

W/O EXP
M. Harding



ADP No. HUU 12400

SI/Hunter/124

3 December 1975

From: CENTRAL DEFECT AUTHORITY

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London WC2H 8LD

A SI/HUNTER/124
(SUPERSEDING SI/HUNTER/118B)
MAINPLANE FITTING: UNDERCARRIAGE PIVOT GROUP: PORT AND STARBOARD:
CRACKING

B 1 Hunter, all Marks.

2 Hunter Mainplanes and Mainplane Fittings, Undercarriage Pivot Group,
Port Pt No E174345 (Ref 26FX/6098065), and Starboard, Pt No E174346 (Ref
26FX/6098066), held as spare or in store.

C Cracking has occurred in the port and starboard, undercarriage pivot group, mainplane fittings around the circumference of one of the machined faces into which the bearing-cap retraining studs are screwed. Examination of defective fittings has established that the cracks were due to static loading, and it is considered that they resulted from heavy landings. There was, however, some evidence of the onset of fatigue originating from two points of high stress concentration and STI/HUNTER/375A was issued to eliminate this possibility with the removal of a small amount of material from these points. Following a recent case where cracking was found visually, extending $2\frac{1}{2}$ inches along the inboard web, an area not covered by CSDE/HUNTER/EDD4 (RAF), NATEC/HUNTER/EDD/3 (RN) technique, an ultrasonic technique has been developed for examination in the area of the initiation points and extended the scope of the eddy current technique to include the inboard web. It is considered prudent to introduce the ultrasonic technique in conjunction with the extended CSDE/HUNTER/EDD4A (RAF), NATEC/HUNTER/EDD3A (RN) examination and bring forward the embodiment point of STI/HUNTER/375A if outstanding.

D 1 a PART A

Within 3 months of receipt of the specialist ultrasonic equipment and subsequently in accordance with the attached NDT Examination Flow Chart.

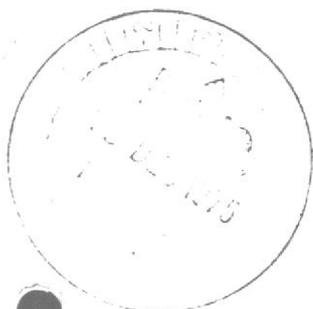
PART B

After every heavy landing and subsequently in accordance with the attached NDT Examination Flow Chart.

b PART A

(1) Examine the Mainplane Fittings, Undercarriage Pivot Group, Port, Pt No. E174345 (Ref 26FX/6098065) and Starboard, Pt No. E174346 (Ref 26FX/6098066), for cracks using Technique CSDE/HUNTER/ULT/9 (RAF), NATEC/HUNTER/ULT/4 (RN)

(2) Refer to the attached NDT Examination Flow Chart, and satisfy the requirements of the flow chart on both port and starboard fittings dependent upon the results of the ultrasonic examination carried out at para D1 b (1) above.



Note (1) Where no evidence of cracking is found on either port, or starboard fitting during this ultrasonic examination and the subsequent examination at next Minor Servicing the embodiment point for STI/HUNTER/375A is brought forward to the Minor on pre-STI standard aircraft.

Note (2) Where on embodiment of STI/HUNTER/375A the fitting is found satisfactory "STI/HUNTER/375A" is to be marked on the fitting in 0.5 inch letters on an area not covered by the CSDE/HUNTER/EDD4A(RAF), NATEC/HUNTER/EDB3A(RN) technique using Lacquer Opaque Yellow (Ref 33B/9429181). Retrospective marking on post STI/HUNTER/375A fittings found satisfactory should also be made.

PART B

(3) Where the heavy landing occurs prior to the initial application of this Instruction, as detailed in PART A, examination is to be undertaken in accordance with PART A of this Instruction.

(4) Where the heavy landing occurs following the initial application of this Instruction the examination is to be carried out on both fittings using the Technique called for by the NDT Examination Flow Chart following the last examination carried out.

c 1 Man-hour (Initial examination only).

2 a Before installation or issue.

b Satisfy this Instruction and STI/HUNTER/375A.

E Record on F720, F727, F4801, F4805 (RAF) or in accordance with AP(N) 140 Article 2213 (RN).

F Report by F760 in accordance with the attached NDT examination flow chart.

G 1 Superseding SI/HUNTER/118B.

