



DEPARTMENT OF THE NAVY
NAVAL AIR WARFARE CENTER AIRCRAFT DIVISION

13600 IN REPLY REFER TO:
Ser 314400596-2/0968

MAY 13 2002

From: Head, Common Support Equipment Branch, (Code 3.1.4.4),
Naval Air Warfare Center Aircraft Division, Highway 547,
Lakehurst, NJ 08733-5108

Subj: SUPPORT EQUIPMENT BULLETIN NO. 670 REVISION B, TD CODE 63,
MOBILE FACILITY CORROSION CONTROL

Ref: (a) Naval Air Warfare Center Aircraft Division Lakehurst, NJ
ltr Ser 4.8.7.2.00B596-1/0117 of 21 May 1998, SEB 670
Revision A, Amendment 1
(b) NAVAIRWARCENACDIV LAKEHURST, NJ 010933Z Sep99, SEB 670
Revision A, Amendment 2.
(c) NAVAIRWARCENACDIV LAKEHURST NJ 081033Z Dec 99, SEB 670
Revision A, Amendment 3
(d) NAVAIRWARCENACDIV LAKEHURST NJ 191033Z Mar01, SEB 670
Revision A Amendment 4
(e) NAVAIRWARCENACDIV LAKEHURST NJ 312028Z Oct 01, SEB 670
Revision A, Amendment 5.
(f) NAVAIR 00-25-300, NAVAL AIR SYSTEMS COMMAND TECHNICAL
DIRECTIVE SYSTEM

Encl: (1) FIG. 1 Mobile Facility, End Frame Close-up
FIG. 2, Huck Rivet, Sealing of

1. Cog Code: Engineering, T. Zalepa, NAVAIRWARCENACDIVLKE,
Code 4.8.7.2, DSN 624-1953
Logistics, S.Gruber, NAVAIRWARCENACDIVLKE,
Code 3.1.4.4, DSN 624-4207

2. Category: Urgent

3. Documentation Affected:

a. NAVAIR 19-25-177, Technical Manual, Operation and
Intermediate Maintenance with Illustrated Parts Breakdown, Mobile
Facility of 1 Mar 1995

b. NAVAIR 17-1-125, Technical Manual, Maintenance Instructions
(Organizational and Intermediate Levels) Support Equipment Cleaning,
preservation and Corrosion Control of 15 March 2000 w/change 1 -15
April 2001.

c. This revision supersedes references (a) thru (e).

4. Purpose: The purpose of this bulletin is to provide inspection
and corrective action for specified deficiencies that might lead to
corrosion in the mobile facility. This revision is being prepared

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to meet the requirements of ref (f) which cites that a bulletin must be revised after 3 amendments have been issued. This revision collates all the changes set forth in references (a) thru (e).

5. Application:

a. Basic Equipment:

<u>NOMENCLATURE</u>	<u>SERIAL NO.</u>	<u>QTY</u>
Mobile Facility	All mobile facilities manufactured IAW Drawing Package 1339ASXXXX	4700

b. Trainers: N/A

c. Spares: N/A

6. Compliance:

a. Basic Equipment: Initiation of inspection and repair shall be performed at the organizational/intermediate maintenance activities no later than 30 days after bulletin issue, and full compliance no later than 30 Dec 2003.

b. Trainers: N/A

c. Spares: N/A

7. Man Hours

a. Basic Equipment:

<u>NO. OF MEN</u>	<u>SKILL</u>	<u>TOTAL MAN HOURS</u>
2	Aviation Support Equipment Technician/MOS 6XXX	4.0

b. Trainers: N/A

c. Spares: N/A

0

8. Supply Data:

a. Requirements for basic equipment:

(1) Parts/Material required:

<u>QTY</u>	<u>P/N</u>	<u>CAGE</u>	<u>NOMENCLATURE</u>	<u>SM&R</u>	<u>NSN SOURCE</u>
AR	MIL-S-8802 TY2 CLB-2	30244	Sealing Compound	PAGZZ	8030-01-152-0013 (A)
AR	INHIBITOR-46	OEJU4	Conversion Coating	PAGZZ	6850-01-253-6781 (A)
AR	75448	05792	Conversion Coating	PAGZZ	6850-01-253-5781 (A)

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(2) Peculiar Support Equipment Required: None

(3) Disposition of Material Removed:

Any paint, rust or sealant removed should be disposed of in accordance with local EPA regulations

(4) Source of supply:

(a) Requisition through normal supply channels.

