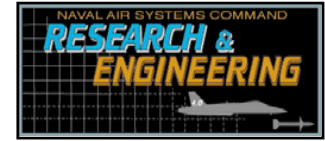




HVOF as a Hard Chrome Replacement



**Jon L.
Devereaux**

AIR - 4.9.7.4

**NADEP
Jacksonville**

**Materials
Engineer**

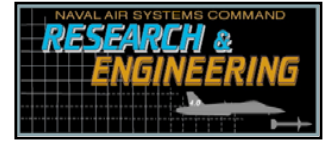


US Navy Photo by Photographer's Mate 3rd Class Milosz Reterski

Report Documentation Page				Form Approved OMB No. 0704-0188	
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				5c. PROGRAM ELEMENT NUMBER	
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15. SUBJECT TERMS					
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a. REPORT unclassified	b. ABSTRACT unclassified	c. THIS PAGE unclassified			



HVOF as a Hard Chrome Replacement



Current Status of P-3 Main Landing Gear

**HVOF MLG Piston installed 26 April 99 on VP-30
Aircraft BuNo 156522**

850 Landings on HVOF coated MLG Piston (Aug 00)

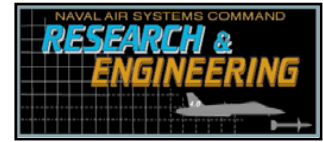
**HVOF Coated Piston removed from service Aug 2000
due to internal oil leak on ID-2 (NOT HVOF COATED)**

**HVOF Coated Strut repaired, sent back to VP-30
Installed on Aircraft 160284 STBD April 25, 2001**

1,078 Total Landings on HVOF coated strut (8/23/01)



HVOF as a Hard Chrome Replacement



Current Status of P-3 Main Landing Gear

2,858 Total Landings on HVOF coated strut as of 30 Sept 03

Aircraft sent to Depot JAX for PDM on 13 August 2003

Aircraft returned to VP-30 on Feb. 6, 2004

3,329 Total Landings on HVOF coated strut as of 7 May 04

4,410 Total Landings on HVOF coated strut as of 1 March 05

6,378 Total Landings on HVOF coated strut as of 15 January 2006 when strut was removed & turned in to Supply IAW AFB 383

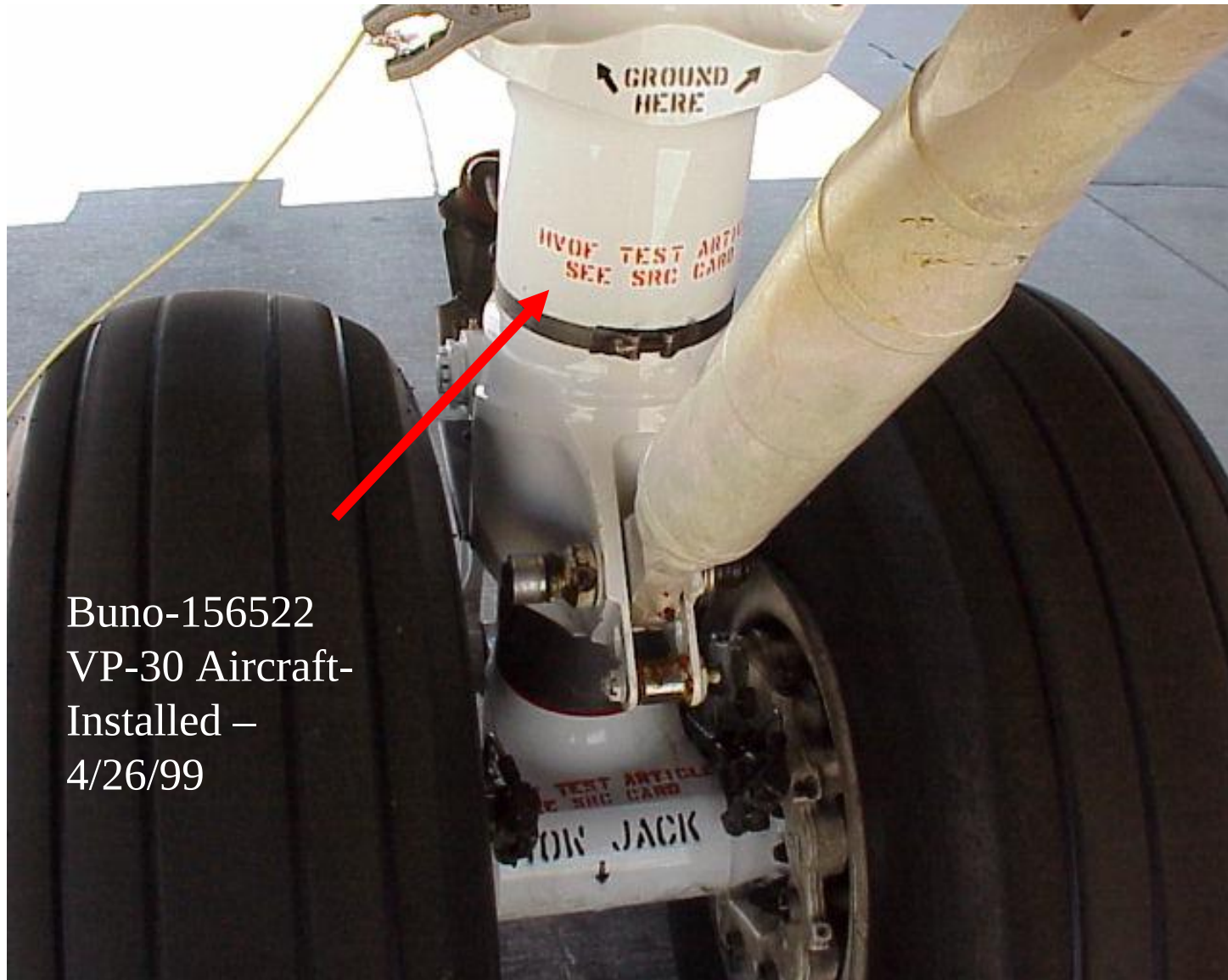
(Strut Assy S/N C30-1252 P/N 937958-103 R/H MLG)

