



737
NON-DESTRUCTIVE TEST MANUAL

PART 4 - ULTRASONIC

TABLE OF CONTENTS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>
<u>FLIGHT CONTROLS</u>	
GENERAL	
CHROME PLATE CHECK OF THE RUDDER, ELEVATOR AND AILERON PCU MANIFOLD BORES	27-00-01
<u>FUEL</u>	
STORAGE	
AUXILIARY FUEL TANK BOND INSPECTION	28-10-01
AUXILIARY FUEL TANK BOND INSPECTION - INTERNAL AND EXTERNAL SURFACES	28-10-02
<u>LANDING GEAR</u>	
MAIN GEAR	
MAIN LANDING GEAR - UPPER TORSION LINK PIN	32-10-01
MAIN LANDING GEAR ACTUATOR BEAM ARM	32-10-02
INSPECTION OF THE ACTUATOR BEAM ARM OF THE MAIN LANDING GEAR WITH A PAINTBRUSH TYPE TRANSDUCER	32-10-03
MAIN LANDING GEAR ACTUATOR BEAM ARM	32-10-04
NOSE GEAR	
NOSE LANDING GEAR - UPPER AND LOWER TORSION LINKS APEX	32-20-01
<u>STRUCTURES</u>	
GENERAL/COMPOSITE	
STRUCTURES GENERAL	51-00-00
Procedure 1 - FASTENER INSPECTION	
Procedure 2 - THICKNESS MEASUREMENT - A-SCAN INSTRUMENT WITH DIGITAL THICKNESS DISPLAY	
Procedure 3 - THICKNESS MEASUREMENT - DIGITAL DISPLAY INSTRUMENT	
PULSE-ECHO INSPECTION OF LAMINATED STRUCTURES	51-00-01
HONEYCOMB AND LAMINATE STRUCTURE THROUGH-TRANSMISSION INSPECTION	51-00-02
DETECTION OF WATER IN HONEYCOMB	51-00-03
BONDLINE DELAMINATION INSPECTION IN COMPOSITE HONEYCOMB STRUCTURE	51-00-04
BONDTEST INSPECTION OF HONEYCOMB STRUCTURE AND METAL-TO-METAL SKIN STRUCTURE	51-00-05

PART 4 FRONTMATTER
TABLE OF CONTENTS

Page 1

Nov 15/2015

D6-37239

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details



737
NON-DESTRUCTIVE TEST MANUAL

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>
HONEYCOMB AND LAMINATE STRUCTURE - AIR COUPLED THROUGH-TRANSMISSION INSPECTION	51-00-06
GENERAL	
BONDTEST INSPECTION OF METAL BONDED PARTS AND NON-METAL LAMINATES	51-40-00
Procedure 1 - BONDED SKIN AND DOUBLER INSPECTIONS	
<u>DOORS</u>	
PASSENGER/CREW	
FORWARD ENTRY DOOR UPPER HINGE ARM	52-10-01
AFT CARGO DOOR FRAMES	52-10-02
<u>FUSELAGE</u>	
MAIN FRAME	
FORWARD FLANGE OF THE OUTBOARD CHORD AT THE INTERSECTION OF STATION 727 AND STRINGER S-18A	53-10-01
BS 178 PRESSURE WEB INSPECTION	53-10-02
PRESSURE WEB INSPECTION AT STATION 227.8 OF THE NOSE WHEEL WELL	53-10-03
FRAME WEB CRACK AT STATION 303.9 AND S-16L	53-10-04
FRAME WEB AND INNER CHORD AT WL 201 OF THE STA 727 BULKHEAD	53-10-05
FORWARD CARGO DOOR SURROUND - FORWARD AND AFT EDGE FRAMES AT STA 440 AND 492.4	53-10-06
FORWARD CARGO DOOR SURROUND - BEAR STRAP AT S-24R, BS 440 AND BS 492.4	53-10-07
AFT CARGO DOOR SURROUND - FORWARD AND AFT EDGE FRAMES AT BS 794.37 AND BS 847	53-10-08
FLANGE AND WEB OF THE FRAME INNER CHORD AT BS 727 AND WL 201	53-10-09
OVERWING EMERGENCY EXIT CUTOUT - OUTER CHORD OF THE EDGE FRAME	53-10-10
AUXILIARY STRUCTURE	
BULKHEAD CHORD AND SPLICE ANGLE AT BS 540, STRINGERS S-20 THRU S-26	53-20-01
PLATES/SKINS	
ULTRASONIC BOND INSPECTION OF FUSELAGE DOUBLERS	53-30-01
ULTRASONIC BOND INSPECTION OF WINDOW BELT DOUBLERS	53-30-02
FUSELAGE SKIN BEHIND THE UPPER RIB PLUS CHORD	53-30-03
FUSELAGE SKIN CRACK INSPECTION - LOWER SKIN AT THE LAP SPLICES	53-30-04
FUSELAGE SKIN SCRIBE LINE CRACK INSPECTION - LOWER SKIN AT THE LAP JOINTS, DOUBLERS, AND EXTERNAL STRUCTURE	53-30-05

