BOMBARDIER
Toronto Site
PROPRIETARY INFORMATION

PPS Revision Notice

As of March 2, 2016, the following PPS's have been released, having been revised as noted below:

PPS 21.05, Issue 8 - Sealing of Fibre Reinforced Composite Parts (F32)

- Revised PPS title to include finish code, F32.
- Revised scope of PPS to re-iterate PPS 21.05 use only when specified by the engineering drawing. Replaced paragraph 5.1.1 and 5.1.2 with the following statement, "In general, Tempo 1900, two-part epoxy clear coat is used to seal voids and pinholes in composite air ducts against air leaks".
- Specified Tempo 1900 to DHMS C4.11.
- Deleted precautionary statements regarding Tempo 1900 as containing isocyanate. Product does not contain isocyanate.
- Revised Tempo 1900 cure data to be per manufacturer's current technical data sheet (TDS): pot life from 4 hrs to 8 hrs; work area conditions from 65°F or above ambient and 40 - 80% relative humidity (RH) to 59 - 95°F and 35 - 75% RH; tack free from 2hrs to 4 hrs; cure before working from 12 hrs to 24 hrs.; cure data temperature 65 - 150°F and 40 - 80% RH to 75 ± 5°F and 50% RH; and added accelerated cure data.
- Deleted the term "ambient temperature" for work area conditions as too broad and vague. Defined the acceptable temperature range for the work area.
- Specified that all testing and evaluation specified in PPS 21.05 shall only be performed by Bombardier Toronto Materials Laboratory or by laboratories accredited according to BAERD GEN-018.
- Revised Safety Precautions section.
- Specified to issue clear coat on a first in/first out (FIFO) basis.
- Revised storage temperature range to reflect that of Tempo 1900 current TDS.

PPS 32.35, Issue 12 - Chemical Conversion Coating for Low Electrical Resistance (C10)

- Specified abrasive paper to be 180 - 240 grit size and of aluminum oxide.
- Specified SD 8383 as an example of an acceptable spot facing tool.
- Added the option of AEMC Micro-Ohmmeter, Model 6250 use.
- Removed the term "digital" ohmmeters from paragraph 5.3.3.1.1 and 5.3.6 as the list of approved ohmmeters specified in the PPS includes non-digital ohmmeters.
- Replaced the term "high resistance film" with "non-conductive coating" throughout PPS.
- Revised chemical waste disposal requirement. Specified EHS-OP-005 applies to Bombardier Toronto only. For suppliers, dispose of all chemical waste solutions according to the country's national legislation and local regulations.

- Revised preparation of parts for manual chemical conversion coating section.
  - Deleted use of water moistened abrasive pads or abrasive paper. Specified to remove non-conductive coating with 180 - 240 grit aluminum oxide abrasive paper. Specified it is acceptable to use spot facing tool to remove the bulk of the non-conductive coating provided that final removal is performed by hand abrading.
  - Deleted verifying previously masked area and verify only the areas where non-conductive coatings have been removed prior to applying C10 coating.