HVOF as a Hard Chrome Replacement



Buno-156522
VP-30 Aircraft
Installed 4/26/99

HVOF as a Hard Chrome Replacement



Buno-156522
VP-30 Aircraft-
Installed –
4/26/99



A/C 160284
Nov 14, 2003
2,858 Landings

HVOF as a Hard Chrome Replacement

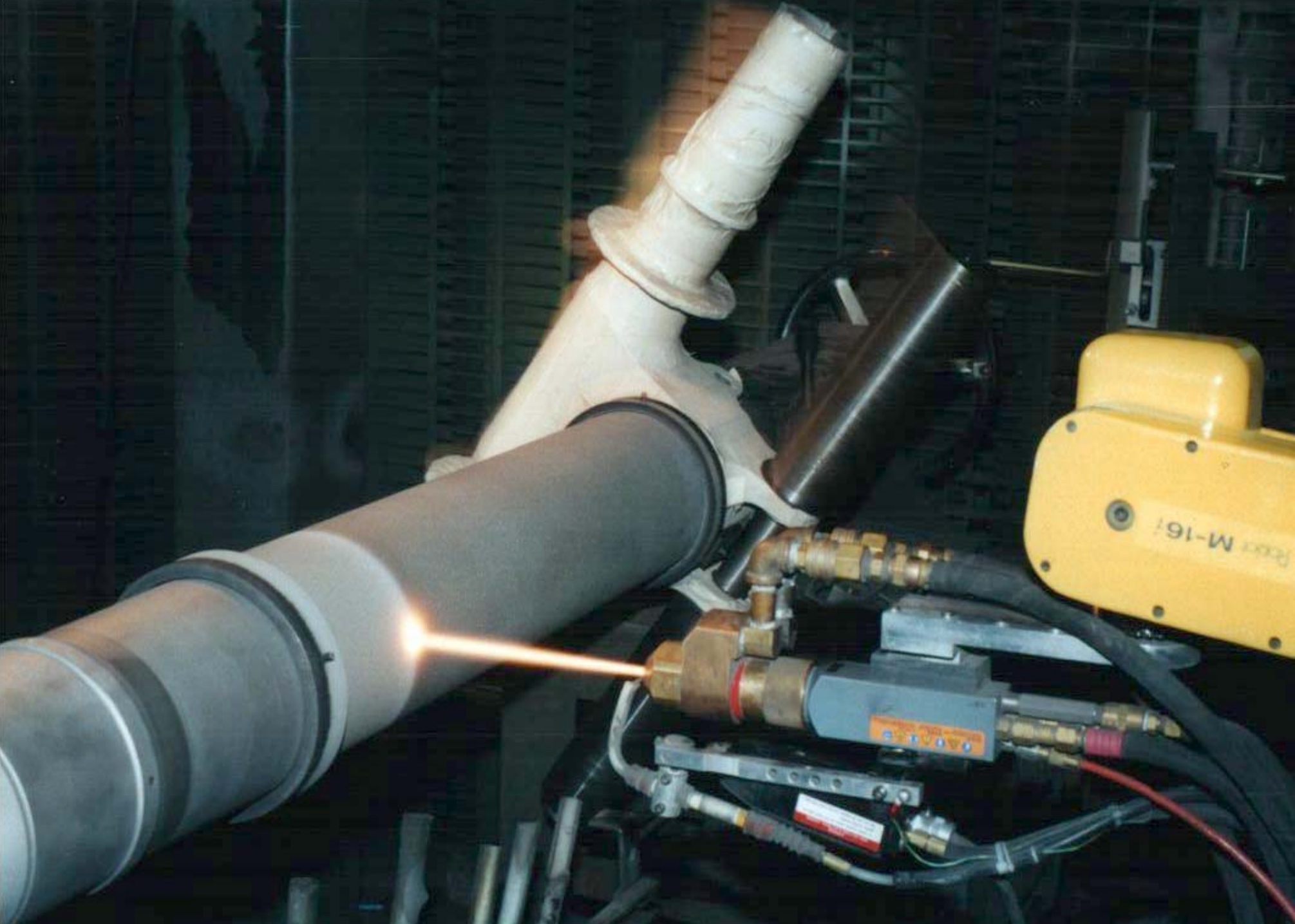
Second P-3 MLG Piston coated with HVOF WC/Co 83/17

- Tested in \$70M P-3 aircraft SLAP/SLEP - Full Scale Fatigue Test
- R/H MLG chrome plated
- L/H MLG HVOF coated
- HVOF coating, grinding & processing of gear funded by Naval Research Lab (NRL)
- Testing started 30 August 2001 (24 month test)
- 26,000 CTH planned; ECD December 02 if all goes well
- Landing gear shows no sign of coating problems