PART 4 FRONTMATTER
TABLE OF CONTENTS

Page 2

Nov 15/2015

D6-37239

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details



737
NON-DESTRUCTIVE TEST MANUAL

**CHAPTER
SECTION
SUBJECT**

SUBJECT

FUSELAGE SKIN SCRIBE LINE CRACK INSPECTION - LOWER SKIN AT THE LAP JOINTS, DOUBLERS, AND EXTERNAL STRUCTURE (PHASED ARRAY)	53-30-06
FUSELAGE SKIN - INTERNAL CRACKS AT DOUBLER EDGES WITH PHASED ARRAY	53-30-07
FUSELAGE SKIN SCRIBE LINE CRACK INSPECTION - LOWER SKIN AT THE LAP JOINTS THAT HAVE MODIFIED UPPER SKINS (PHASED ARRAY)	53-30-08
FUSELAGE SKIN CRACK ANALYSIS AT CHEM-MILL AREAS	53-30-09
AFT PRESSURE PANEL OF THE APU ENCLOSURE	53-30-10
FUSELAGE SKIN LAP SPLICE AND CIRCUMFERENTIAL SPLICE BOND INSPECTIONS (HFBT)	53-30-11
FUSELAGE SKIN - INTERNAL CRACKS AT THE EDGES OF CHEM-MILL DOUBLERS WITH THE WIDE AREA PHASED ARRAY PROBE	53-30-12

SECTION 48 STRUCTURE

VERTICAL FIN REAR SPAR ATTACHMENT FITTINGS	53-80-01
--	----------

NACELLES/PYLONS

ATTACH FITTINGS

LEFT AND RIGHT UPPER SPAR CHORDS AT NSTA 242.7	54-40-01
LOWER SPAR CHORDS AT THE FIRE SEAL DEPRESSOR BRACKETS OF THE ENGINE SUPPORT STRUTS	54-40-02
UPPER LINK OF THE ENGINE STRUT	54-40-03
CROWN BEAM FITTING OF THE STRUT-T0-WING ATTACH FITTINGS	54-40-04
SIDE SKIN OF THE ENGINE STRUT AT THRUST REVERSER HINGE FITTINGS 2 AND 3 (NSTA 222.6 AND NSTA 242.7)	54-40-05
LOWER SPAR CHORDS OF THE ENGINE STRUT TORQUE BOX AT THE PRECOOLER FITTING AND BRACKET LOCATIONS	54-40-06
LOWER CHORDS OF THE NACELLE STRUT	54-40-07
VERTICAL LEG OF THE LOWER CHORDS OF THE NACELLE STRUT	54-40-08

