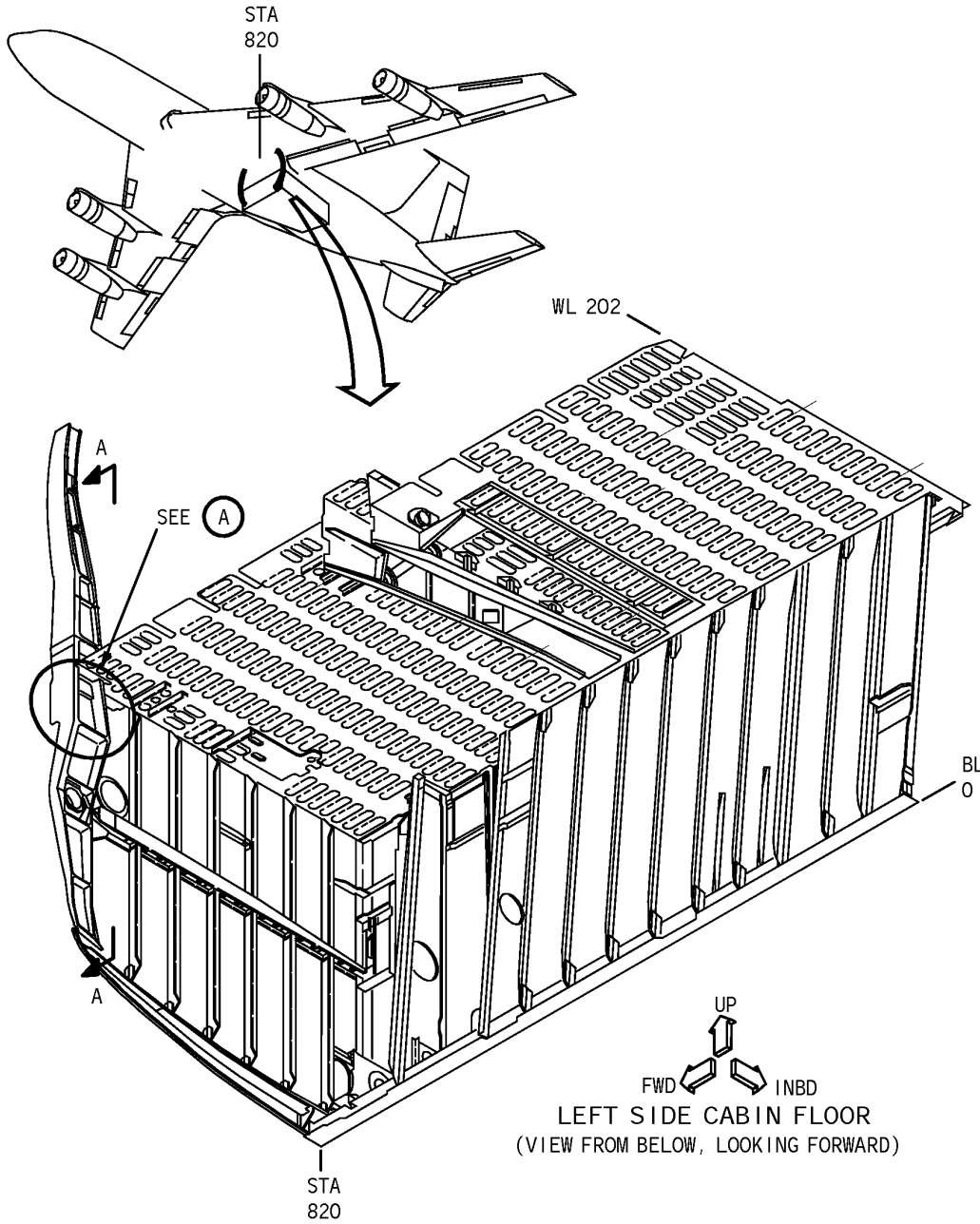
**MAINT      RII/INSP**

**FIGURE 4: RIGHT BODY TERMINAL FITTING INSPECTION - BODY STATION 600K.  
(SHEET 3 OF 3)**

<b>sabena</b> B707	Module: GENERAL	A/C Reg :	Check :	 <b>02F300001</b> Page 12 of 25
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FIGURE 5: GROUPS 1 & 2 - LEFT BODY TERMINAL FITTING INSPECTION - BODY STATION 820.