HVOF as a Hard Chrome Replacement

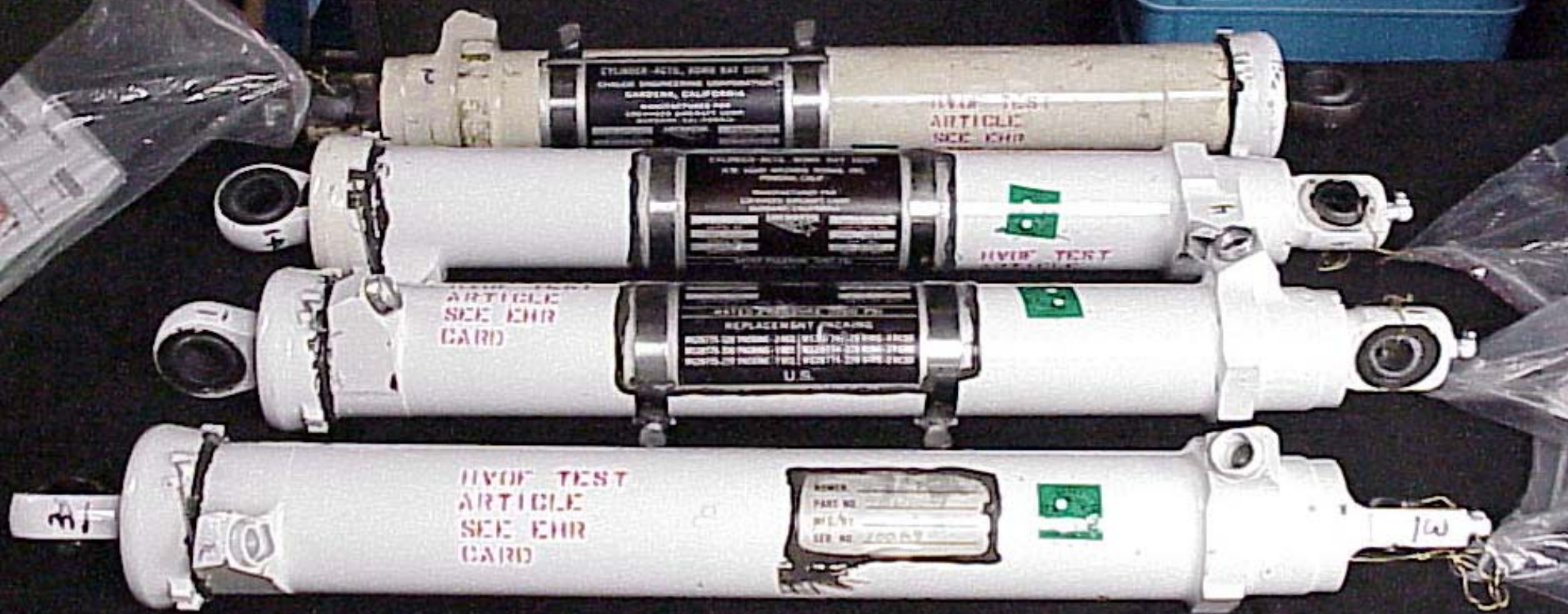
Second P-3 MLG Piston coated with HVOF WC/Co 83/17

- 26,000 CTH initially planned
- Test extended to 38,000 CTH - some of airframe not tested sufficiently
- 200-250K cycles on LG representing 47,000 Landings
- Test represents two fatigue lifetimes
- If this testing doesn't break the landing gear or HVOF coating, then nothing will! - NAVAIR Structures
- Landing gear shows no sign of failure or coating problems
- Test Completed with a "BANG!" on 4 March 2003
- Landing Gear removed April 2003 for inspection

