BOMBARDIER
Toronto (de Havilland)
PROPRIETARY INFORMATION

PPS 34.05

PRODUCTION PROCESS STANDARD

Application of Corrosion Inhibiting Jointing Compound (F16)

Issue 9
- This standard supersedes PPS 34.05, Issue 8.
- Vertical bars in the left hand margin indicate changes over the previous issue.
- Direct PPS related questions to PPS.Group@aero.bombardier.com or (416) 375-4365.
- This PPS is effective as of the distribution date.

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1 Scope

1.1 This Production Process Standard (PPS) specifies the procedure and requirements for the application of F16 corrosion inhibiting jointing compound.

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 13.28 - Storage Life of Adhesives, Sealants, Paints and Composite Products.

3.2 PPS 31.17 - Solvent Usage.

4 Materials and Equipment

4.1 Materials

4.1.1 Corrosion inhibiting jointing compound to DSC 489. If the engineering drawing, engineering order, manufacturing documentation (e.g., assembly manual) or PPS specifies the use of Densochrome paste, use DSC 489 compound.

4.2 Equipment

4.2.1 Suitable rubber, plastic, nylon or disposable wooden spatula.

5 Procedure

5.1 General

5.1.1 Only use DSC 489 corrosion inhibiting jointing compound if application of DSC 489 compound or F16 is specified on the engineering drawing, manufacturing documentation (e.g., assembly manual), or PPS.

5.2 Preparation of Material

5.2.1 DSC 489 corrosion inhibiting jointing compound is supplied in a ready to use condition and no mixing is required.

5.3 Preparation of Parts

5.3.1 Solvent clean the joint area of parts to which corrosion inhibiting jointing compound is to be applied according to PPS 31.17. Take care when cleaning primed or painted surfaces not to remove finish by using excessive quantities of solvent.

5.4 Application of Corrosion Inhibiting Jointing Compound

5.4.1 Use a non-metallic spatula or gloved hand to spread corrosion inhibiting jointing compound into both surfaces of the joint, leaving a smooth and continuous film approximately 0.001" - 0.002" thick covering the entire joint area of each surface.

5.4.2 Join surfaces immediately after applying the corrosion inhibiting jointing compound.

5.4.3 Install fasteners immediately after the joining surfaces have been brought together.

5.4.4 Use a non-metallic spatula to remove excess jointing compound which has extruded during the joining of the surfaces and solvent clean the area according to PPS 31.17.

5.4.5 Threaded portions of bolts, nuts, and fasteners which have become contaminated with a small amount of compound do not require cleaning unless the fasteners are to be torqued.

5.5 Clean-Up

5.5.1 Remove corrosion inhibiting jointing compound from equipment and other areas by solvent cleaning according to PPS 31.17.

6 Requirements

6.1 The applied film of corrosion inhibiting jointing compound shall be smooth, even, and continuous with a thickness of approximately 0.001" - 0.002" on each surface.

6.2 Defective areas, misaligned bolts or poorly fitted joints shall not be covered or filled with corrosion inhibiting jointing compound.

7 Safety Precautions

7.1 Observe general shop safety precautions when performing the procedure specified herein.

7.2 Do not smoke or eat in application areas.

7.3 Avoid skin contact with corrosion inhibiting jointing compound. Always wear protective gloves when handling compound.

7.4 Dispose of empty cans or wiping cloths contaminated with corrosion inhibiting jointing compound in approved oily waste cans.

7.5 Refer to PPS 31.17 for safety precautions relating to solvents

8 Personnel Requirements

8.1 Personnel responsible for the application of F16 corrosion inhibiting jointing compound must have a good working knowledge of the procedure and requirements as specified herein and shall have exhibited their competency to their supervisor.

9 Storage

9.1 Refer to PPS 31.17 for storage requirements of solvents.

9.2 Store corrosion inhibiting jointing compound in a dry area at a temperature of 40°F - 100°F; for optimum storage life, a temperature of 60°F - 80°F is recommended. Refer to PPS 13.28 for the storage life of DSC 489 corrosion inhibiting jointing compound. Clearly mark containers with the storage life expiry date. Issue oldest stock first. When not in use, keep containers tightly closed.