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## REVISIONS

CHANGE	ITEM NO.	DESCRIPTION	DATE	DRAWN	CHECKED	STRESS	APPROVED
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**ALUMINUM OXIDE, ABRASIVE BLASTING  
(IVD PROCESS PRE CLEANING)****Requirements:****Classification:****Abrasive Materials:**

The material shall be uniform in appearance, non-caking, free flowing, and shall not contain foreign grit or free iron visible to the eye or easily separable with a magnet.

The grain appearance when viewed under magnification of 100X should be angular, multi-sided, and blocky with a maximum of 2 percent slivers or flats.

The grit should be 100% virgin aluminum oxide grains with a specific gravity of 3.93 - 3.97 grams/cc per ASTM-181C. The grit shall contain a minimum of 95% aluminum oxide and a maximum of 0.06% free iron.

The abrasive material shall conform to the particle size requirements per RR-S-366d specified in Table 1 below:

Grit No.	Sieve through Which 100% Must Pass	Control Sieve No.	Max.O/Size on Control Sieve (%)	Min Through Ctrl Sieve & Retained Percent On Sieve
220	100	200	15	30 230 & 270

The physical and chemical properties of the material shall conform to the requirements as noted above.

**Inspection:**

If a shipment of previously qualified material is found not meeting the requirements of this specification, the material shall be returned to the Manufacturer for replacement with new material. Production shipments shall be tested as frequently as deemed necessary.

**Qualification:**

The abrasive material furnished to this specification shall be a product which has been tested and approved as passing the qualification requirements of this specification.

**Materials and Manufacture:**

Products conforming to this specification shall be manufactured in accordance with the best commercial practices using high quality ingredient materials.

**Product Composition:**

A material that has been approved to this specification shall not have the formulation or methods of manufacture changed without approval.

**Preparation for Delivery:**

The abrasive material, in the quantity specified, shall be shipped in multiwall paper sacks or cardboard containers 100 lbs max. acceptable to common carrier or other suitable means. The lot number shall be on each bag and the lot numbers in the shipment shall be listed on the Manufacturer's shipper.

**Labeling:**

Each container shall be marked with the following information:

Part Number: - DSC-460  
Nomenclature: Aluminum Oxide Grit  
Grit Size:  
Lot Number:  
Manufacturer's Name:

NOTE: Procurement shall specify the DSC and the Vendor part number on the Purchase Order.

**Approved Suppliers:**

Exolon Company  
Sohio Electro Minerals Company  
Washington Mills Company  
Norton Company

Tonowanda, NY  
Niagara Falls, NY  
Grafton, MA  
Worcester, MA

## SOURCE CONTROL DRAWING

Only the item(s) listed on this drawing and identified by vendor's name(s), address(es) and part number(s) have been approved by the de Havilland Aircraft Company of Canada for use in DHC aircraft. A substitute item shall not be used without prior approval by the de Havilland Aircraft Company of Canada.

**deHAVILLAND**  
A BOEING COMPANY  
CANADA

DRAWN	KRONKAMP	18/6/91
CHECKED	P. LAM	21.06.19
APPROVED	L. SALNAIS	11.7.91
MTL & STDS	KRONKAMP	11-7-91
STRESS		
CH. DRAFTN.		

DRAWING TITLE  
ALUMINUM OXIDE, Abrasive Blasting,  
(IVD Process Pre-Cleaning)

REPORT ALL DRAWING ERRORS  
TO ENGINEERING

DWG SIZE	CODE IDENT NO.	DRAWING NO.	RELEASE	REV.
B	71867	DSC 460		
SCALE	WGT CALC	ACTUAL	SHEET	