



737
NON-DESTRUCTIVE TEST MANUAL

PART 2 - X-RAY

INBOARD MIDFLAP - INTERNAL STRUCTURE

1. Purpose

- A. To detect cracks in flange of machined forward and aft rib on inboard midflap at WBL 74.50 and WBL 82.58 and at forward rib at WBL 117.10. See Figure 1.
- B. 737 Maintenance Planning Document (D6-17594, D6-38278) Reference:
 - (1) Item: 6-57-09
 - (2) Item: S57-09-A

ALL

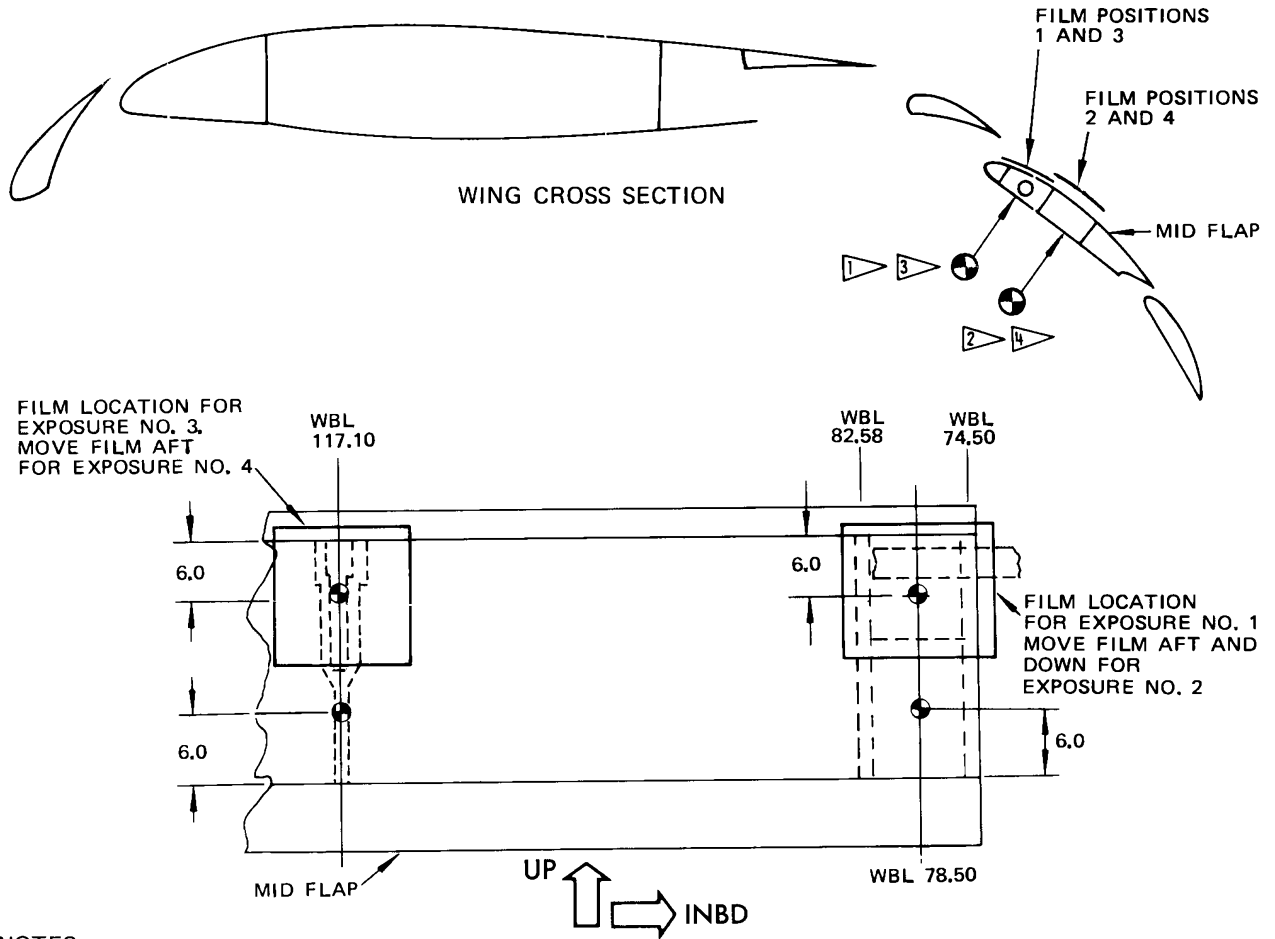
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NOTES

- ALL DIMENSIONS ARE IN INCHES EXCEPT AS NOTED
- X-RAY GENERATOR POSITION
- 1> CENTER X-RAY TUBE ON WBL 78.50. FOR EXPOSURE NO. 1 PLACE X-RAY TUBE 6.0 INCHES AFT OF FWD BULL NOSE.
- 2> CENTER X-RAY TUBE ON WBL 78.50. FOR EXPOSURE NO. 2 PLACE X-RAY TUBE 6.0 INCHES FORWARD OF THE TRAILING EDGE OF THE FLAP.
- 3> CENTER X-RAY TUBE ON WBL 117.10. FOR EXPOSURE NO. 3 PLACE X-RAY TUBE 6.0 INCHES AFT OF FWD BULL NOSE.
- 4> CENTER X-RAY TUBE ON WBL 117.10. FOR EXPOSURE NO. 4 PLACE X-RAY TUBE 6.0 INCHES FORWARD OF THE TRAILING EDGE OF THE FLAP.

