

THE INFORMATION, TECHNICAL DATA AND DESIGNS DISCLOSED IN THIS DOCUMENT (THE "INFORMATION") ARE EITHER THE EXCLUSIVE PROPERTY OF BOMBARDIER INC., OR ARE SUBJECT TO PROPRIETARY RIGHTS OF OTHERS. THE INFORMATION IS NOT TO BE USED FOR DESIGN OR MANUFACTURE, OR DISCLOSED TO OTHERS WITHOUT THE EXPRESS PRIOR WRITTEN CONSENT OF BOMBARDIER INC. THE HOLDER OF THIS DOCUMENT, BY ITS RETENTION AND USE, AGREES TO HOLD THE INFORMATION IN CONFIDENCE. THESE RESTRICTIONS DO NOT APPLY TO PERSONS HAVING PROPRIETARY RIGHTS IN THE INFORMATION, TO THE EXTENT OF THOSE RIGHTS.

de HAVILLAND

CAGE CODE 71867

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 FOR USE IN DE HAVILLAND AIRCRAFT. A SUBSTITUTE ITEM SHALL NOT BE USED WITHOUT PRIOR APPROVAL BY DE HAVILLAND ENGINEERING STANDARDS

SOURCE CONTROL DRAWING

ITEM	DESCRIPTION	APPROVED VENDOR		
		PRODUCT	COLOUR	VENDOR
DSC536-1	TWO PART EPOXY POTTING COMPOUND	EY-3010 A/B	BLUE	FIBER RESIN CORP
DSC536-2		L-318	GREEN/ BROWN	J. D. LINCOLN INC

TYPICAL PHYSICAL PROPERTIES

		DSC536-1	DSC536-2
COLOUR:	PART A PART B	WHITE BLUE	WHITE GREEN/BROWN
MIX RATIO (By Weight))	PART A PART B	100 8	100 10
VISCOSITY MIXED		SOFT PASTE	
WORK LIFE @ 75 °F		20-25 MINUTES	12-20 MINUTES
FULL CURE:		7 DAYS @ 75 °F 3 HRS @ 150 °F	24 HRS @ 75 °F 1HR @ 150 °F

TYPICAL CURED PROPERTIES: NOTES:

PROPERTY	CONDITION	DSC536-1	DSC536-2
DENSITY: (GM/CC)		0.58	---
COMPRESSIVE STRENGTH, PSI	@ 75 °F AFTER 30 DAYS WATER IMMERSION	5000 3750	---
TENSILE LAP SHEAR, PSI		1600	---
SELF EXTINGUISHING		YES	---
COEFFICIENT OF THERMAL EXPANSION	α_1 , IN./IN./ °F. α_2 , IN./IN./ °F.	17.1×10^{-6} 36.6×10^{-6}	---
FLATWISE TENSION, LBS	NOTE 1	540	---
SHEAR, LBS		810	---
TORQUE OUT, IN.LBS		140	---
PULL OUT STRENGTH	NOTE 2	---	260 IN LBS
INSERT TENSION	NOTE 2	---	76 LBS
COMPRESSION		---	5000 PSI
COMPRESSION MODULUS		---	12000 PSI
NOTES: 1. PERFORMED USING SHUR-LOK SL607-3-78 INSERTS IN 1/4 IN AL CORE/.020 IN AL SKINS PANEL 2. BASED ON CDM 050.60 PANEL			

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	B. McDONALD	TITLE: POTTING COMPOUND, EPOXY (C&D INTERIOR RETROFIT ONLY)	DSC 536
CHECKED	P. LAM		
STRESS	---		
APPROVED	S. HAMID		PAGE 1 OF 2

REV:

REV:

REV:

REV:

REV:

REV:

APPROVED: 23 OCT 1998

THE INFORMATION, TECHNICAL DATA AND DESIGNS DISCLOSED IN THIS DOCUMENT (THE "INFORMATION") ARE EITHER THE EXCLUSIVE PROPERTY OF BOMBARDIER INC., OR ARE SUBJECT TO PROPRIETARY RIGHTS OF OTHERS. THE INFORMATION IS NOT TO BE USED FOR DESIGN OR MANUFACTURE, OR DISCLOSED TO OTHERS WITHOUT THE EXPRESS PRIOR WRITTEN CONSENT OF BOMBARDIER INC. THE HOLDER OF THIS DOCUMENT, BY ITS RETENTION AND USE, AGREES TO HOLD THE INFORMATION IN CONFIDENCE. THESE RESTRICTIONS DO NOT APPLY TO PERSONS HAVING PROPRIETARY RIGHTS IN THE INFORMATION, TO THE EXTENT OF THOSE RIGHTS.

de HAVILLAND

CAGE CODE 71867

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 FOR USE IN DE HAVILLAND AIRCRAFT. A SUBSTITUTE ITEM SHALL NOT BE USED WITHOUT PRIOR APPROVAL BY DE HAVILLAND ENGINEERING STANDARDS

SOURCE CONTROL DRAWING

STORAGE LIFE: 12 MONTHS @ 77 °F, MAXIMUM RELATIVE HUMIDITY OF 50%

ACCEPTANCE TEST:

	DSC536-1	DSC536-2
GEL TIME	30 MINUTES	30 MINUTES
DENSITY	< 0.60 GM/CC	< .090 GM/CC
SHORE 'D' HARDNESS	> 60	> 60

VENDORS ADDRESS:

FIBER RESIN CORP. 20701 NORDHOFF ST.
CHATSWORTH, CA 91311

J. D. LINCOLN INC. 851 W 18TH ST
COSTA MESA, CA 92627

NOTES:

PROCUREMENT DEPT SHALL SPECIFY THE DSC AND MANUFACTURER'S PART NUMBER ON THE PURCHASE ORDER

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	B. McDONALD	TITLE: POTTING COMPOUND, EPOXY (C&D INTERIOR RETROFIT ONLY)	DSC 536
CHECKED	P. LAM		
STRESS	---		
APPROVED	S. HAMID		PAGE 2 OF 2

REV:

REV:

REV:

REV:

REV:

REV:

APPROVED: 23 OCT 1998

THE INFORMATION, TECHNICAL DATA AND DESIGNS DISCLOSED IN THIS DOCUMENT (THE "INFORMATION") ARE EITHER THE EXCLUSIVE PROPERTY OF BOMBARDIER INC., OR ARE SUBJECT TO PROPRIETARY RIGHTS OF OTHERS. THE INFORMATION IS NOT TO BE USED FOR DESIGN OR MANUFACTURE, OR DISCLOSED TO OTHERS WITHOUT THE EXPRESS PRIOR WRITTEN CONSENT OF BOMBARDIER INC. THE HOLDER OF THIS DOCUMENT, BY ITS RETENTION AND USE, AGREES TO HOLD THE INFORMATION IN CONFIDENCE. THESE RESTRICTIONS DO NOT APPLY TO PERSONS HAVING PROPRIETARY RIGHTS IN THE INFORMATION, TO THE EXTENT OF THOSE RIGHTS.

de HAVILLAND

CAGE CODE 71867

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 FOR USE IN DE HAVILLAND AIRCRAFT. A SUBSTITUTE ITEM SHALL NOT BE USED WITHOUT PRIOR APPROVAL BY DE HAVILLAND ENGINEERING STANDARDS

SOURCE CONTROL DRAWING

ITEM	DESCRIPTION	APPROVED VENDOR		
		PRODUCT	COLOUR	VENDOR
DSC536-1	TWO PART EPOXY POTTING COMPOUND	EY-3010 A/B	BLUE	FIBER RESIN CORP
DSC536-2		L-318	GREEN/ BROWN	J. D. LINCOLN INC

TYPICAL PHYSICAL PROPERTIES

		DSC536-1	DSC536-2
COLOUR:	PART A PART B	WHITE BLUE	WHITE GREEN/BROWN
MIX RATIO (By Weight))	PART A PART B	100 8	100 10
VISCOSITY MIXED		SOFT PASTE	
WORK LIFE @ 75 °F		20-25 MINUTES	12-20 MINUTES
FULL CURE:		7 DAYS @ 75 °F 3 HRS @ 150 °F	24 HRS @ 75 °F 1HR @ 150 °F