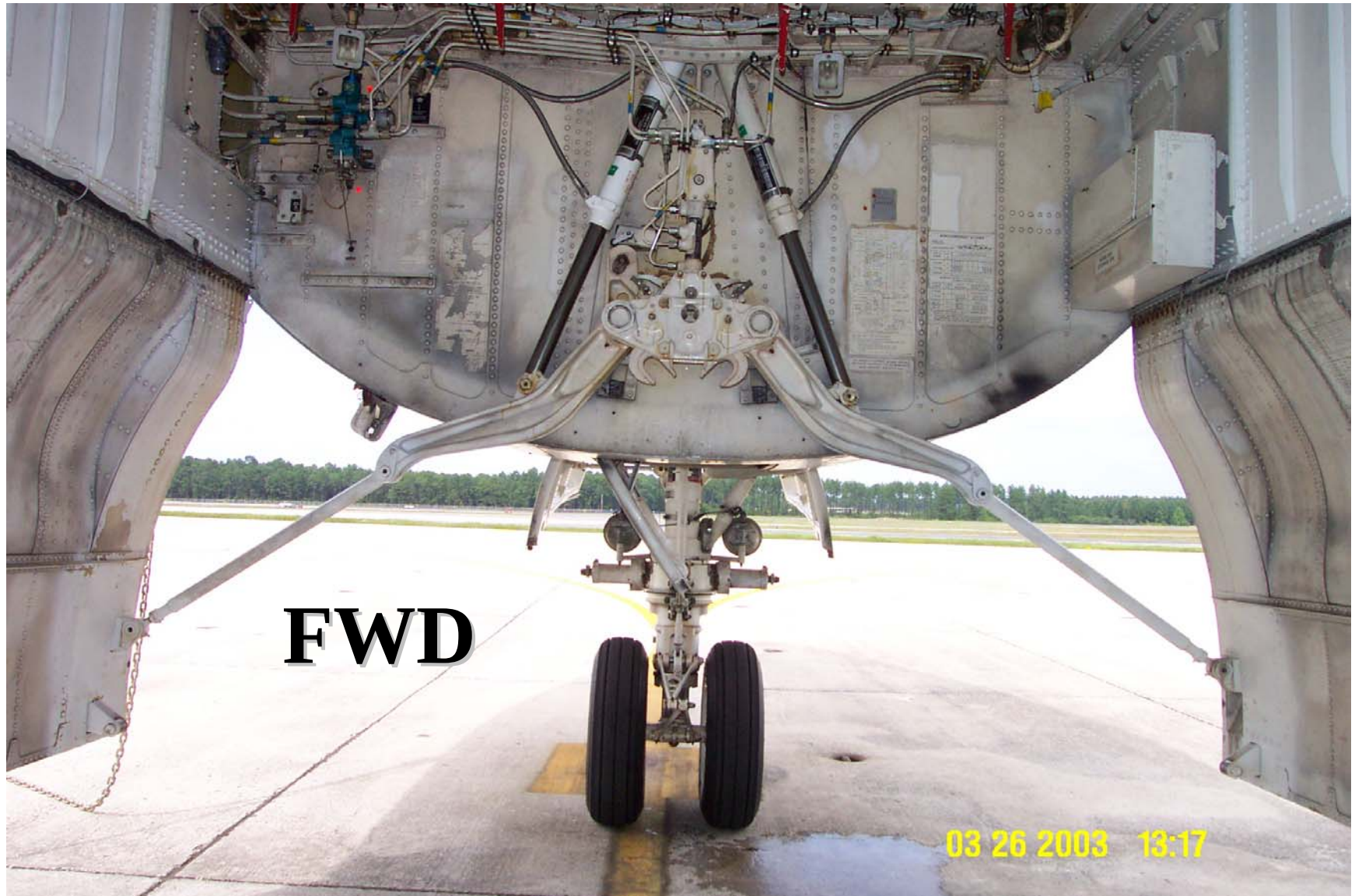


HVOF as a Hard Chrome Replacement

- **P-3 Bomb Bay Door Actuator Pistons coated, ground, & superfinished**
- **Four HVOF coated P-3 Bomb Bay Door Actuator Assemblies RFI and installed on VP-30 Aircraft BuNo 156510 July 2001**
- **1,363 Flight Hours on HVOF coated actuators as of (20 JAN 06)**
- **156510 currently at Greenville, SC**
- **Undergoing PDM & ESSI (started Sept. 05)**
- **Wing spar replacement on TLI bird (Time Life Indexed)**
- **Aircraft due back at VP-30 on 29 April 06**