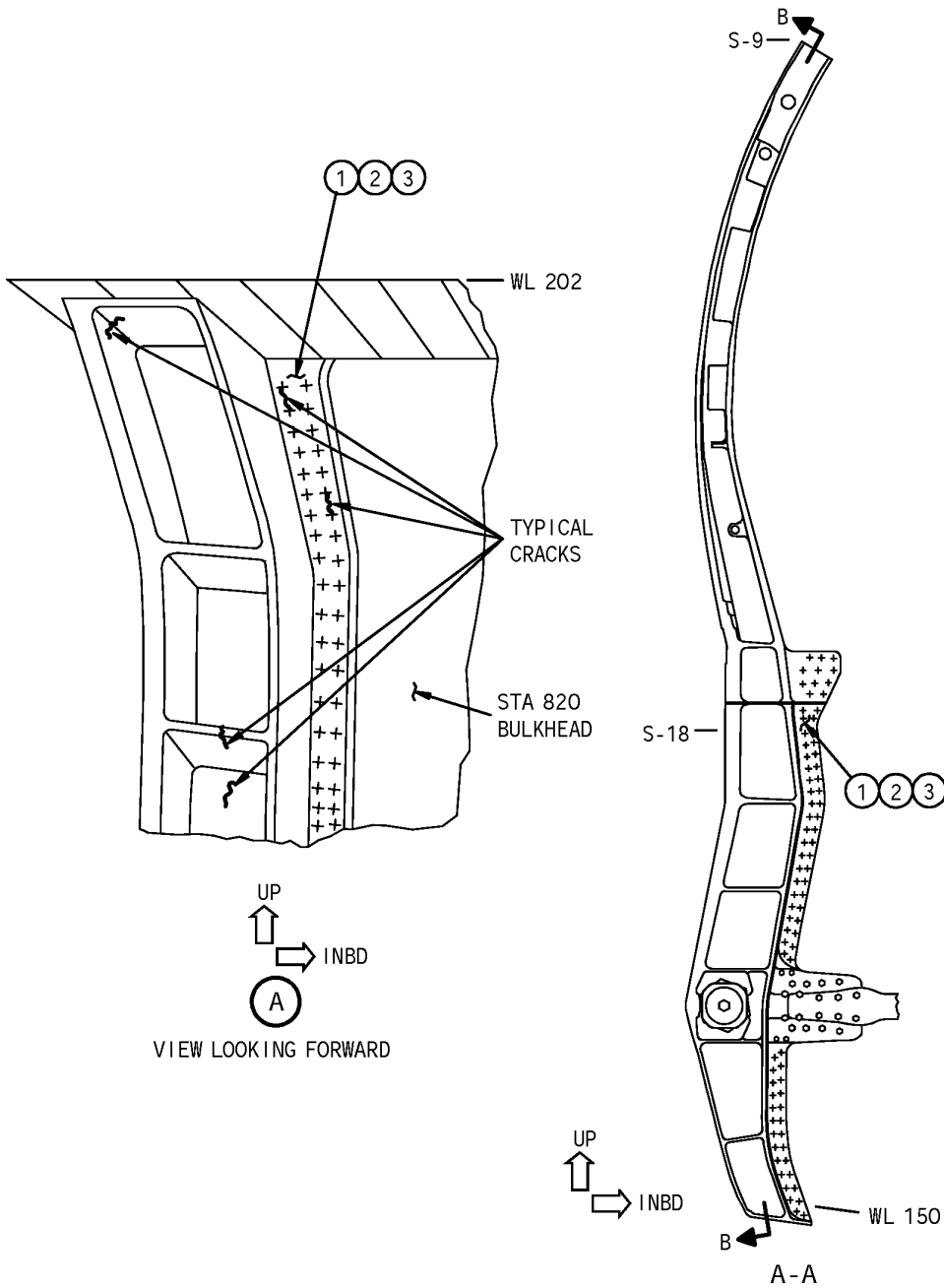
MAINT      RII/INSP

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FIGURE 5: GROUPS 1 & 2 - LEFT BODY TERMINAL FITTING INSPECTION - BODY STATION 820.  
(SHEET 1 OF 4)


<b>sabena</b> B707	Module: GENERAL	A/C Reg :	Check :	 <b>02F3000001</b> Page 13 of 25
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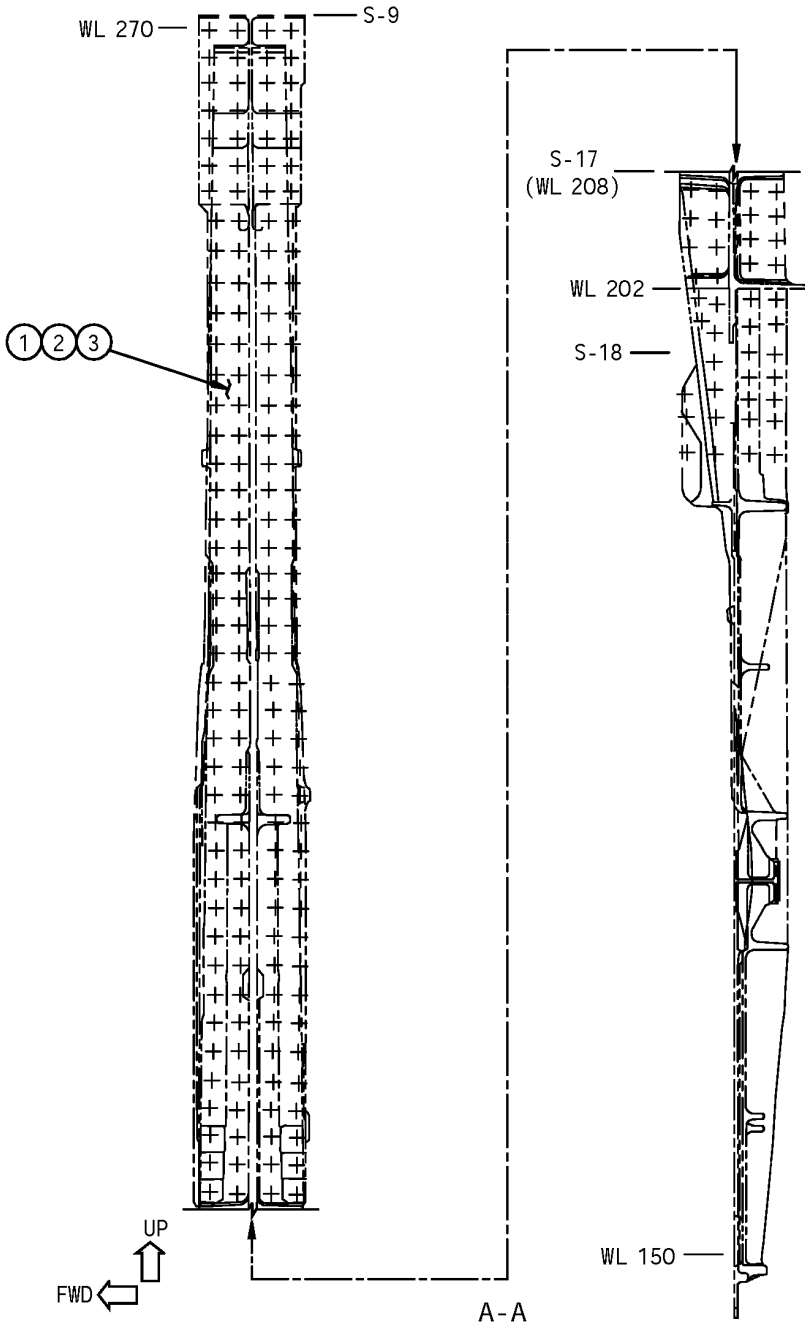


MAINT	RII/INSP

FIGURE 5: GROUPS 1 & 2 - LEFT BODY TERMINAL FITTING INSPECTION - BODY STATION 820.  
(SHEET 2 OF 4)


<b>sabena</b> B707	Module: GENERAL	A/C Reg :	Check :	 <b>02F3000001</b> Page 14 of 25
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FIGURE 5: GROUPS 1 & 2 - LEFT BODY TERMINAL FITTING INSPECTION - BODY STATION 820.  
(SHEET 3 OF 4)

<b>sabena</b> <b>B707</b>	Module: GENERAL	A/C Reg :	Check :	 <b>02F3000001</b> <b>Page 15 of 25</b>
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The step numbers shown below agree with the numbers shown in the circle symbols in the figure. The QTY numbers shown below are the number of parts necessary for one side of the airplane.