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X-Ray Generator and Film Positioning
Figure 1 (Sheet 1 of 2)

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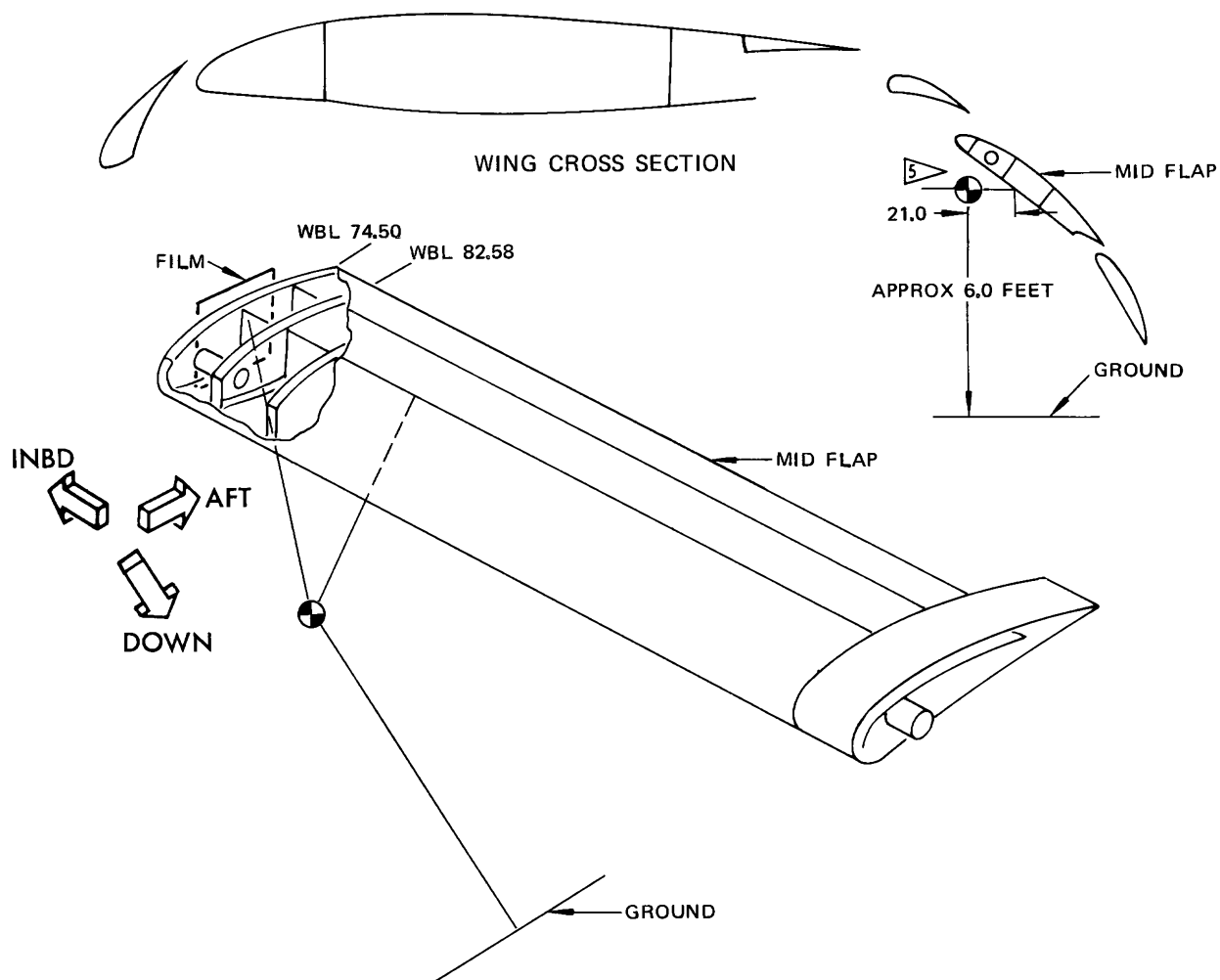
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5 FOR EXPOSURE NO. 5 POSITION X-RAY TUBE 21.0 INCHES FROM THE CENTER OF THE FLAP. POINT X-RAY TUBE SO THAT THE BEAM WILL MISS THE FWD RIB LOWER SURFACE AT WBL 82.58. PLACE FILM ON INBOARD SIDE OF FWD RIB AT WBL 74.50.

X-RAY PARAMETERS						
EXPOSURE NUMBER	FILM		SETTINGS			H & D FILM DENSITY
	ASTM CLASS	SIZE (INCHES)	SFD (INCHES)	KV	MAS	
1	II	14 x 17	36	120	630	2.50
2	II	14 x 17	40	120	630	2.50
3	II	14 x 17	36	120	630	2.50
4	II	14 x 17	40	120	630	2.50
5	II	14 x 17	21	120	630	2.50

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X-Ray Generator and Film Positioning
Figure 1 (Sheet 2 of 2)

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