DOCKET NO.: SA-515 EXHIBIT NO. 11L

NATIONAL TRANSPORTATION SAFETY BOARD WASHINGTON, D.C.

MAINTENANCE GROUP CHAIRMAN'S FACTUAL REPORT

ATTACHMENT 21

PRATT & WHITNEY JT8D ENGINE MANUAL FRONT COMPRESSOR GROUP 1ST STAGE HUB CLEANING SPOP 19 PLASTIC BEAD

(3 PAGES)

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Pratt & Whitney

JT

FRONT

JTSD ENGINE MANUAL (PN 773128)

FRONT COMPRESSOR GROUP - CLEANING-01

	<u></u>	
Part	Clean by spor	Part
Subtask 72-33-31-12-003		72-33-35
Hub, 1st Stage (Titanium)		Ph Stage
HID, THE Stage (11 contra)	16	(10 Coat)
Subtask 72-33-31-12-009		
Hub, 1st Stage (Titanium)	19	72-33-5 3
HID, The Bedge (11countain)		1st Stag
Subtask 72-33-35-11-001		Tur Vanes
Hub, 4th Stage (Steel)	3	19
(Nickel Cadmium Plate		
Or PWA 110 Coat)		72-33-5
02 11122 250 20-07		ist Sta
Subtask 72-33-35-11-007		Vanes
Hub, 4th Stage (Steel)	203	
(Nickel Cadmium Plate)		72-33-5:
		1.5 Star
Subtask 72-33-35-11-014		
Hub, 4th Stage (Steel)	252	
(Nickel Cadmium Plate)		72-33-5
(1.5 Stac
Subtask 72-33-35-11-039		F 70 33 5
Hub, 4th Stage (Steel)	257	72-33-5
(Nickel Cadmium Plate)		2nd Sta
Subtask 72-33-35-11-041		72-33-5
Hub, 4th Stage (Steel)	209	2nd Sta
(Nickel Cadmium Plate		See Star
Or PWA 110 Coat)		
		3rd Sta
Subtask 72-33-35-12-002		2 2 Ca
Hub, 4th Stage (Steel)	9	\$* \$-
(Nickel Cadmium Plate)		72-33-5
		3rd Sta
Subtask 72-33-35-12-009	19	
Hub, 4th Stage (Steel)		92-33-5
(Nickel Cadmium Plate)		4th Sta
		Cadmium
Subtask 72-33-35-12-010	10	
Hub, 4th Stage (Steel)		rubbe:
(Nickel Cadmium Plate)		POP 209
Subtask 72-33-35-11-001	3	72-33-5
Hub, 4th Stage (Steel)		och Sta
(PWA 110 Coat)		Cadmium
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Subtask 72-33-35-11-941	209	inppe
Hub, 4th Stage (Steel)		Ob 508
(PWA 110 Coat)		
		2

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Pratt & Whitney OVERHAUL STANDARD PRACTICES MANUAL

CLEANING PROCEDURES

SPOP 19 - DRY PLASTIC BLAST (PRESSURE-TYPE MACHINE OR SUCTION-TYPE MACHINE)

- NOTE: This procedure is for removal of RTV rubber, PWA 60 graphite R varnish, PWA 474 antigalling compound, and PWA 544 sealant from compressor blades, disks, and hubs. Operators who use R SPOP 19 to remove antigallant and RTV rubber from titanium R blades and disks will find the use of SPOP 18 before SPOP 19 R will be more effective. R For the removal of paint and varnish, refer to the specific repair in Engine Manual and CAUTION before Operation No. 4. The removal of large pieces of RTV with a razor or sharp R plastic scraper will increase the efficiency of the blasting R process. R Generally pressure-type machines are more effective than suction-type machines. R Oper. Description/Operation No. R 1 Degrease with SPOP 209 to prevent contamination of the media. R R R Mask, as necessary, so that material will not get caught 2 inside the part. Mask plasma coated airseals. R 3 Set machine air pressure, as follows:
 - b. For suction-type machine: 60 80 psi.

a. For pressure-type machine: 30 - 40 psi.

WARNING: REFER TO THE MANUFACTURER'S MATERIAL SAFETY DATA SHEETS FOR CONSUMABLE MATERIAL'S INFORMATION SUCH AS: HAZARDOUS INGREDIENTS, PHYSICAL/CHEMICAL CHARACTERISTICS, VIRE, EXPLOSION, REACTIVITY, HEALTH HAZARD DATA, PRECAUTIONS FOR SAFE HANDLING, USE AND CONTROL MEASURES.

> STANDARD PRACTICES 70-21-00

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Pratt & Whitney OVERHAUL STANDARD PRACTICES MANUAL

CLEANING PROCEDURES

SPOP 19 - DRY PLASTIC BLAST (PRESSURE-TYPE MACHINE OR SUCTION-TYPE MACHINE) (Continued)

Oper.

Description/Operation No.

> CAUTION: PLASTIC BLAST WILL DEGRADS THE ANODIZED COATING ON ALUMINUM. IF SPOP 19 IS USED ON ALUMINUM, SURFACE TREATMENT BY SPOP 42 WILL BE NECESSARY.

> > IF SPOP 19 IS USED ON MAGNESIUM, THE CHROMATE CONVERSION COATING MUST BE REPLACED BY SPOP 41.

- Blast with plastic blast media (PMC 3300, 3304, 3306 or R SPMC 167), as necessary. There must be a 3 - 4 inch nozzle-R to-part distance at a 45 - 60 degree angle to the work surface.
 - 5 Blow clean with air. If necessary, clean by SPOP 209 and pressure spray rinse with hot water to remove any remaining plastic media.
 - 6 Remove masking.
 - 7 Apply corrosion inhibitor with SPOP 5. as necessary.

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