2 Replacement fittings (Mod 1361) will require examination in accordance with PART A of this Instruction.

H 1 Nil.

2 No.

Issued on behalf of
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DEA for MOD(AFD)
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and
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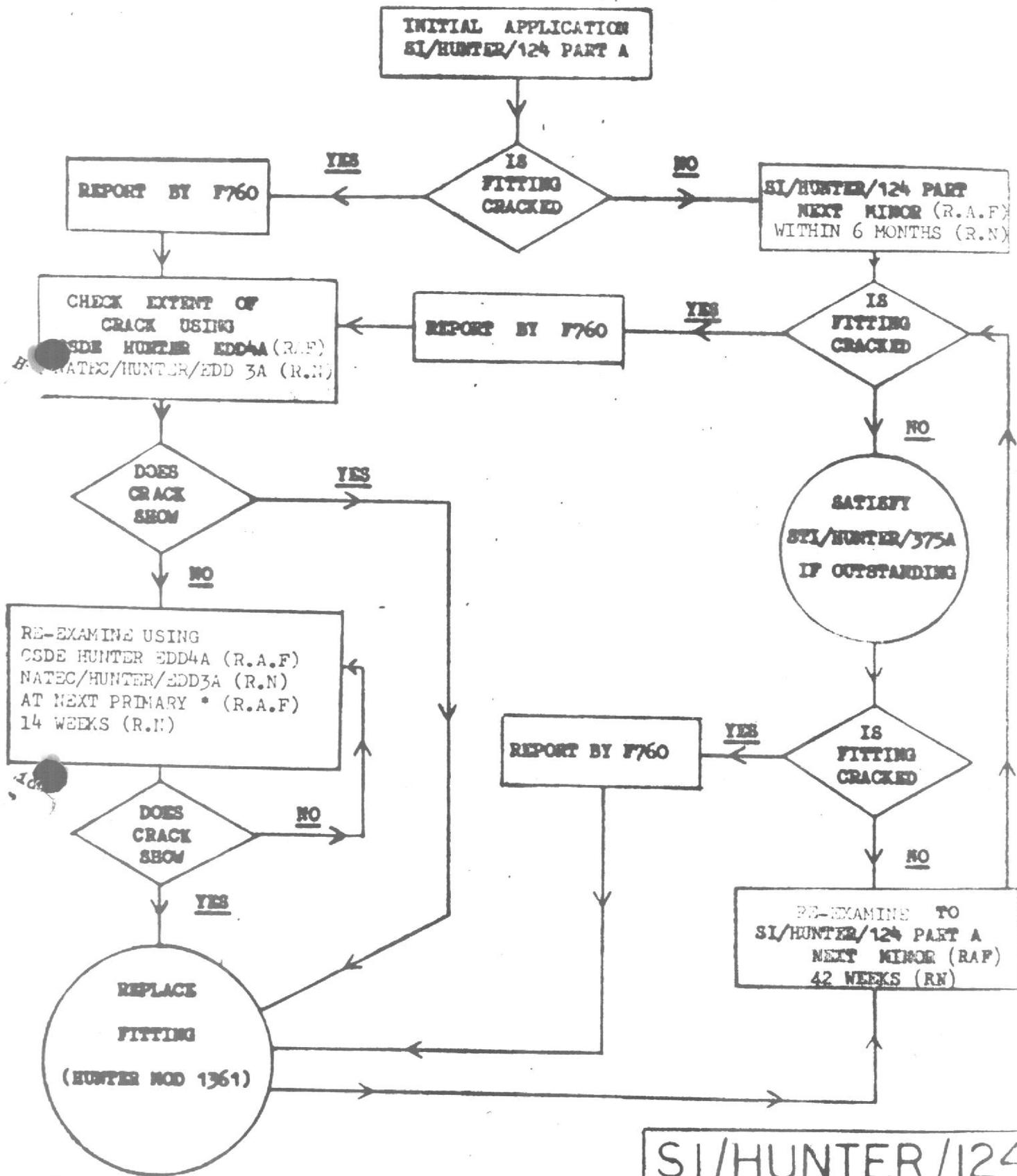


(D T SHARWOOD) CDA(M)5
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M4/864712

HUNTER - ALL MARKS - MAINPLANE FITTINGS -

U/C PIVOT GROUP PORT & STARBOARD



SI/HUNTER/124
NDT EXAMINATION
FLOW CHART

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