

BOMBARDIER

Toronto (de Havilland)

PROPRIETARY INFORMATION

PPS 16.26

PRODUCTION PROCESS STANDARD

APPLICATION OF ELEPHANT SKIN PROTECTIVE TAPE

- Issue 3
- This standard supersedes PPS 16.26, Issue 2.
 - Vertical lines in the left hand margin indicate changes over the previous issue.
 - Direct PPS related questions to PPS.Group@aero.bombardier.com or (416) 375-7641.
 - This PPS is effective as of the distribution date.

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	Quality	

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1 SCOPE

- 1.1 This Production Process Standard (PPS) specifies the procedure and requirements for the protection of aircraft skins using protective tape (elephant skin).
 - 1.1.1 This PPS complements the engineering drawings that specify its use as an authorized instruction. The procedure specified in this PPS must be followed to ensure compliance with all applicable specifications. In general, if this PPS conflicts with the engineering drawing, follow the engineering drawing. The requirements specified in this PPS are necessary to fulfil the engineering design and reliability objectives.
 - 1.1.2 Refer to [PPS 13.26](#) for the subcontractor provisions applicable to this PPS.
 - 1.1.3 Procedure or requirements specified in a Bombardier BAPS, MPS, LES or P. Spec. **do not** supersede the procedure or requirements specified in this PPS. Similarly, the procedure and requirements specified in this PPS are not applicable when use of a BAPS, MPS, LES or P. Spec. is specified.

2 HAZARDOUS MATERIALS

- 2.1 Before receipt at Bombardier Toronto (de Havilland), all materials must be approved and assigned Material Safety Data Sheet (MSDS) numbers by the Bombardier Toronto (de Havilland) Environment, Health and Safety Department. Refer to the manufacturer's MSDS for specific safety data on any of the materials specified in this PPS. If the MSDS is not available, contact the Bombardier Toronto (de Havilland) Environment, Health and Safety Department.

3 REFERENCES

- 3.1 [PPS 13.26](#) - General Subcontractor Provisions.
- 3.2 [PPS 31.17](#) - Solvent Usage.

4 MATERIALS AND EQUIPMENT

4.1 Materials

- 4.1.1 Protective tape (elephant skin), Protex 20V, Mask-Off Company, or equivalent.

4.2 Equipment

- 4.2.1 Stanley Utility Knife, 10-299, with a U.I.H. Hook Blade (available in CTS).
 - 4.2.1.1 Refer to [Figure 1](#) for a general description of a utility knife with a hook blade.
- 4.2.2 Gloves, neoprene (e.g., DSC 422-5).