(b) Requirements for Trainers: N/A

(c) Requirements for Spares: N/A

9. REIDENTIFICATION: N/A

10. DETAILED INSTRUCTIONS:

CAUTION: WHEN CLEANING AREAS OF CORROSION, ENSURE MINIMUM AMOUNT OF UNCORRODED METAL IS STRIPPED, SO LESS AREAS ARE EXPOSED TO CORROSION ESPECIALLY IF PRIMING/ PAINTING CANNOT BE ACCOMPLISHED IN A FEASIBLE TIME FRAME.

a. Inspect all exposed Huck Rivet heads (see Fig. 1 and Fig. 2). All rivets that show indications of advanced corrosion at the rivet head or surrounding area (ie peeling, blistering, or exfoliation), should be treated in accordance with NAVAIR 17-1-125, Section VII and Section VIII

b. Inspect and clean sharp edges of all steel components (see Fig. 1). These include the steel End Frame and the steel Gusset. All indications of advanced corrosion shall be treated in accordance with NAVAIR 17-1-125.

NOTE: OBTAIN RESPECTIVE MATERIAL SAFETY DATA SHEETS (MSDS) ON ANY SEALANT, PAINT, OR PRIMER PRIOR TO USE.

c. Apply corrosion coating, NSN 6850-01-253-6871, to all the exposed Huck Rivets and corrosion affected areas (Steel Gussets and Steel End Frames). When the conversion coating is dry, a second coating will be applied. After the second coat is dry, apply sealing compound, MIL-S-8802 TY II CL B-2 (NSN 8030-00-152-0013), on

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top of the conversion coating to seal the Huck Rivets (see Fig. 1 and Fig. 2). To apply the sealing compound use a manual sealant gun, NSN 5130-00-924-6396. Using the same sealant gun, lay a bead of sealant along all the sharp edges of all the steel beams. Be sure to fill in the corners where the original sealant might have been removed (see fig. 1). Approximately 4 pts of sealant are required for each mobile facility.

NOTE: PRIMING AND PAINTING SHOULD BE ACCOMPLISHED AS SOON AS FEASIBLE BUT NOT LATER THAN 90 DAYS AFTER PERFORMING STEP "c", THUS MINIMIZING THE NEED TO REPEAT STEP "a".

d. Prime (MIL-P-53022) and paint (MIL-C-85285 TY II COLOR # 17925) all affected areas and let cure for 24 hours.

11. Weight and Balance: N/A

12. Records affected:

a. Enter compliance support equipment custody and maintenance record (OPNAV 4790/51).

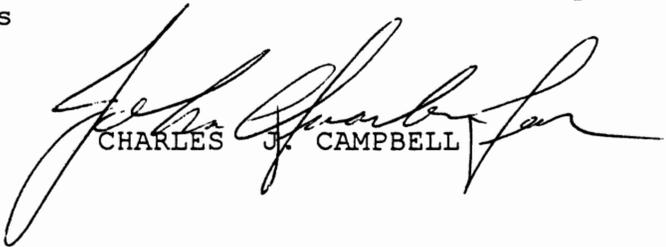
b. Report compliance through VIDS/MAF form (OPNAV 4790/60) and technical directive status accounting system.

13. Verified by: MALS 14

14. Target completion date: 30 December 2003

15. Related instructions:

a. Request widest dissemination to all mobile facility supporting/using activities


CHARLES J. CAMPBELL

Distribution:
COMNAVAIRSYSCOM (3.9.4, 3.1.8.2)
COMNAVAILANT (N422)
COMNAVIRPAC (N422B3, N422C2A)
COMNAVIAESFOR (N4316)
COMNAVRESFOR (ALD-E)
CNATRA (N422)
MARFORLANT (ALD-E)

