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)

	Part	Clean by SPO
	Subtask 72-33-31-12-003 Hub, 1st Stage (Titanium)	16
	Subtask 72-33-31-12-009 Hub, 1st Stage (Titanium)	19
	Subtask 72-33-35-11-001 Hub, 4th Stage (Steel) (Nickel Cadmium Plate Or PWA 110 Coat)	3
	Subtask 72-33-35-11-007 Hub, 4th Stage (Steel) (Nickel Cadmium Plate)	203
	Subtask 72-33-35-11-014 Hub, 4th Stage (Steel) (Nickel Cadmium Plate)	252
	Subtask 72-33-35-11-039 Hub, 4th Stage (Steel) (Nickel Cadmium Plate)	257
	Subtask 72-33-35-11-041 Hub, 4th Stage (Steel) (Nickel Cadmium Plate Or PWA 110 Coat)	209
	Subtask 72-33-35-12-002 Hub, 4th Stage (Steel) (Nickel Cadmium Plate)	9
	Subtask 72-33-35-12-009 Hub, 4th Stage (Steel) (Nickel Cadmium Plate)	19
	Subtask 72-33-35-12-010 Hub, 4th Stage (Steel) (Nickel Cadmium Plate)	10
R R R	Subtask 72-33-35-11-001 Hub, 4th Stage (Steel) (PWA 110 Coat)	3
R R R	Subtask 72-33-35-11-041 Hub, 4th Stage (Steel) (PWA 110 Coat)	209

CLEANING PROCEDURES

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

R NOTE: This procedure is for removal of RTV rubber, PWA 60 graphite varnish, PWA 474 antigalling compound, and PWA 544 sealant
R 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.

For the removal of paint and varnish, refer to the specific repair in Engine Manual and CAUTION before Operation No. 4.

R The removal of large pieces of RTV with a razor or sharp
R plastic scraper will increase the efficiency of the blasting process.

R Generally pressure-type machines are more effective than
R suction-type machines.

Oper. No.	Description/Operation
R 1	Degrease with SPOP 209 to prevent contamination of the media.
R 2	Mask, as necessary, so that material will not get caught inside the part. Mask plasma coated airseals.
3	Set machine air pressure, as follows: a. For pressure-type machine: 30 - 40 psi. b. For suction-type machine: 60 - 80 psi.

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

(2)

CLEANING PROCEDURES

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

Oper. No.	Description/Operation
	CAUTION: PLASTIC BLAST WILL DEGRADE 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.
R R 4	Blast with plastic blast media (PMC 3300, 3304, 3306 or SPMC 167), as necessary. There must be a 3 - 4 inch nozzle-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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