STABILIZERS

HORIZONTAL

HORIZONTAL STABILIZER - UPPER CHORD OF THE REAR SPAR AT STAB STA 68.14	55-10-01
ELEVATOR REAR SPAR CHORD BOND	55-10-02
HORIZONTAL STABILIZER - UPPER CHORD OF THE REAR SPAR FROM STAB STA 68.14 TO 193.9	55-10-03
HORIZONTAL STABILIZER CENTER SECTION - JACKSCREW FITTING LUGS	55-10-04
HORIZONTAL STABILIZER CENTER SECTION - LOWER CLEVIS LUGS OF THE REAR SPAR	55-10-05

PART 4 FRONTMATTER
TABLE OF CONTENTS

Page 3
Jul 01/2016

D6-37239

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details



737
NON-DESTRUCTIVE TEST MANUAL

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>
HORIZONTAL STABILIZER CENTER SECTION - UPPER CHORD OF THE REAR SPAR AT LBL 1.3 AND RBL 1.3	55-10-06
HORIZONTAL STABILIZER CENTER SECTION - UPPER CHORD OF THE REAR SPAR AT THE THRUST BEAM SPLICE FITTING	55-10-07
HORIZONTAL STABILIZER CENTER SECTION - UPPER CLEVIS LUGS OF THE REAR SPAR	55-10-08
HORIZONTAL STABILIZER CENTER SECTION - UPPER AND LOWER CHORDS OF THE THRUST BEAMS	55-10-09
HORIZONTAL STABILIZER CENTER SECTION - THRUST BEAM CHORD AT THE PRIMARY BEAM JOINT	55-10-10
UPPER CHORD OF THE REAR SPAR BETWEEN THE TITANIUM FITTING OF THE HORIZONTAL STABILIZER	55-10-11
AFT FLANGE OF THE UPPER CHORD AT THE REAR SPAR OF THE HORIZONTAL STABILIZER AT ELEV STA 213.32, 250.04, 265.45, AND STAB BL 254.66	55-10-12
HORIZONTAL STABILIZER - REAR SPAR - TERMINAL FITTINGS OF THE UPPER CHORD	55-10-13
HORIZONTAL STABILIZER CENTER SECTION - UPPER CHORD OF THE PRIMARY BEAM	55-10-14
TERMINAL FITTING LUGS AT THE REAR SPAR OF THE HORIZONTAL STABILIZER	55-10-15
UPPER LUGS OF THE FRONT SPARS FOR THE HORIZONTAL STABILIZERS AND THE FRONT SPAR OF THE CENTER SECTION FOR THE HORIZONTAL STABILIZER AT BS 1093.5	55-10-16
UPPER LUGS OF THE REAR SPARS FOR THE HORIZONTAL STABILIZERS AND THE REAR SPAR OF THE CENTER SECTION FOR THE HORIZONTAL STABILIZER	55-10-17
HORIZONTAL STABILIZER - WEB FLANGE OF THE LOWER CHORD WHERE THE RIBS ATTACH TO THE REAR SPAR FROM STAB STA 212.3 TO 310.54 (UT)	55-10-18
HORIZONTAL STABILIZER - WEB FLANGE OF THE UPPER CHORD AT THE REAR SPAR	55-10-19
HORIZONTAL STABILIZER CENTER SECTION - UPPER AND LOWER CHORDS OF THE PRIMARY BEAMS AT THE FRONT AND REAR SPARS	55-10-20
UPPER AND LOWER CHORD LUGS OF THE FRONT SPARS FOR THE HORIZONTAL STABILIZERS	55-10-21
VERTICAL	
VERTICAL STABILIZER REAR SPAR PRIMARY CHORDS	55-30-01
VERTICAL STABILIZER - REAR SPAR PRIMARY CHORD	55-30-02
ATTACH FITTINGS	
HORIZONTAL STABILIZER CENTER SECTION REAR SPAR ATTACHMENT LUG AND CLEVIS FITTINGS	55-50-01