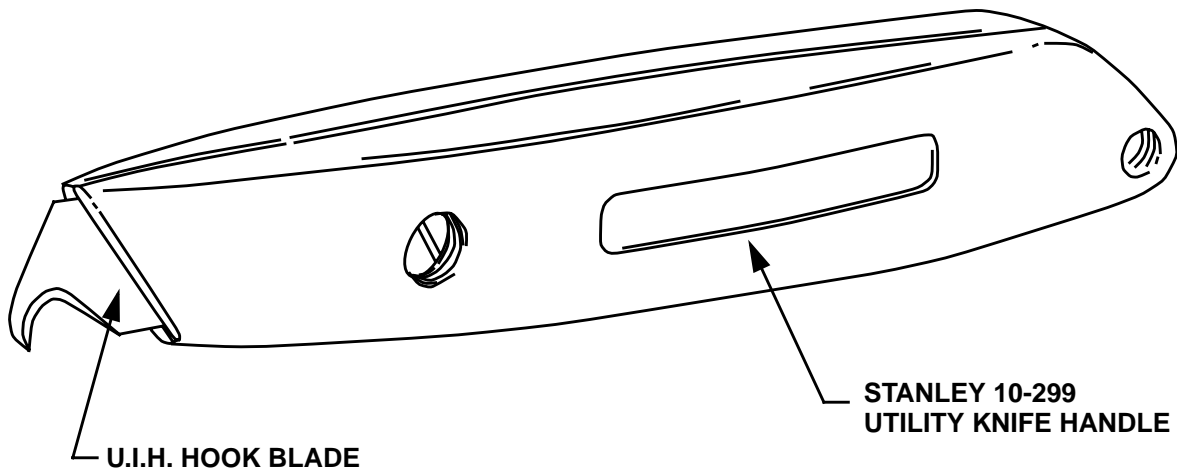


FIGURE 1 - GENERAL DESCRIPTION OF A UTILITY KNIFE WITH A HOOK BLADE

5 PROCEDURE

5.1 General

- 5.1.1 Elephant skin protective tape is used primarily to protect wing skins from scuffing, scratches, scrapes, ground in dirt, etc. caused by operators walking and working on the wing.

5.2 Preparation of Surface

- 5.2.1 Surfaces to be covered with elephant skin protective tape must be free of excessive grease, dirt, etc.
- 5.2.2 Remove excessive dirt, grease, etc. by solvent cleaning the affected area according to [PPS 31.17](#).

5.3 Application of Elephant Skin Protective Tape (see [Figure 2](#))

- 5.3.1 Using the applicable width of elephant skin protective tape, roll out a suitable length for the area to be covered.
- 5.3.2 Peel back the backing film for a short distance from one end of the length of elephant skin.
- 5.3.3 Apply the exposed adhesive to one end of the area to be covered by smoothly spreading out from one corner, taking care to avoid excessive creasing or creation of air bubbles.
- 5.3.3.1 Take care to ensure that the elephant skin protective tape is correctly oriented on the area to be covered.

- 5.3.4 Peel the backing film back a short distance further and secure according to [paragraph 5.3.3](#).
- 5.3.5 Repeat [paragraph 5.3.4](#) until the entire length is secured.
- 5.3.6 Trim the elephant skin protective tape to the profile of the protected area and from all cut-outs using a utility knife with a hook blade (see [paragraph 4.2.1](#)).
- 5.3.6.1 Take care to avoid scoring the surface when trimming the elephant skin protective tape.

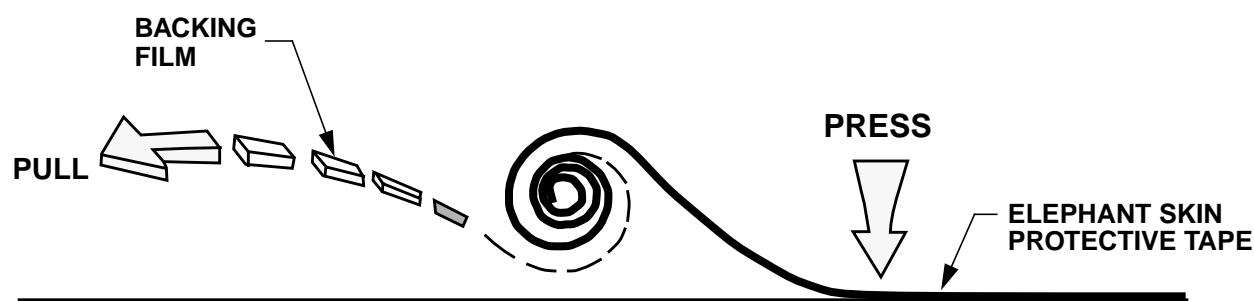


FIGURE 2 - APPLICATION OF ELEPHANT SKIN PROTECTIVE TAPE

6 REQUIREMENTS

- 6.1 Application of elephant skin protective tape shall be performed according to the procedure as specified herein.

7 SAFETY PRECAUTIONS

- 7.1 *Observe general shop safety precautions when performing the procedure specified herein.*
- 7.2 *Refer to [PPS 31.17](#) for the safety precautions for handling and using solvents.*

8 PERSONNEL REQUIREMENTS

- 8.1 Personnel responsible for the protection of aircraft skins using protective tape (elephant skin) must have a basic understanding of the procedure and requirements as specified herein and must have exhibited their familiarity to their supervisor.