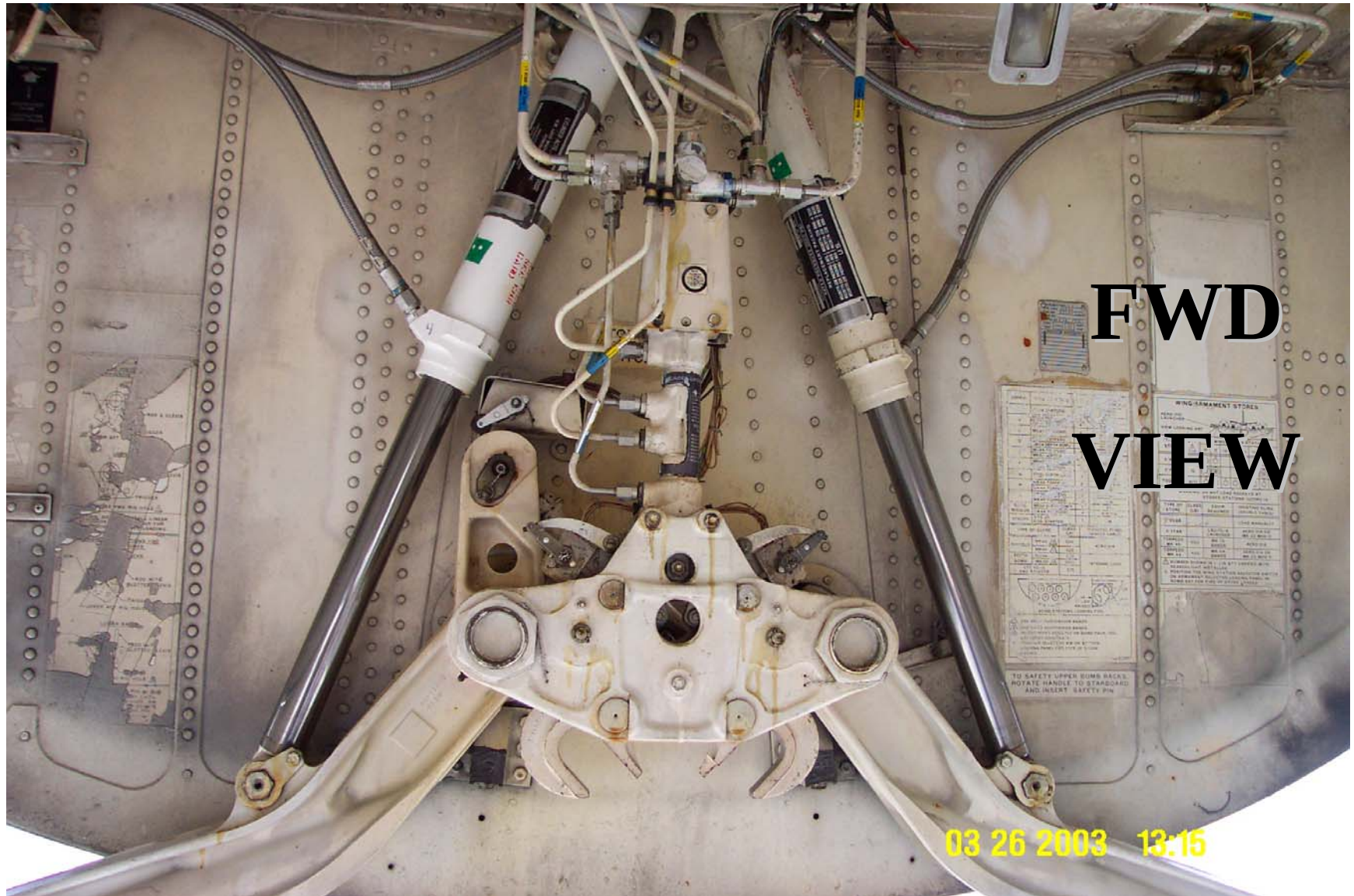


HVOF as a Hard Chrome Replacement

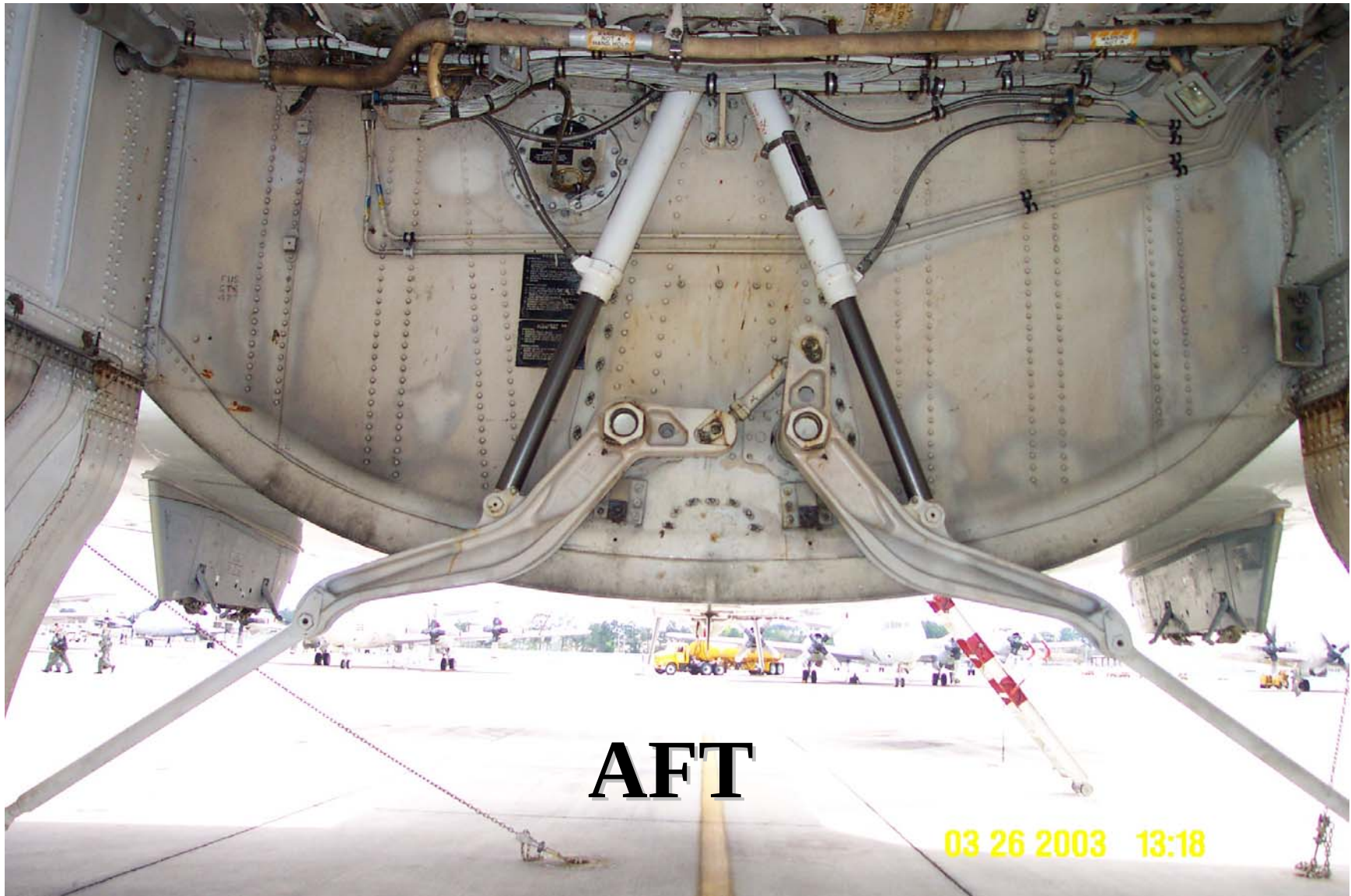


03 26 2003 13:17

HVOF as a Hard Chrome Replacement



HVOF as a Hard Chrome Replacement



HVOF as a Hard Chrome Replacement



AFT PORT

03 26 2003 13:18

HVOF as a Hard Chrome Replacement

F/A-18 Horizontal Stabilator Piston Rod

P/N 3003130 (Vendor Code 93835) - Nat'l Water Lift

HVOF Coat short external end with WC/Co/Cr 86/10/4

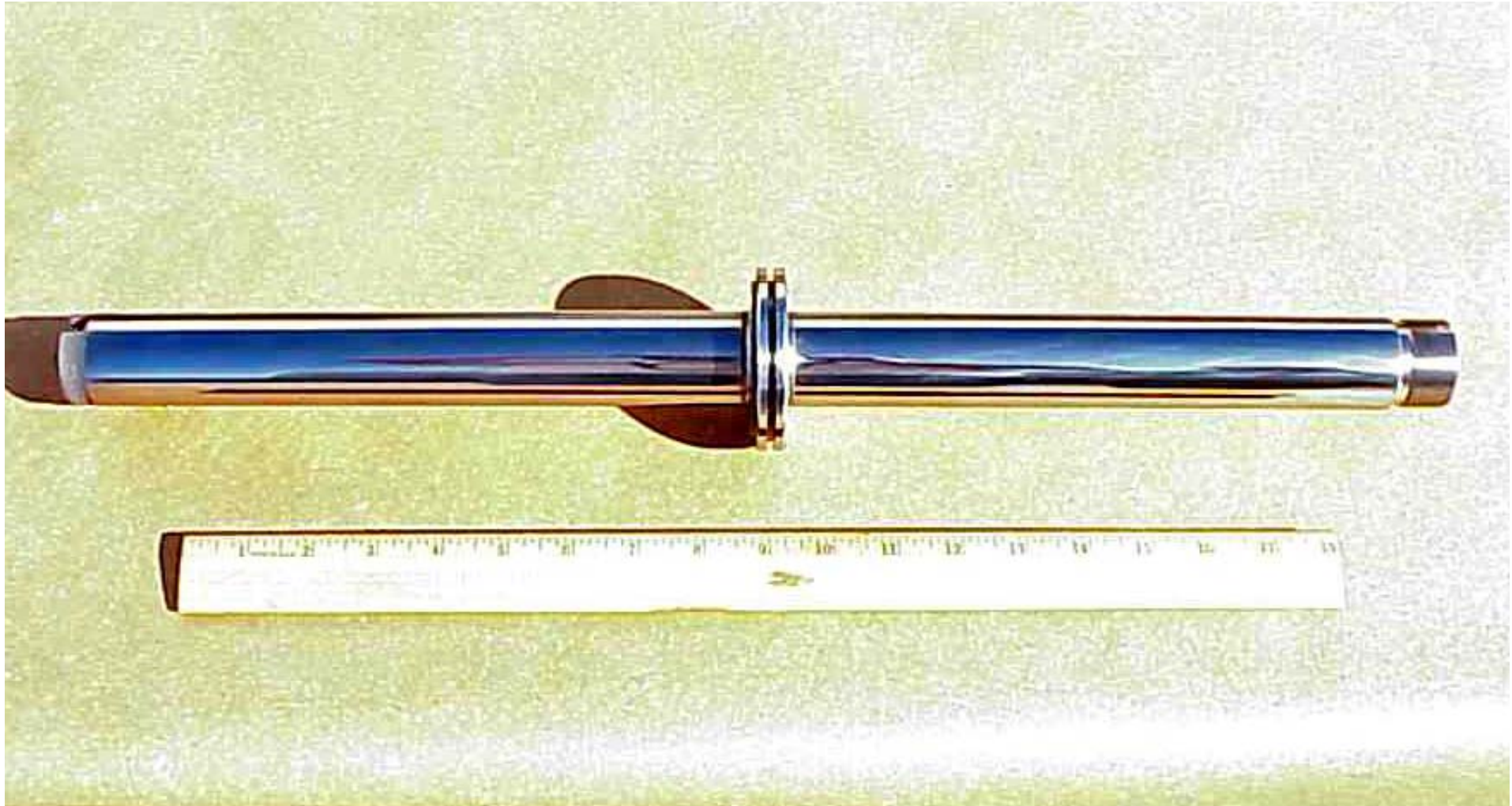
HVOF Coat longer internal end with WC/Co 83/17

Grind to 8 - 16 μ in Ra finish

Superfinish to ≤ 2 μ in Ra finish

**Shipped to PAX Lab for additional Hydraulic Actuator
seal compatibility testing on 15 Nov 02**

HVOF as a Hard Chrome Replacement

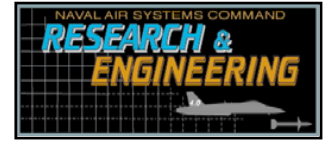


HVOF as a Hard Chrome Replacement





HVOF as a Hard Chrome Replacement



**F/A-18 Trailing Edge Flap (TEF) Actuator Piston Rod
P/N 303247-3 (Vendor Code 82106) - Parker Hannifin
HVOF Coat OD of Piston Rod with WC/Co/Cr 86/10/4**