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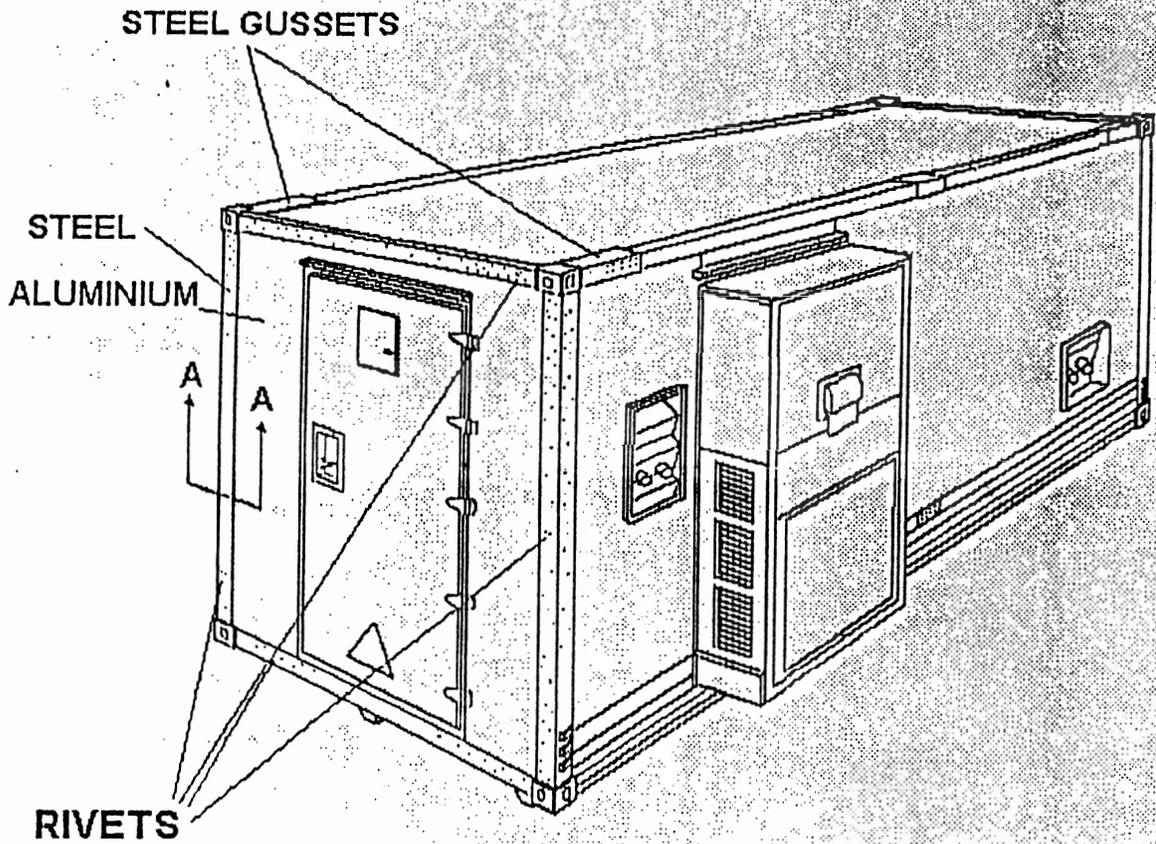
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MARFORPAC (ALD-E)

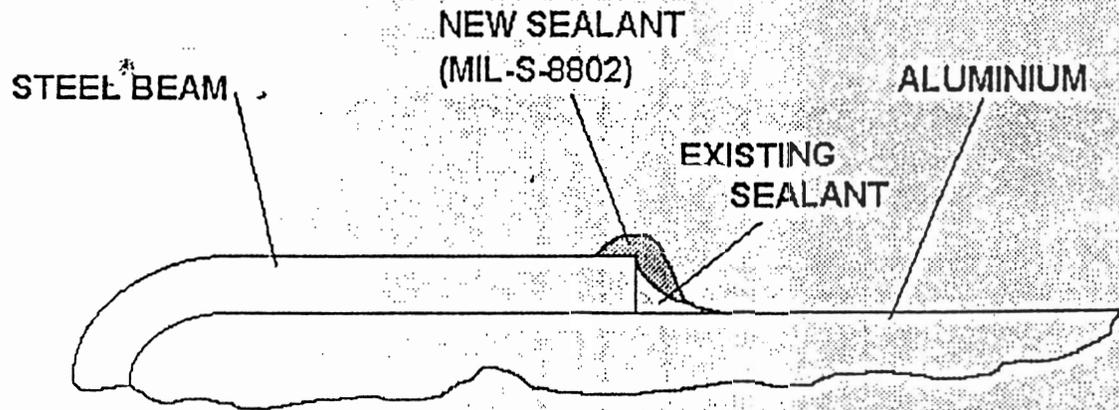
PWC NORFOLK (30M)

NAVAIRDEPOT NORTH ISLAND (3144, 48730, 61423)

NATEC (3.3A16)



(Some rivets may already be sealed near the bottom of the Mobile Facility. Not all Huck rivets are shown.)

