BOMBARDIER
Toronto Site
PROPRIETARY INFORMATION

PPS Revision Notice

As of November 6, 2018, the following PPS's have been released, having been revised as noted below:

PPS 13.39, Issue 7 - Bombardier Toronto Engineering Process Manual

- Specified the following as "Controlled Special Process": PPS 6.10, PPS 22.06, PPS 22.07, PPS 22.12 and PPS 31.06.

PPS 21.19, Issue 16 - Sealing Removable Parts

- Replaced discontinued MS-143H with MS-143HN.

PPS 32.35, Issue 13 - Chemical Conversion Coating for Low Electrical Resistance (C10)

- Specified that compressed air utilized must meet BAERD GEN-023.
- Updated the following product name:
    - Oakite Chromicoat L-25 to Chemetall Chromicoat L-25
    - Bonderite M-CR 1200 to Bonderite M-CR 1200 Aero
    - Bonderite M-CR 1000 to Bonderite M-CR 1000L Aero
    - Deleted option of Alodine 1000
    - Alodine 1201 to Bonderite M-CR 1201 Aero
- Added option of AEMC Micro-Ohmmeter Model 6240.
- Specified that solution make-up procedure is also applicable to top up of solution.
- Deleted the term "tap water" from solution make-up as any water is acceptable provided the water quality requirements are met (i.e., TDS).
- Specified to allow new Bonderite M-CR 1200 Aero solution to stand for at least 24 hours prior to use.
- Revised Bonderite M-CR 1200 Aero solution initial concentration make-up to 1.5 Kg/100 L in place of 18 g/L.
- Specified an extended solution control analysis base on consecutive successful 12 months testing (i.e., through SPC charts, etc.).
- Defined "room temperature" as 60 to 90°F.
- Specified to always use the oldest stock first (i.e., first in/first out (FIFO) basis).
- Specified that at Bombardier Toronto, dispose of chemical contaminated work clothes, rags, etc., into Red Containers labelled "Waste Rags".

PPS 36.07, Issue 12 - Metal to Metal and Metal to Metal Honeycomb High Strength Bonding Using DHMS A6.03 Adhesive Film and Primer

- Replaced where Cor-Fil 615 low density filler is specified with DHMS P1.30 honeycomb core filler. Specified to prepare and cure DHMS P1.30 epoxy resin according to PPS 13.23.
- Replaced where Frekote 33 is specified with DSC 234-13-3 or DSC 234-13-4 release agent.
- Specified Kraft paper should be neutral.
- Defined controlled contamination area (CCA) as the work area conditions and environmental control requirements that meet the requirements as specified in PPS 36.21.
- Specified to store, handle and prepare DHMS A6.03 and DHMS A6.06 film adhesives according to PPS 10.25. Deleted all details within this PPS to avoid conflict with information specified in PPS 10.25.
- Clarified that adhesive primer in section 5.2.2 is to DHMS A6.03-1.
- Specified the cotton gloves should be lint-free.
- Added new Step 8 in Autoclave Curing section.
- Added new details for when the engineering drawing specifies “Edge Filling” of panels (see section 5.10).
- Specified to use DHMS S3.01 Type II Class B sealant wherever PR1422 B2 and B1/2 sealant is specified. Specified to prepare and cure DHMS S3.01 according to PPS 21.20.
- As PPS 36.07 is categorized as a Controlled Critical Process, added new Personnel Requirements section and referred to PPS 13.39 for personnel requirements.
- Deleted Process Baths section as the processing PPS will determine the requirements (i.e., within PPS 31.13 and PPS 32.11).
- Added new Disposal of Chemical Waste section.
- Replaced “alodine” with “C1 coating”.