

As of October 26, 2016, the following PPS's have been released, having been revised as noted below:

PPS 25.23, Issue 10 - Bonding using DHMS A6.11 Type I Class 1 Adhesive

- Deleted QAMTR 007 as receipt, shelf life and extension testing shall be as specified in PPS 13.28.
- Revised Facilities Requirements section wording.
- As this process is no longer being performed in Bombardier Toronto site, hence, specified that safety precautions applicable to the materials and procedures specified herein shall be defined by the subcontractor performing the work for Bombardier Toronto.
- Specified storage temperature to be 40 to 80°F in place of 60 to 80°F.
- Specified to always use oldest stock first (i.e., first in/first out (FIFO) basis).

PPS 30.04, Issue 33 - Steel Heat Treatment - Carbon and Low Alloy Steels

- Replaced throughout "oven" with "furnace".
- Specified that quenching vacuum furnaces shall meet Class 25 Type C per BAERD GEN-007.
- Specified soaking times for vacuum furnaces and when soak times begins.
- For soak baths, specified that soaking time commences when the control temperature returns to the specified set temperature after the insertion of the load.
- Added to section 4.2.6, "Oil used in integral vacuum furnace systems, where the quench chamber is below atmospheric pressure, shall be hot vacuum degassed when the tank is first filled and again after each major oil addition".
- Added to quenching section 5.8.4, "When a vacuum furnace with an integral oil quench is to be employed, the parts shall be transferred from the heating chamber to a chamber separated by a physical partition capable of being under partial pressure with an inert gas from which parts shall be quenched in circulating oil." and also the following, "Inert gases employed for quenching in vacuum furnaces shall conform to section 4.1. The furnace shall be capable of recirculating the inert gas in order to achieve the required cooling rates."

PPS 38.02, Issue 12 - Installation of Heating and Insulating Blankets

- Added the option of DSC 91-21 securing tape.
- Added CSP 519-4 and CSP 519-5 clips.

This revision notice lists brief summaries of technical changes introduced for each of the revised PPS's. Please note that these summaries are not detailed and are intended only to assist in alerting PPS users to changes which may affect them; refer to the applicable PPS for authorized, detailed procedure and requirements.