TYPICAL CURED PROPERTIES: NOTES:

PROPERTY	CONDITION	DSC536-1	DSC536-2
DENSITY: (GM/CC)		0.58	---
COMPRESSIVE STRENGTH, PSI	@ 75 °F AFTER 30 DAYS WATER IMMERSION	5000 3750	---
TENSILE LAP SHEAR, PSI		1600	---
SELF EXTINGUISHING		YES	---
COEFFICIENT OF THERMAL EXPANSION	α_1 , IN./IN./ °F. α_2 , IN./IN./ °F.	17.1×10^{-6} 36.6×10^{-6}	---
FLATWISE TENSION, LBS	NOTE 1	540	---
SHEAR, LBS		810	---
TORQUE OUT, IN.LBS		140	---
PULL OUT STRENGTH	NOTE 2	---	260 IN LBS
INSERT TENSION	NOTE 2	---	76 LBS
COMPRESSION		---	5000 PSI
COMPRESSION MODULUS		---	12000 PSI
NOTES: 1. PERFORMED USING SHUR-LOK SL607-3-78 INSERTS IN 1/4 IN AL CORE/.020 IN AL SKINS PANEL 2. BASED ON CDM 050.60 PANEL			

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	B. McDONALD	TITLE: POTTING COMPOUND, EPOXY (C&D INTERIOR RETROFIT ONLY)	DSC 536
CHECKED	P. LAM		
STRESS	---		
APPROVED	S. HAMID		PAGE 1 OF 2

REV:

REV:

REV:

REV:

REV:

REV:

APPROVED: 23 OCT 1998

THE INFORMATION, TECHNICAL DATA AND DESIGNS DISCLOSED IN THIS DOCUMENT (THE "INFORMATION") ARE EITHER THE EXCLUSIVE PROPERTY OF BOMBARDIER INC., OR ARE SUBJECT TO PROPRIETARY RIGHTS OF OTHERS. THE INFORMATION IS NOT TO BE USED FOR DESIGN OR MANUFACTURE, OR DISCLOSED TO OTHERS WITHOUT THE EXPRESS PRIOR WRITTEN CONSENT OF BOMBARDIER INC. THE HOLDER OF THIS DOCUMENT, BY ITS RETENTION AND USE, AGREES TO HOLD THE INFORMATION IN CONFIDENCE. THESE RESTRICTIONS DO NOT APPLY TO PERSONS HAVING PROPRIETARY RIGHTS IN THE INFORMATION, TO THE EXTENT OF THOSE RIGHTS.

de HAVILLAND

CAGE CODE 71867

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 FOR USE IN DE HAVILLAND AIRCRAFT. A SUBSTITUTE ITEM SHALL NOT BE USED WITHOUT PRIOR APPROVAL BY DE HAVILLAND ENGINEERING STANDARDS

SOURCE CONTROL DRAWING

STORAGE LIFE: 12 MONTHS @ 77 °F, MAXIMUM RELATIVE HUMIDITY OF 50%

ACCEPTANCE TEST:

	DSC536-1	DSC536-2
GEL TIME	30 MINUTES	30 MINUTES
DENSITY	< 0.60 GM/CC	< .090 GM/CC
SHORE 'D' HARDNESS	> 60	> 60

VENDORS ADDRESS:

FIBER RESIN CORP. 20701 NORDHOFF ST.
CHATS WORTH, CA 91311

J. D. LINCOLN INC. 851 W 18TH ST
COSTA MESA, CA 92627

NOTES:

PROCUREMENT DEPT SHALL SPECIFY THE DSC AND MANUFACTURER'S PART NUMBER ON THE PURCHASE ORDER

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	B. McDONALD	TITLE: POTTING COMPOUND, EPOXY (C&D INTERIOR RETROFIT ONLY)	DSC 536
CHECKED	P. LAM		
STRESS	---		
APPROVED	S. HAMID		PAGE 2 OF 2

REV:

REV:

REV:

REV:

REV:

REV:

APPROVED: 23 OCT 1998