Grind to 8 - 16 μ in Ra finish

Superfinish to ≤ 2 μ in Ra finish

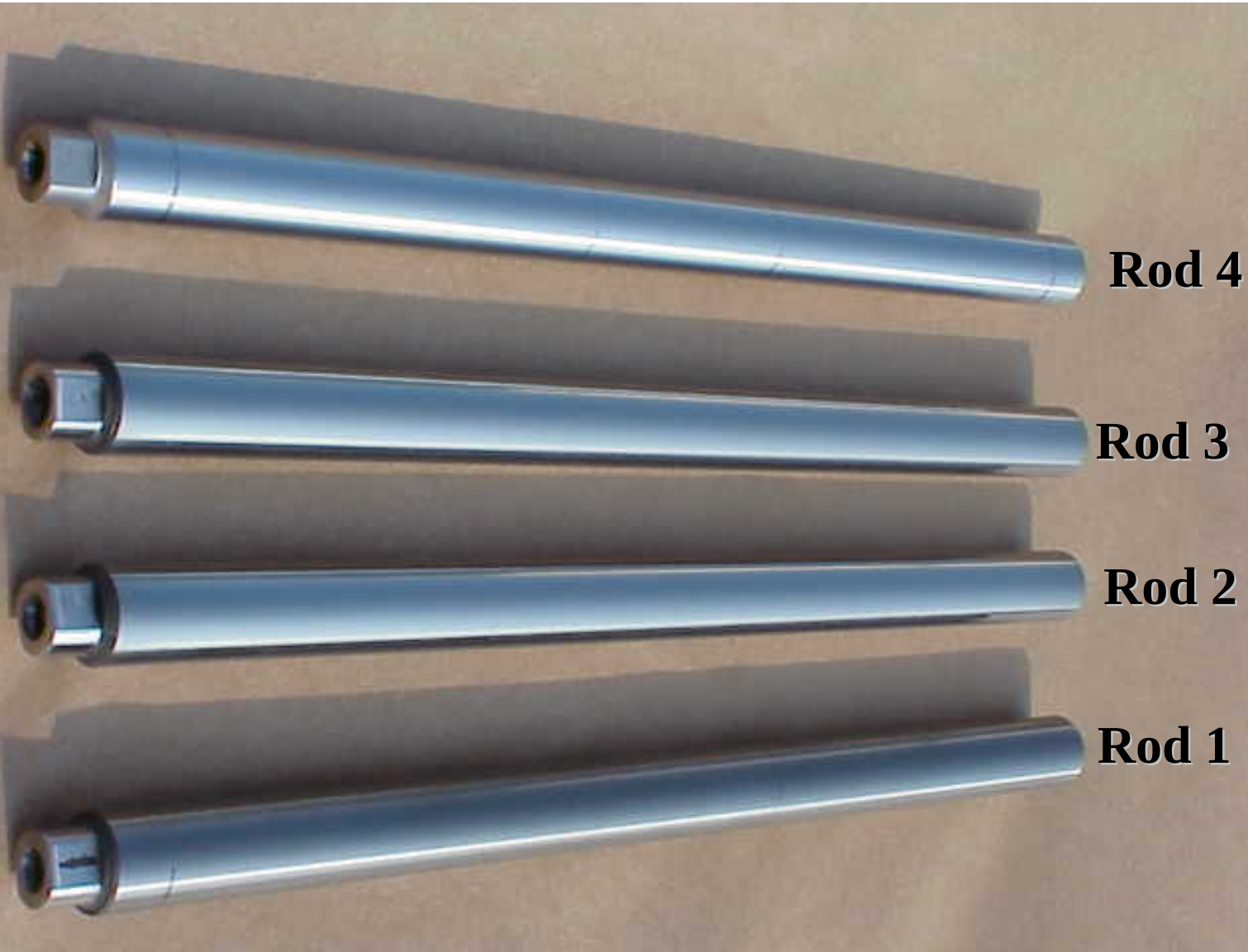
**Shipped to NADEP NORIS for additional Hydraulic
Actuator seal compatibility testing on 20 Mar 03**

**Second F/A-18 TEF Actuator Piston Rod shipped to
NADEP NORIS 16 Sept 03 for build-up and then ship to
PAX for additional Hydraulic Actuator seal
compatibility testing**

HVOF as a Hard Chrome Replacement



HVOF as a Hard Chrome Replacement



**HCAT
Hydraulic
Actuator
JTP
Part II
Phase 1
1" dia.
Test rod**

**Superfinished
at
NADEP JAX**

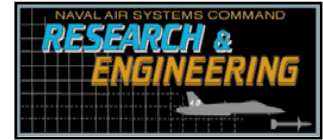
HVOF as a Hard Chrome Replacement

E-6A MLG Lock Hook Shaft P/N 9-45196





HVOF as a Hard Chrome Replacement E-6A Main Landing Gear



**Two HVOF coated E-6A MLG Uplock Hook Shafts installed 10
March 99 on A/C 164388**

6,019.5 Flight Hours (Nov 2005)

4,381 Landings (Nov 2005)

HVOF Shafts to be removed during LG O/H 9-29-2008

**One HVOF coated E-6A MLG Uplock Hook Shaft
installed on Aircraft 162784 in Feb. 2000**

6,235 Flight Hours (Nov 2005)

4,377 Landings (Nov 2005)

HVOF Shaft to be removed during LG O/H 12-3-2007

HVOF as a Hard Chrome Replacement

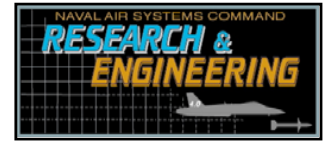


HVOF coated R/H EA-6B MLG Strut Assy.

P/N 1707B00-02 S/N BFG 5008



HVOF as a Hard Chrome Replacement



Current Status of HVOF Coated

EA-6B Main Landing Gear Strut Assy.

