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NATIONAL TRANSPORTATION SAFETY BOARD
WASHINGTON, D.C.

ATTACHMENT 22

DELTA AIR LINES PROCESS STANDARD FOR PAST PREPARATION AND INSPECTION, NO. 900-6-3, DATED OCTOBER 1, 1995

(2 PAGES)

PROCESS STANDARD

DELTA AIR LINES

4. E. (3) Water wash parts using coarse water spray at appx. 30 psi. Hold the nozzle appx. 12" f and at an angle to the surface to remove excess background penetrant, flushing entrap areas such as undercuts, blind holes and oilways. Maximum rinse time is 45 seconds. Water temperature should not exceed 100°F.

(4) Observe parts during rinsing with a 100 watt ultraviolet light to determine that excess penetrant has been removed. Rinsing is considered complete when ultraviolet light doe not indicate the presence of fluorescence on the part.

(5) Position parts to allow excess water to drain and if necessary, rotate or shake the part. Remove entrapped water by siphoning, by blowing with shop air at less than 170 kpa (2 psi) or by blotting with a clean, lint free towel.

(6) Dry the parts by placing them in a circulating hot air dryer. Do not allow parts to remain in dryer any longer than necessary to remove moisture. A temperature range of 140°-160°F is recommended; oven temperature not to exceed 160°F.

(7) Immediately after drying, dust area to be inspected with powder developer (DD2) assuring complete coverage of area to be inspected with a light dusting of powder.

(8) After dusting allow part to stand for not less than 15 minutes to allow sufficient development.

(9) Parts must be inspected within 2 hrs. of development. If part is not inspected within 2 hrs., clean it completely and reprocess. Consider indications found after one hour to be questionable.

(10) Examine area to be inspected under ultraviolet light within one hour after applying developer.

NOTE: Inspectors must accustom their eyes to darkness of the inspection booth for a period of 1 to 3 minutes if entering from a surrounding shop area. Eye adaptation may require 5 minutes or longer if entering from outside in bright sun. The use of visual aids (mirrors, boroscope or other suitable equipment) is required to examine areas not readily visible due to geometric configuration. Interpret penetrant indications per Section 4.G.

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FLUORESCENT PENETRANT INSPECTION

9. Inspection Controls

A. Make an inspection of the parts to the Engine Manual acceptance standards.

B. If there are more than four hours between application of dry developer and inspection or more than one hour between application of nonaqueous developer, then clean and process the part(s) again.

CAUTION: DURING INSPECTION, DO NOT WEAR EYE GLASSES THAT HAVE LENSES WHICH DARKEN WHEN THEY ARE IN THE UV LIGHT.

C. The inspection area for FPI must have protection from white light. White light must not be more than 2 footcandles at the inspection surface of the part.

D. Start the inspection not less than one minute after you enter the dark inspection room. The eyes must first adjust to the dark inspection area.

E. Do not do continuous visual inspection for more than two hours at one time. Permit the eyes to rest for at least 15 minutes. There must be no high visual concentration during this time. Inspectors must not face each other's UV lights during inspection.

F. Use visual aids (such as, dental mirrors and borescopes) during inspections of surfaces that are difficult to see by direct vision.

NOTE: Position UV borescope probe ends from the inspection surface so that you get optimum light intensity as well as clarity of focus.

G. Position UV light to avoid glare during the inspection.

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To Frank Gattolini	From Lee Chamt
Co. NTSB	Dept./Sta. Delta Air Lines
Dept./Sta.	Phone [redacted]
Fax # [redacted]	Fax # [redacted]

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