

BOMBARDIER

Turboprops (de Havilland)

PROPRIETARY INFORMATION

PPS 25.66

PRODUCTION PROCESS STANDARD

CLEANLINESS REQUIREMENTS FOR APPLICATION OF ADHESIVES

- Issue 3
- This standard supersedes PPS 25.66, Issue 2.
 - PPS ACN 25.66/1 has been superseded in this or previous issues.
 - Vertical lines in the left hand margin indicate changes over the previous issue (e.g., changes initiated by Bombardier Corrective Action Request CAR #T4-4.9-133 and Bombardier Turboprops PPS Amendment Request AR #'s 8466 & 8486).

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1 SCOPE

- 1.1 This Production Process Standard (PPS) specifies the procedure and requirements for the application of adhesives in designated bonding areas.
 - 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 Turboprops, all materials must be approved and assigned Material Safety Data Sheet (MSDS) numbers by the Bombardier Turboprops 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 Turboprops Environment, Health and Safety Department.

3 REFERENCES

- 3.1 [PPS 13.26](#) - General Subcontractor Provisions.

4 MATERIALS AND EQUIPMENT

4.1 Materials

- 4.1.1 Kraft paper.

4.2 Equipment

- 4.2.1 Temperature and humidity control equipment capable of maintaining the requirements specified herein.
- 4.2.2 Temperature and relative humidity continuous chart recording equipment.

5 PROCEDURE

- 5.1 Maintain bonding area cleanliness within the requirements of [section 6](#) using the cleaning methods specified in [Table I](#).

6 REQUIREMENTS

6.1 Cleanliness of the Bonding Area

- 6.1.1 Clean bonding areas at the intervals specified in [Table I](#) or sooner if any accumulation of dust, dirt or other contamination is evident. Maintain records of dates of cleaning.

TABLE I - SCHEDULE FOR CLEANING BONDING AREAS

ITEMS	MAXIMUM CLEANING TIME INTERVAL	CLEANING METHOD
Tables	24 hours	Re-cover with clean Kraft paper
Floors	24 hours	Vacuum and/or damp mop
Equipment	24 hours	Wipe with damp cloth
Walls from the floor to a height of 7 feet (Note 1)	6 months (check condition at least once every 7 days and clean if necessary)	Appropriate method to remove accumulated dirt, dust, grease, etc.
Walls above 7 feet high, ceilings, beams, light fixtures, etc. (Note 1)	6 months (check condition at least once every 30 days and clean if necessary)	
Note 1. In designated bonding areas only (i.e., clean rooms, plastic shop, etc.).		

6.2 Temperature and Humidity Limits

- 6.2.1 Maintain the temperature and relative humidity of the bonding areas within the range specified in [Figure 1](#). Bonding when the relative humidity is below 30% will increase the chance of static discharge and worker discomfort, but will not affect part quality. Record the temperature and relative humidity of the bonding areas on continuous chart recording equipment when parts are being processed for Bombardier.

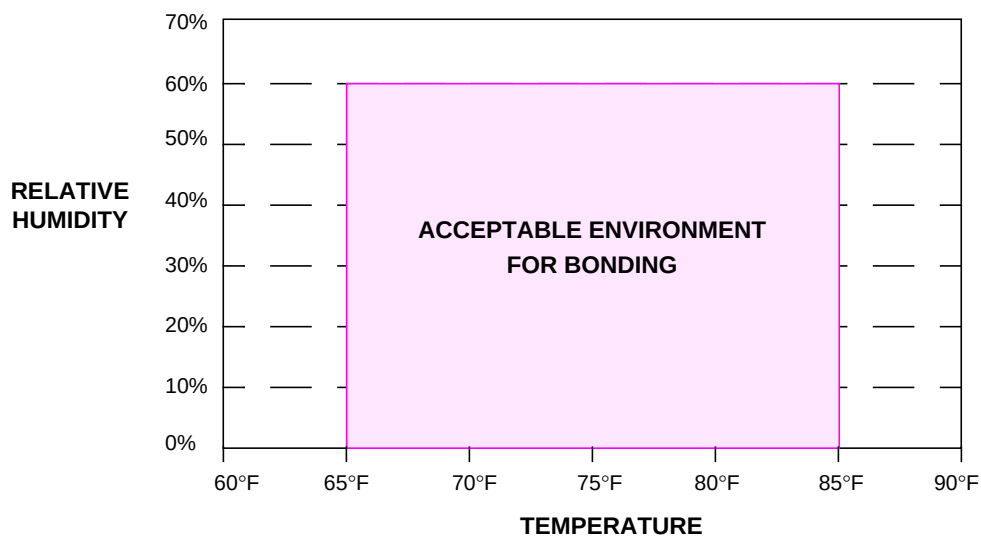


FIGURE 1 - TEMPERATURE AND HUMIDITY LIMITS FOR BONDING AREAS

7 SAFETY PRECAUTIONS

7.1 *Observe general shop floor safety precautions.*

8 PERSONNEL REQUIREMENTS

8.1 Personnel responsible for application of adhesives must have a basic understanding of the procedure and requirements as specified herein and must have exhibited their familiarity to their supervisor.