**EA-6B MLG alloy is 4330 V-mod
220-240 KSI UTS 180-185 KSI Yield Strength**

MLG Piston coated Oct. 99

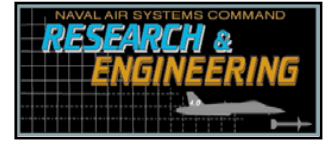
Depot processing completed Dec. 99

Flight clearance requested Jan 2000

**NAVAIR Structures (AIR-4.3.3.1) gives approval to move
ahead with flight clearance request for HVOF coated
Strut in Mtg. At PAX River on 19 August 2003**



HVOF as a Hard Chrome Replacement



Flight Clearance Message issued DTG 102001Z DEC 03

HVOF coated Strut Assy re-inducted into Depot Landing Gear Shop for repeat of final pressure check and leak test prior to being issued as RFI to aircraft line (Feb 2004)

Aircraft 163395 identified

**HVOF coated MLG Strut Assy installed on EA-6B Aircraft
163395 June 04**

FIRST FLIGHT w/ HVOF strut 13 July 2004

Aircraft delivered to Whidbey Is. 20 July 2004

HVOF as a Hard Chrome Replacement



**HVOF coated
EA-6B MLG
Strut Assy.
P/N 1707B00-02
S/N BFG 5008
Aircraft
163395
July 13, 2004
09:34 a.m.**

HVOF as a Hard Chrome Replacement



HVOF coated

EA-6B MLG

Strut Assy.

P/N 1707B00-02

S/N BFG 5008

Aircraft

163395

July 13, 2004

09:34 a.m.

HVOF as a Hard Chrome Replacement



**HVOF coated
EA-6B MLG
Strut Assy.
P/N 1707B00-02
S/N BFG 5008
Aircraft
163395
July 13, 2004
09:34 a.m.**

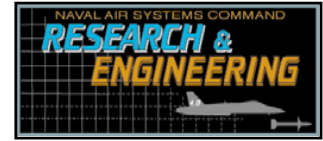
HVOF as a Hard Chrome Replacement



**HVOF coated
EA-6B MLG
Strut Assy.
P/N 1707B00-02
S/N BFG 5008
Aircraft
163395
July 13, 2004**



HVOF as a Hard Chrome Replacement



Aircraft delivered to Whidbey Is. 20 July 2004

1st Carrier Landing 9-14-04 aboard USS Carl Vinson

Returned to NAS Whidbey Is. 10-3-2004

30 Cats & 30 Traps during 3 week work-ups

Deployed again to USS Carl Vinson 1-20-2005

Successfully completed World Cruise 8-8-2005

Latest info 330 Total Landings on HVOF coated Strut

162 Cat Shots; 164 Traps (19 December 2005)

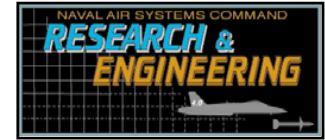
HVOF as a Hard Chrome Replacement



US Navy Photo by Photographer's Mate 3rd Class Milosz Reterski



HVOF as a Hard Chrome Replacement



The HVOF coated MLG Strut Assy has now undergone the severest operational in-service testing during this world cruise which included combat operations in an active zone.

This strut continues to gather valuable dem/val data for this technology insertion effort.

Upon successful completion of this world cruise, the HVOF coated MLG Strut Assy has now accumulated a TOTAL of 330 Landings, including 164 Traps (arrested landings) and 162 Cat Shots (catapult launches) as of 19 Dec 2005.

Aircraft deployed to Alaska 5 – 21 Oct 2005

Aircraft transferred to VAQ-209 on 19 Dec 05

VAQ-138 EA-6B A/C 502

First carrier landing with HVOF coated
MLG Strut Assy installed at NADEP JAX

USS Carl Vinson 9-14-04

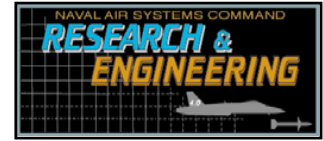








HVOF as a Hard Chrome Replacement



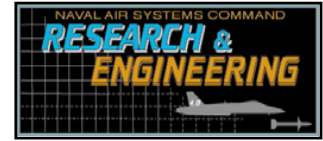
NAVAIR Approvals

**Authorization to implement HVOF on P-3 NLG &
MLG Pistons and Bomb Bay Door Actuators on
May 28, 2003**

**Successfully produced NAVAIR Materials Engineering
HVOF Coating Implementation Guidance Document
on March 3, 2005 mtg. @ Cherry Point**



HVOF as a Hard Chrome Replacement



AMS 2448 - HVOF Coating Application Specification
Published by SAE in October 2004

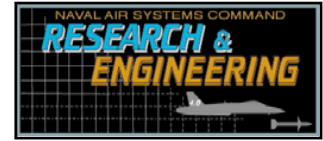
AMS 2449 – HVOF Grinding Specification
Published by SAE in August 2004

AMS 7881 – Tungsten Carbide-Cobalt Powder
Specification published by SAE in April 2003

AMS 7882 – Tungsten Carbide-Cobalt Chrome Powder
Specification published by SAE in April 2003



HVOF as a Hard Chrome Replacement



AMS 7881 & AMS 7882 – Powder Specifications

Revision A is currently being drafted to include changes that will accommodate Praxair/Tafa, Stellite, & other powders

Revision A to each powder spec will be presented to AMEC for balloting by Don Parker next week

AMEC Mtg. 189 @ Asilomar, Pacific Grove, CA

1 – 3 February 2006

AMEC will then forward Revision A specs to Committee B for approval

Donald.S.Parker@nasa.gov

HVOF as a Hard Chrome Replacement



HVOF Delivery Service

Any Questions?