PART 4 FRONTMATTER
TABLE OF CONTENTS

Page 4
Jul 01/2016

D6-37239

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details



737
NON-DESTRUCTIVE TEST MANUAL

CHAPTER
SECTION
SUBJECT

SUBJECT

WINGS

CENTER WING

WING - LOWER SPAR CHORD AT FSS 296	57-10-01
WING - LOWER WING STRINGER S-5 AT WBL 191	57-10-02
WING FRONT SPAR - LOWER CHORD AT WBL 183.4, 191, 198.6 AND 254	57-10-04
WING FRONT SPAR AT THE NACELLE SUPPORT FITTINGS - LOWER CHORD AT THE R1 SIDE LINK BACKUP FITTING AND WING LOWER SKIN AT THE R7/R8 SIDE LINK ATTACH FITTING	57-10-05
WING LOWER SKIN AT THE R2, R3 AND R4 NACELLE SUPPORT FITTINGS	57-10-06
OUTER WING - RAIL AND SPLICE STRINGERS AT THE WING LOWER SKIN	57-10-07
OUTER WING - WING LOWER SKIN BEHIND THE FLAP TRACK FITTINGS	57-10-08
OUTER WING - SKIN AND WEB FLANGES OF THE LOWER CHORD OF THE FRONT SPAR	57-10-09
OUTER WING - SKIN AND WEB FLANGES OF THE UPPER CHORD OF THE REAR SPAR	57-10-10
OUTER WING - REAR SPAR WEB AT THE UPPER AND LOWER CHORDS	57-10-11
UPPER SKIN OF THE WING CENTER SECTION - FROM THE FRONT SPAR TO THE REAR SPAR AT BL 0, BL 25 AND BL 45	57-10-12
WING CENTER SECTION - LOWER SKIN PANEL AT THE KEEL BEAM AND LOWER BEAMS	57-10-13
WING SPAR CHORDS AT THE CHORDWISE SKIN SPLICES FOR THE UPPER AND LOWER SKIN PANELS	57-10-14
WING LOWER SKIN AT THE FLAP TRACK AND NACELLE FAIRINGS	57-10-15
OUTER WING - WEB FLANGE OF THE LOWER CHORD OF THE REAR SPAR	57-10-16
UPPER AND LOWER SKINS AT THE INTERSECTION OF THE FRONT AND REAR SPARS OF THE WINGS WITH THE SIDE-OF-BODY SPLICES AT BBL 70.85	57-10-17
SKIN FLANGE OF THE LOWER CHORD AT THE REAR SPAR OF THE WING	57-10-18

TRAILING EDGE AND TRAILING EDGE DEVICES

NUMBER 1, 2, 7 AND 8 OUTBOARD FLAP TRACKS	57-50-01
OUTBOARD MIDFLAP CARRIAGE SPINDLES	57-50-02
INBOARD TRAILING EDGE FLAP - TORQUE TUBE OF THE CARRIAGE ASSEMBLIES AT WBL 66.5 AND 191	57-50-03
ACTUATOR HINGE FITTING LUGS OF GROUND SPOILERS 4 AND 5	57-50-04

POWER PLANT

MOUNTS

ENGINE MOUNT AFT CONE BOLT	71-20-01
----------------------------	----------

PART 4 FRONTMATTER

TABLE OF CONTENTS

Page 5

Mar 01/2016

D6-37239

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details



737
NON-DESTRUCTIVE TEST MANUAL

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>
<u>EXHAUST</u>	
THRUST REVERSER	
ACOUSTIC FAN DUCT INNER COWL BOND INSPECTION	78-30-01
THRUST REVERSER - INNER WALL	78-30-02
THROUGH-TRANSMISSION INSPECTION OF THE INNER WALL OF THE THRUST REVERSER (AIR-COUPLED)	78-30-03

PART 4 FRONTMATTER
TABLE OF CONTENTS

Page 6
Mar 01/2016

D6-37239