

As of July 20, 2018, the following PPS's have been released, having been revised as noted below:

## **PPS 2.01, Issue 31 - Installation of Solid Rivets**

- Defined the term "MRB" in the General Procedure section to avoid repetitiveness throughout the PPS.
- Revised term "head thickness" with "head height" throughout.
- Modified note 1 in Table 5 (i.e., Deleted mentioning countersinks; Clarified that drill size is recommended provided that final hole size requirements of Table 4 are met).
- Modified note 1 in Table 6 to clarify that drills and drill/countersinks for use with Spacematic or Q-Matic Drillmotors are recommended provided that Table 4 or Table 9 requirements are met.
- Deleted the term "recommended" from Table 7, Table 8, Table 9, paragraph 5.2.4, and paragraph 5.6.5.
- Clarified that drills or drill/countersink are recommended provided that final hole/countersink size are met as specified in Table 4 or Table 9.

## **PPS 25.53, Issue 9 - Bonding using 2262 Adhesive**

- Revised 3M adhesive name from "EC-2262" to "2262".

## **PPS 31.02, Issue 35 - Cleaning Processes for Aluminum and Aluminum Alloys**

- Specified that all testing and evaluation specified in PPS 31.02 shall only be performed by Bombardier Toronto Materials Laboratory or by laboratories accredited according to BAERD GEN-018.
- Updated product name of Turco 4215 NC-LT to Bonderite C-AK 4215 NC-LT. Deleted Turco 4215 Additive as it is not on the Bonderite C-AK 4215 NC-LT technical data sheet.
- Deleted Turco 53 from alkaline cleaning list.
- Specified that for cleaning before fusion welding or brazing, parts must be degreased according to PPS 31.04 prior to subsequent cleaning steps.
- Revised cleaning procedures for all parts prior to fluorescent penetrant inspection.
- Added details for in-situ cleaning prior to FPI for all parts (i.e., not just RNC parts). Specified solutions to use and preparation details.
- When rinsing after FPI, specified all rinse water as specified in PPS 31.02 Table III are acceptable options (i.e., initial, final, spray or de-ionized water rinses).
- Added a section on how to determine the etch rate for the in-situ 15% sodium hydroxide paste utilized for manual FPI.

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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.

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# PPS Revision Notice

- Specified to oven dry parts following cleaning according to PPS 20.03 prior to performing FPI.
- Clarified that when determining between degreasing or solvent cleaning, if degreasing is possible, do not solvent clean parts, but degrease according to [PPS 31.04](#).
- Deleted Flow Chart regarding "In-Situ Alkaline Cleaning".
- Revised Flow Chart 6 to "Manual Deoxidizing".

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