**MAINT      RII/INSP**

STEP	TASK	NAME	IDENTIFICATION	QTY	MORE DATA
1	Remove	Corrosion Inhibiting Compound	BMS 3-23, Type II	-	If present to enable detection of any crack or corrosion on the surface. Refer to SOPM 20-41-05 as an accepted procedure.
2	Inspect	Body Terminal Fitting	65-1903-1 or 65-1903-3, or 65-1903-5, or 50-6827-1, or 50-6827-3, or 50-6827-5, or 50-6827-7, or 50-6827-9, or 50-6827-11	1	Do a Detailed Inspection of the visible surfaces of the entire fitting, including webs, flanges and ribs for any crack or corrosion. Pay particular attention to fastener locations. Removal of fasteners or structure is not required. (a)
3	Apply	Corrosion Inhibiting Compound	BMS 3-23, Type II	-	To the entire fitting after inspection if no crack or corrosion is found. Refer to SOPM 20-41-05 as an accepted procedure.

(a) If there are existing repairs, do a Detailed Inspection of the repairs on the fitting for any crack or corrosion. Pay particular attention to fastener locations.

**FIGURE 5: LEFT BODY TERMINAL FITTING INSPECTION - BODY STATION 820.  
(SHEET 4 OF 4)**

<b>sabena</b> B707	Module: GENERAL	A/C Reg :	Check :	 <b>02F300001</b> Page 16 of 25
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FIGURE 6: GROUPS 1 & 2 - RIGHT BODY TERMINAL FITTING INSPECTION - BODY STATION 820.

