



**DEPARTMENT OF THE AIR FORCE
AIR FORCE LIFE CYCLE
MANAGEMENT CENTER ROBINS AIR
FORCE BASE GEORGIA**

16 April 2021

MEMORANDUM FOR SEGERS CORPORATION

FROM: AFLCMC/WLNE

SUBJECT: Compliance With New TO 3H1-18-3 Propeller Overhaul Processes

References: Process Orders, Videos, and CMM Data provided by Segers Corporation

1. C-130 Engineering has reviewed the data provided by Segers in Attachment 1 and concurs that the process changes developed and implemented by Segers Aero Corporation, CAGE 0NMM2, comply with the revised requirements in TO 3H1-18-3 dated 1 November 2020 for 54H60 Propeller overhaul. Additionally, C-130 Engineering accomplished an on-site review of these new processes at the facility in Fairhope, Alabama on 22 March 2021 and determined that the new processes have been effectively integrated into the 54H60 propeller overhaul process.
2. This letter constitutes source approval of Segers Aero Corporation, CAGE 0NMM2 for overhaul of 54H60 propellers and is valid for three years from the date of this letter, at which time Segers Aero Corporation is subject to substantiation which can be submitted 6 months prior to the expiration. This statement serves as the only advance notification Segers Aero Corporation (CAGE 0NMM2) will receive prior to expiration/removal as an approved source at the expiration date.
3. Disposition of review materials will be processed in accordance with the cover letter disposition instructions.
4. Questions may be directed to Mike Fisher at (468) 926-5093.

Attachment 1 – Results of C-130 Engineering Review

Process	Substantiation Artifacts		
	Process order	Video	CMM/ Test
Blade Shank Machining and BTB rough-cut & LWTB Cut	X	X	X
Glass Bead Blasting the Taper Bore	X	X	
Manual Rotary Eddy Current Inspection	X	X	
TB White Light Borescope Inspection	X	X	
UT of butt face	X	X	
Etch (FPI prep)	X		X
Fluorescent Penetrant Inspection Taper Bore and Airfoil	X	X	
Thrust Washer Grinding Bevel Side	X	X	
Thrust Washer Grinding Flat Side	X	X	
Re-Rolling Aluminum Alloy Blades	X		X
Shot Peening the Airfoil	X		
Automatic Shot Peening the Taper Bore	X	X	
Automatic Shot Peening the Pin Holes and Screw Hole Re-Work on 7111 and 7121 Aluminum Alloy Blades	X	X	
Finish Ream Taper Bore and Bluing Check (1st OS)	X		X
Finish Ream Taper Bore and Bluing Check (2nd OS)	X		X
Measuring Taper Bore (Bushing area)	X		X
Measuring Taper Bore (LWTB)	X		X
Quality Control Plan for TB Machining	X		
Grit Blasting Airfoil	X	X	
Etch (anodize)	X		
Fairing Installation	X		
Permatreat and Epoxy Primer Application	X	X	X
Bushing Installation	X	X	X