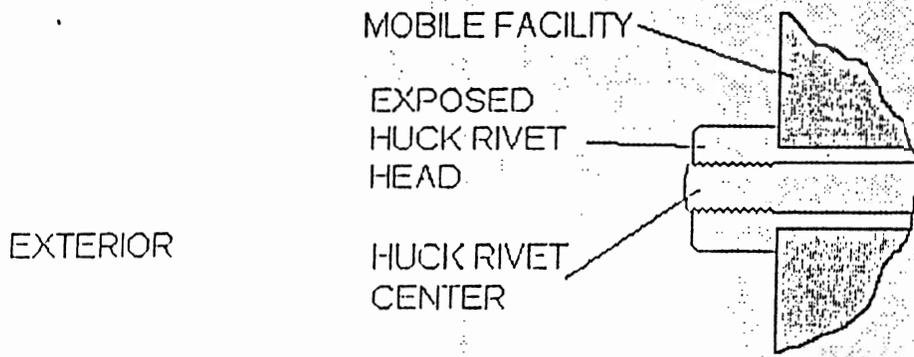


VIEW A

Fig. 1

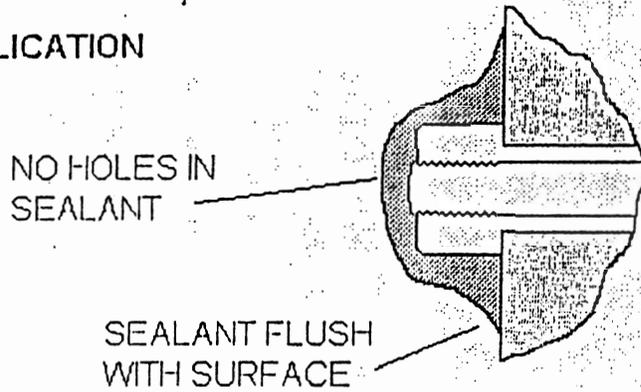
ENCLOSURE (1)

HUCK RIVET



PROPER SEALANT APPLICATION

Note: Be sure that sealant is smooth and flush to the surface of the Mobile Facility for proper seal.



IMPROPER SEALANT APPLICATION

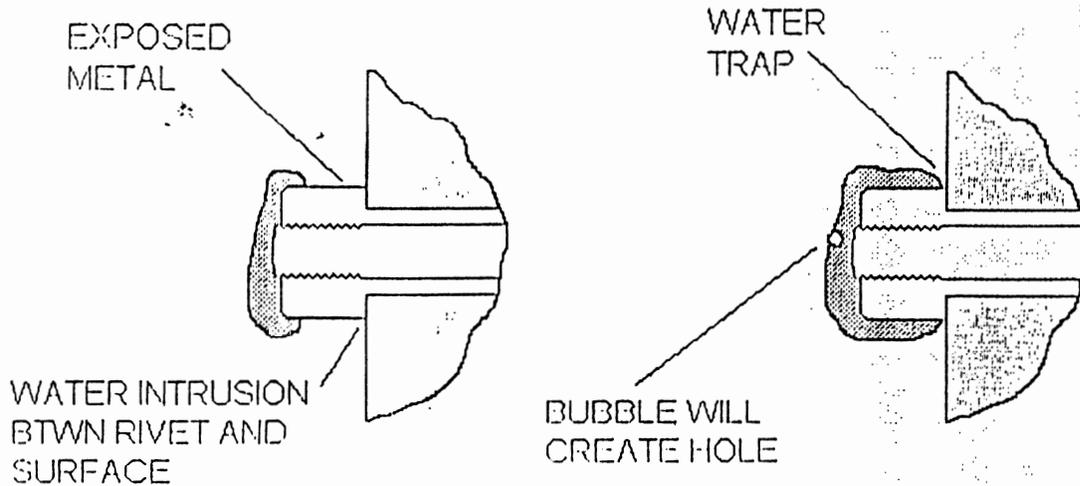


Fig. 2