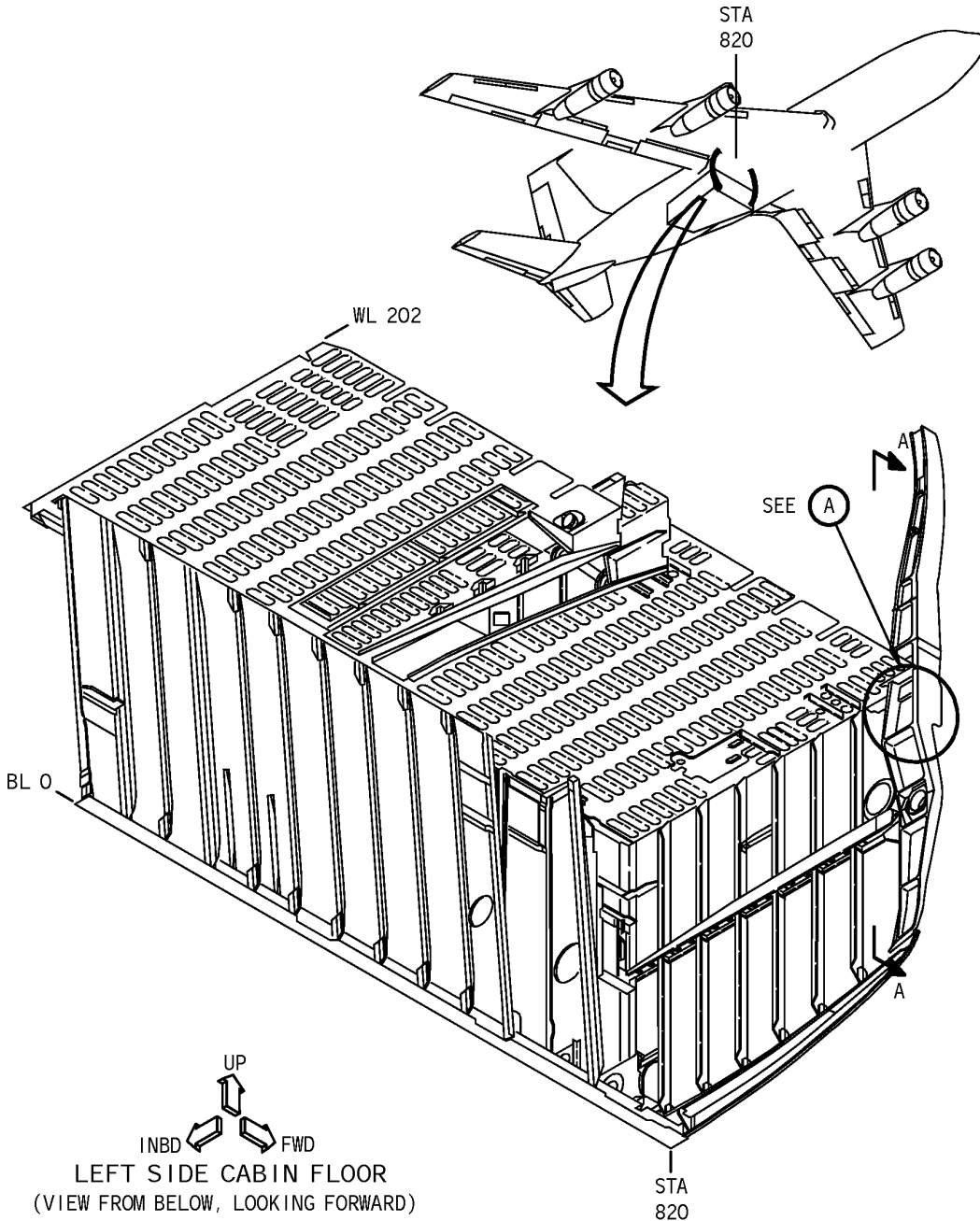

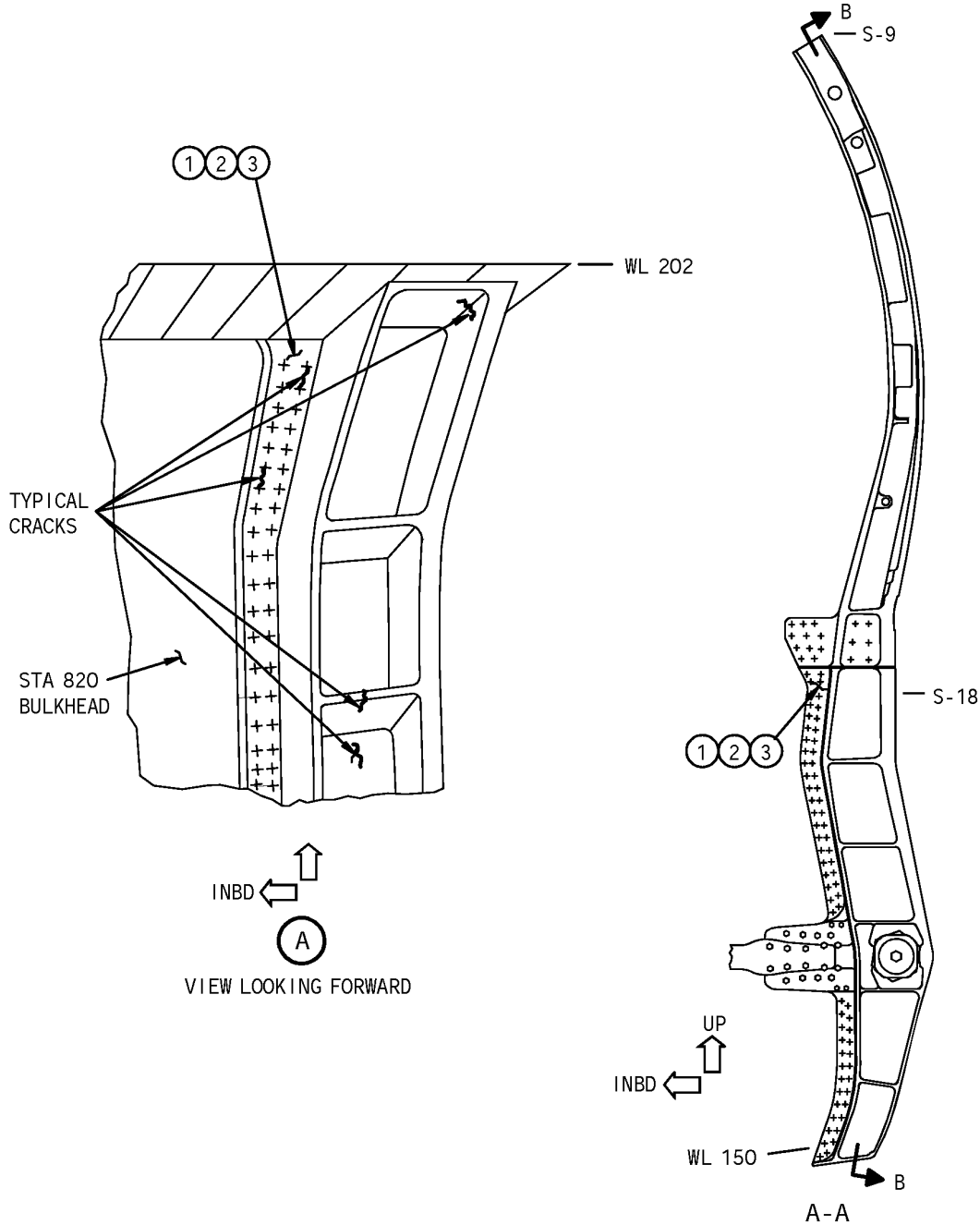


FIGURE 6: GROUPS 1 & 2 - RIGHT BODY TERMINAL FITTING INSPECTION - BODY STATION 820.  
(SHEET 1 OF 4)

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<b>sabena</b> <b>B707</b>	Module: GENERAL	A/C Reg :	Check :	 <b>02F3000001</b> <b>Page 17 of 25</b>
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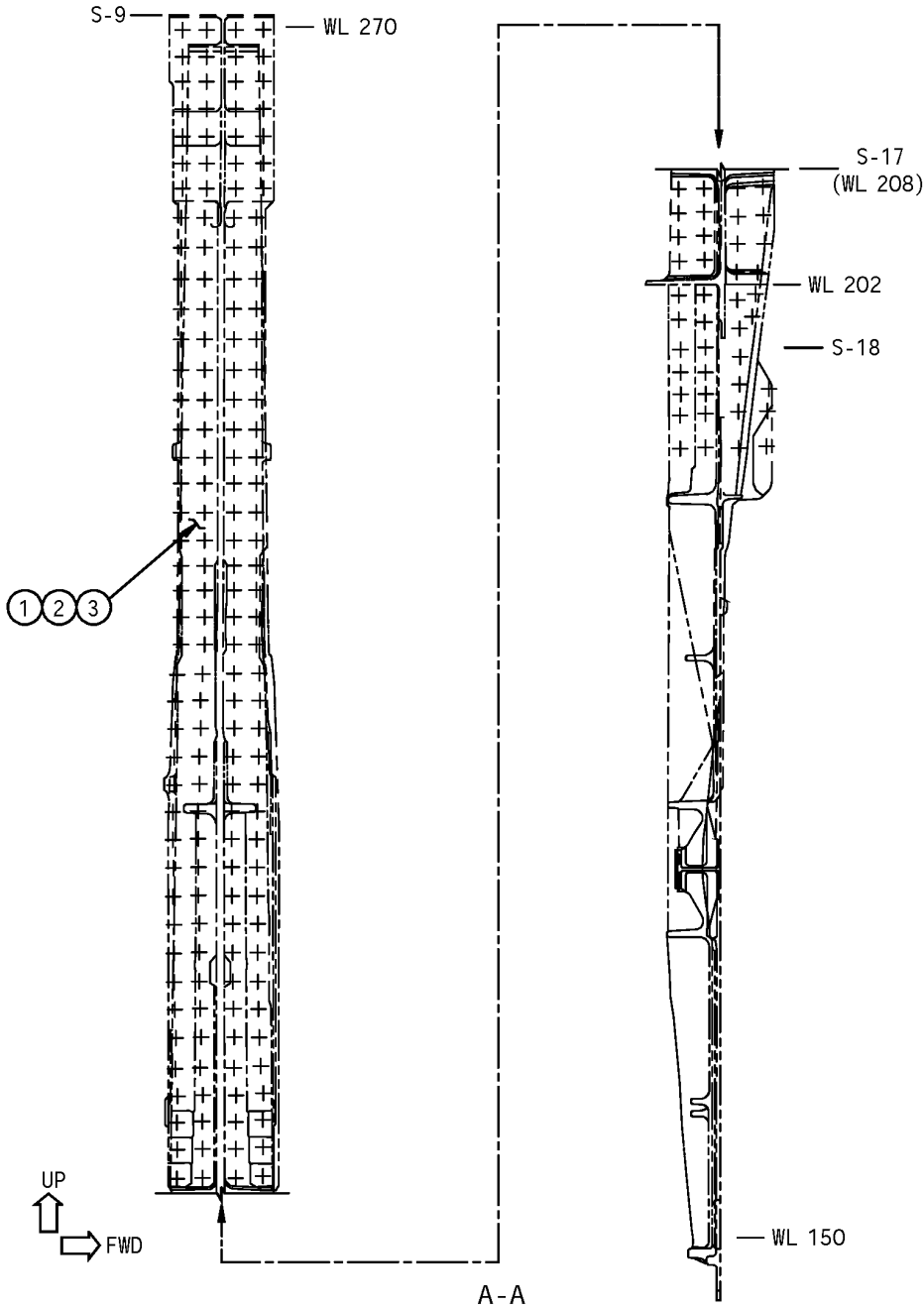


MAINT	RII/INSP

**FIGURE 6: GROUPS 1 & 2 - RIGHT BODY TERMINAL FITTING INSPECTION - BODY STATION 820. (SHEET 2 OF 4)**


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MAINT	RII/INSP

FIGURE 6: GROUPS 1 & 2 - RIGHT BODY TERMINAL FITTING INSPECTION - BODY STATION 820.  
(SHEET 3 OF 4)

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**AD 2009-18-10 BS600K & BS820 TERMINAL FITTING INSPECTION**


The step numbers shown below agree with the numbers shown in the circle symbols in the figure. The QTY numbers shown below are the number of parts necessary for one side of the airplane.

