CHANGE LINK CLEVIS P/N 204-011-136-1, FSN 5340-00-839-3934, TB 55-1520-242-20-6 (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, 150Kw 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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FINAL SECTION OF 02

(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 36 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 BY 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
SDSCE-0MT
ATTN - LEROY PATTON (AV A61-2208)
SUBJECT - SAFETY OF FLIGHT SUPPLEMENTAL INSPECTION CRITERIA FOR PITCH
SCHEMATIC LINK CLEVIS PN 204-081-1-134-1. FSH 5340-08-039-3934, TB
1528-242-20-8 (UH-1-B4-07). REFERENCE MESSAGE UH-1-B4-06

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-B4-06.

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 EXIT SIDE, AND .005 INCH LEAD SCREEN ON X-RAY BEAM
       ENTRANCE SIDE.
C. INSPECTION PROCEDURE -...
MILLIAMPERAGE, 7.0
EXPOSURE TIME, 3.0 MINUTES

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 VIA 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 3X MAGNIFIER, ANY
INDICATION OF A CIRCUMFERENTIAL CRACK IS CAUSE FOR REJECTION.
PARTICULAR ATTENTION SHALL BE GIVEN TO THE BOTTOM OF THE DRILLED HOLE
WHERE CROSS SECTIOANL AREA CHANGES.

4. MARKING INSTRUCTIONS - FOR ACCEPTABLE PARTS VIBRO ETCH A CIRCLED
/// 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-DMT
ATTN - LEROY PATTON (AY 861-220A)
CORPUS CHRISTI, TEXAS 78419

2. REPORTING AND RECORDING - NONE

7. FOREIGN MILITARY SALES/FMS RECIPIENTS REQUIRING CLARIFICATION OF
THIS MESSAGE SHOULD CONTACT USAVSCON, DRSAY-I, CWO KYLE STEPHENSON,
AUTOSYN 693-2813 OR COMMERICAL 314-263-2813.
AVSCON TECHNICAL POINT OF CONTACT IS MR. MIKE BEHNEK, DRSAY-9E,
AUTOSYN 693-1525 OR COMMERICAL 314-263-1525.
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