STEP	TASK	NAME	IDENTIFICATION	QTY	MORE DATA
1	Remove	Corrosion Inhibiting Compound	BMS 3-23, Type II	-	If present to enable detection of any crack or corrosion on the surface. Refer to SOPM 20-41-05 as an accepted procedure.
2	Inspect	Body Terminal Fitting	65-1903-2 or 65-1903-4, or 65-1903-6, or 50-6827-2, or 50-6827-4, or 50-6827-6, or 50-6827-8, or 50-6827-10, or 50-6827-12	1	Do a Detailed Inspection of the visible surfaces of the entire fitting, including webs, flanges and ribs for any crack or corrosion. Pay particular attention to fastener locations. Removal of fasteners or structure is not required. (a)
3	Apply	Corrosion Inhibiting Compound	BMS 3-23, Type II	-	To the entire fitting after inspection if no crack or corrosion is found. Refer to SOPM 20-41-05 as an accepted procedure.

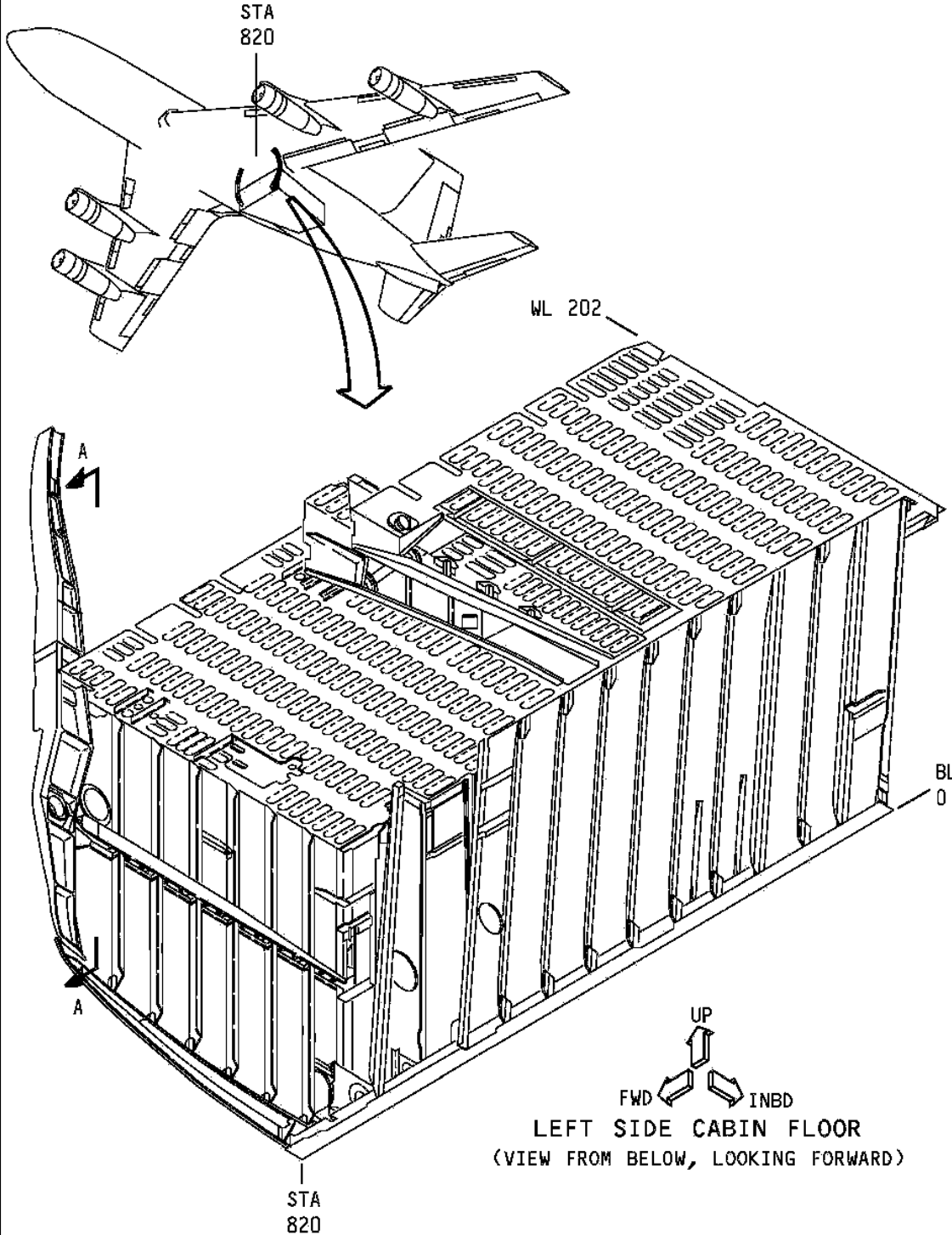
(a) If there are existing repairs, do a Detailed Inspection of the repairs on the fitting for any crack or corrosion. Pay particular attention to fastener locations.


**MAINT RII/INSP**

**FIGURE 6: RIGHT BODY TERMINAL FITTING INSPECTION - BODY STATION 820.  
(SHEET 4 OF 4)**

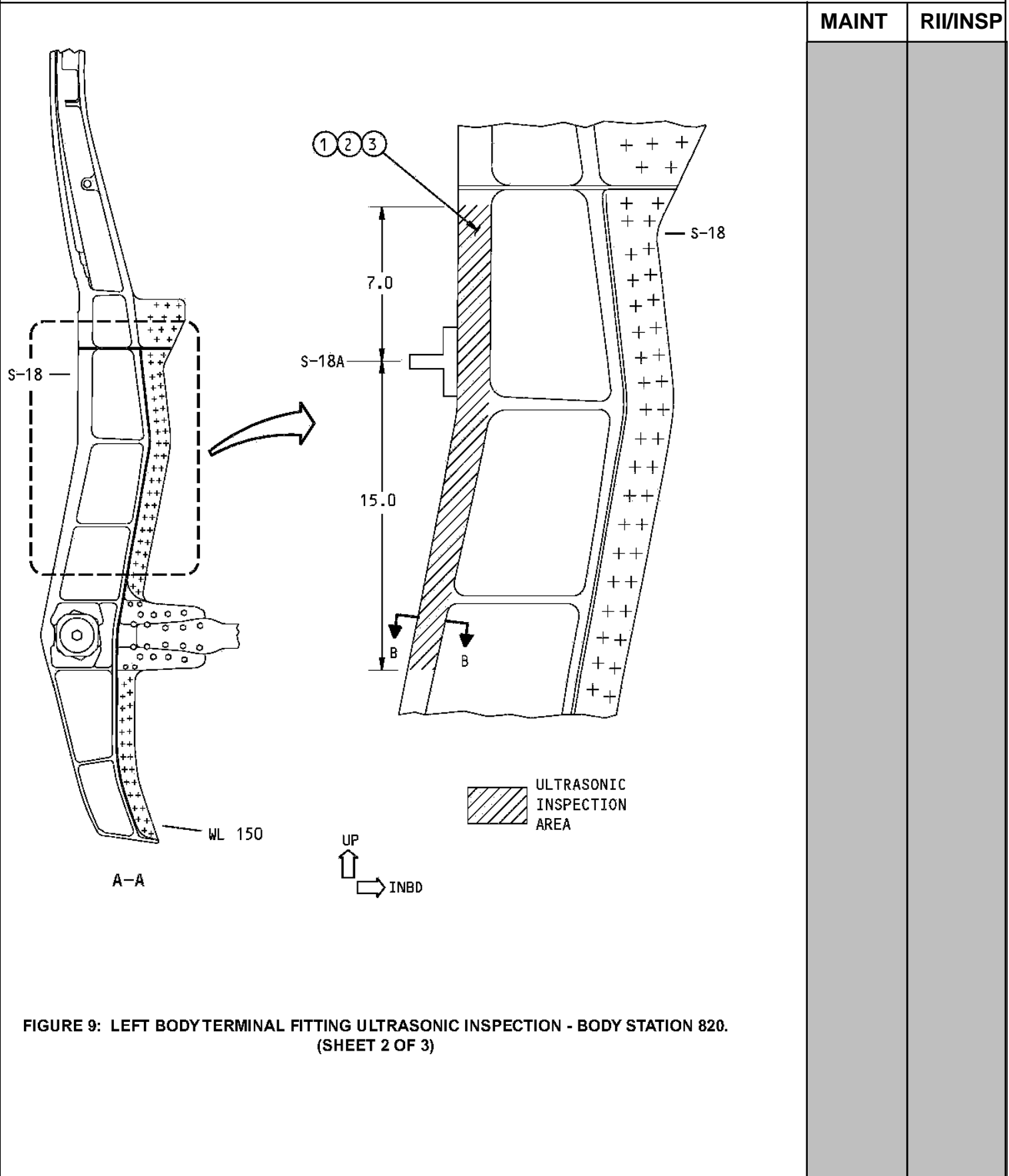
<b>sabena</b> <b>B707</b>	Module: GENERAL	A/C Reg :	Check :	 <b>02F3000001</b> <b>Page 20 of 25</b>
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	Type : STRUCT-INSP	Release Date: 21.05.2010		
Spec. : MECH. INSP				


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	MAINT	RII/INSP
 <p style="text-align: center;"> <b>FIGURE 9: LEFT BODY TERMINAL FITTING ULTRASONIC INSPECTION - BODY STATION 820.</b>  <b>(SHEET 1 OF 3)</b> </p>		

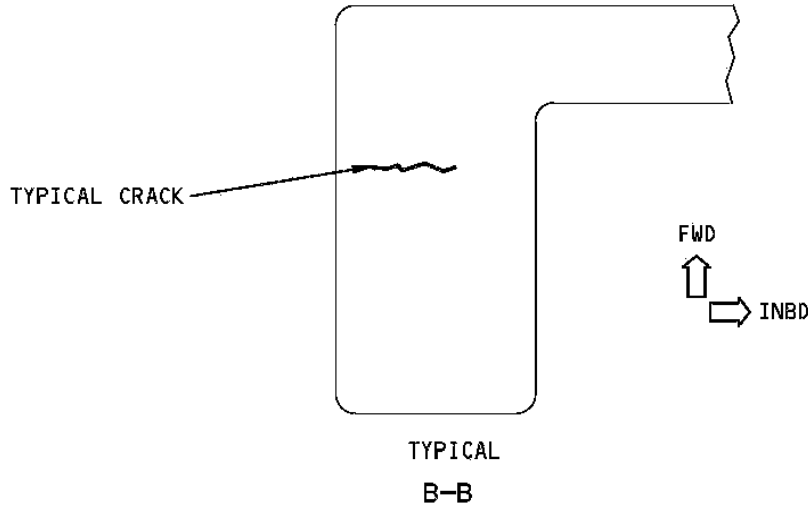
<b>sabena</b> <b>B707</b>	Module: GENERAL	A/C Reg :	Check :	 <b>02F3000001</b> <b>Page 21 of 25</b>
	Oper. : RT-MP HT	Issuer : A62165	Cert.St.: 50516	
	Type : STRUCT-INSP	Release Date: 21.05.2010		
Spec. : MECH. INSP				

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<b>sabena</b> <b>B707</b>	Module: GENERAL	A/C Reg :	Check :	 <b>02F3000001</b> <b>Page 22 of 25</b>
	Oper. : RT-MP HT			
	Type : STRUCT-INSP	Issuer : A62165	Cert.St.: 50516	
	Spec. : MECH. INSP	Release Date: 21.05.2010		

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1579244


The step numbers shown below agree with the numbers shown in the circle symbols in the figure. The QTY numbers shown below are the number of parts necessary for one side of the airplane.

STEP	TASK	NAME	IDENTIFICATION	QTY	MORE DATA
1	Remove	Corrosion Inhibiting Compound	BMS 3-23, Type II	-	If present, from the outer flange. Refer to SOPM 20-41-05 as an accepted procedure.
2	Inspect	Body Terminal Fitting	65-1903-1 or 65-1903-3, or 65-1903-5, or 50-6827-1, or 50-6827-3, or 50-6827-5, or 50-6827-7, or 50-6827-9, or 50-6827-11	1	Do an Ultrasonic Inspection of the entire outboard flange from 7 inches above Stringer 18A down to 15 inches below Stringer 18A for internal cracking. Determine the end locations of each crack that is found. (a) (b)
3	Apply	Corrosion Inhibiting Compound	BMS 3-23, Type II	-	To the outer flange if no crack or corrosion is found. Refer to SOPM 20-41-05 as an accepted procedure.

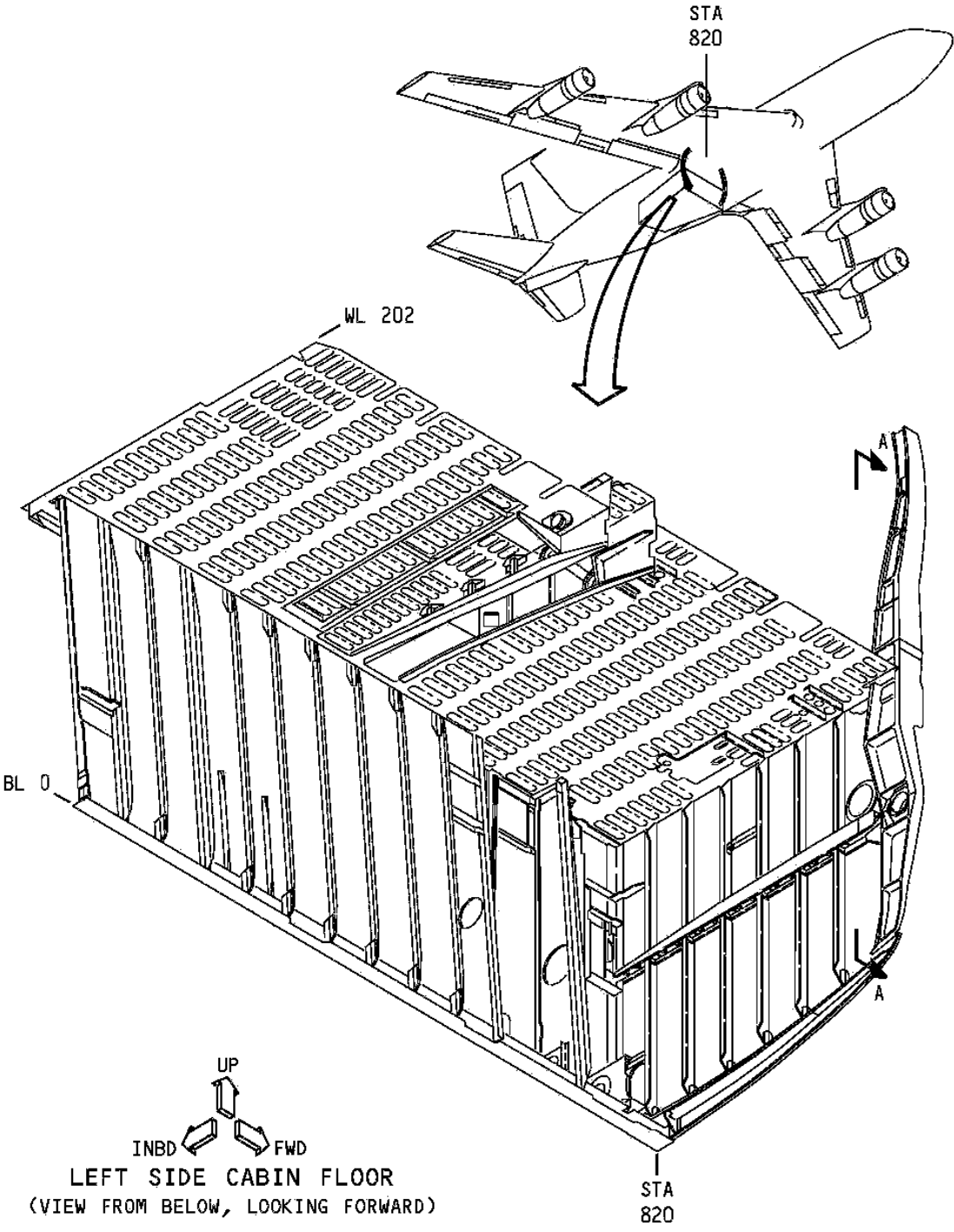
(a) Do the inspection as given in 707, 720 NDT Part 4, 53-10-07 Figure 1.


(b) 707, 720 NDT Part 4, 53-10-07 Figure 1 was intended for use in monitoring crack propagation, but can also be used for crack detection.

**FIGURE 9: LEFT BODY TERMINAL FITTING ULTRASONIC INSPECTION - BODY STATION 820.  
(SHEET 3 OF 3)**

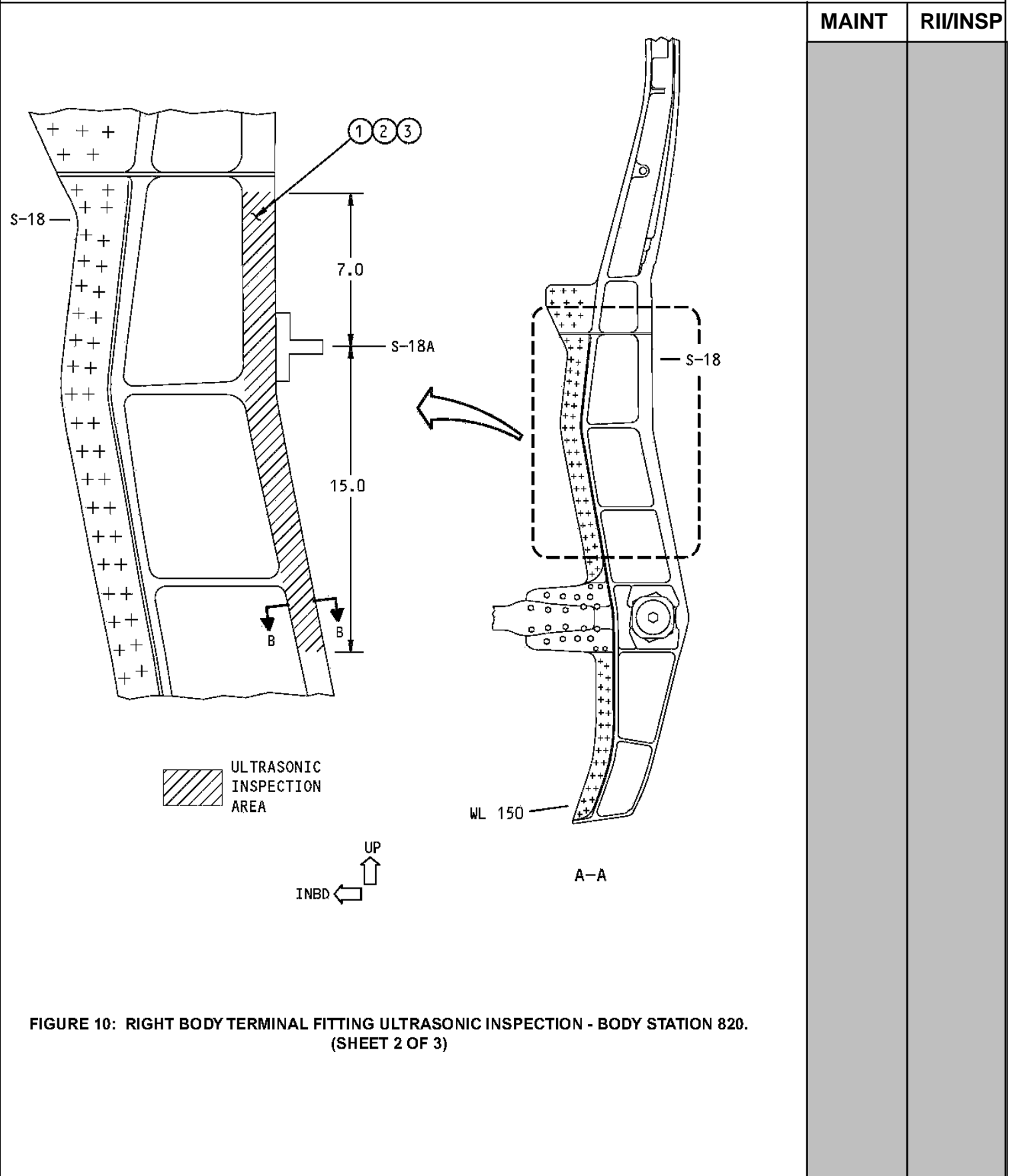
<b>sabena</b> B707	Module: GENERAL	A/C Reg :	Check :	 <b>02F3000001</b> Page 23 of 25
	Oper. : RT-MP HT	Issuer : A62165	Cert.St.: 50516	
	Type : STRUCT-INSP	Release Date: 21.05.2010		
Spec. : MECH. INSP				


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	MAINT	RII/INSP
 <p style="text-align: center;"> <b>LEFT SIDE CABIN FLOOR</b>  (VIEW FROM BELOW, LOOKING FORWARD) </p>		
<b>FIGURE 10: RIGHT BODY TERMINAL FITTING ULTRASONIC INSPECTION - BODY STATION 820.</b> (SHEET 1 OF 3)		

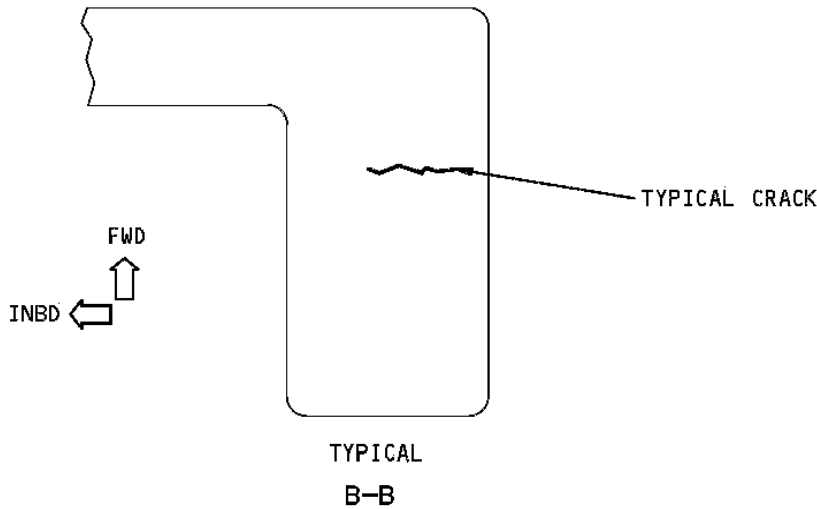
<b>sabena</b> B707	Module: GENERAL	A/C Reg :	Check :	 <b>02F3000001</b> Page 24 of 25
	Oper. : RT-MP HT	Issuer : A62165	Cert.St.: 50516	
	Type : STRUCT-INSP	Release Date: 21.05.2010		
Spec. : MECH. INSP				

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<b>sabena</b> <b>B707</b>	Module: GENERAL	A/C Reg :	Check :	 <b>02F3000001</b> <b>Page 25 of 25</b>
	Oper. : RT-MP HT	Issuer : A62165	Cert.St.: 50516	
	Type : STRUCT-INSP	Release Date: 21.05.2010		
Spec. : MECH. INSP				

**AD 2009-18-10 BS600K & BS820 TERMINAL FITTING INSPECTION**



1579246

The step numbers shown below agree with the numbers shown in the circle symbols in the figure. The QTY numbers shown below are the number of parts necessary for one side of the airplane.

STEP	TASK	NAME	IDENTIFICATION	QTY	MORE DATA
1	Remove	Corrosion Inhibiting Compound	BMS 3-23, Type II	-	If present, from the outer flange. Refer to SOPM 20-41-05 as an accepted procedure.
2	Inspect	Body Terminal Fitting	65-1903-2 or 65-1903-4, or 65-1903-6, or 50-6827-2, or 50-6827-4, or 50-6827-6, or 50-6827-8, or 50-6827-10, or 50-6827-12	1	Do an Ultrasonic Inspection of the entire outboard flange from 7 inches above Stringer 18A down to 15 inches below Stringer 18A for internal cracking. Determine the end locations of each crack that is found. (a) (b)
3	Apply	Corrosion Inhibiting Compound	BMS 3-23, Type II	-	To the outer flange if no crack or corrosion is found. Refer to SOPM 20-41-05 as an accepted procedure.
(a) Do the inspection as given in 707, 720 NDT Part 4, 53-10-07 Figure 1.					
(b) 707, 720 NDT Part 4, 53-10-07 Figure 1 was intended for use in monitoring crack propagation, but can also be used for crack detection.					

**FIGURE 10: RIGHT BODY TERMINAL FITTING ULTRASONIC INSPECTION - BODY STATION 820.  
(SHEET 3 OF 3)**