



# PPS Revision Notice

As of April 13, 2020, the following PPS's have been released, having been revised as noted below:

## **PPS 10.44, Issue 6 - Application of Liquid Shims**

- Replaced throughout PPS where "Bombardier" is specified with "De Havilland Aircraft of Canada Limited" or "DHC".
- Added a safety precaution to wear personal protective respiratory equipment as specified in PPS 13.13 when bonding liquid shim using DHMS A6.09 adhesive.
- Added disposal of chemical wastes section.
- Specified to use the oldest stock first (i.e., first in/first out (FIFO) basis).

## **PPS 13.28, Issue 25 - Storage Life of Adhesives, Sealants, Paints and Composite Products**

- Replaced throughout PPS where "Bombardier" is specified with "De Havilland Aircraft of Canada Limited" or "DHC".
- Added a summary table in Reference section for all testing documents called out in Table II (STORAGE LIFE OF ADHESIVES, SEALANTS, PAINTS AND COMPOSITE PRODUCTS).
- Specified use of BAERD GEN-018 is frozen at revision E.
- Specified to perform receipt and shelf life extension testing of DHMS A6.06 adhesive to the DHMS and not to QAMTR 007.
- Specified shelf life/storage life of DHMS A6.13 components (i.e., unmixed base and catalyst) is 24VS for base (resin) and 36VS for catalyst.

## **PPS 32.05, Issue 22 - Colour or Colourless Anodizing - Sulphuric Acid Process (A3)**

- Replaced throughout PPS where "Bombardier" is specified with "De Havilland Aircraft of Canada Limited" or "DHC".
- Updated ASTM B117 and ASTM B137 titles.
- Specified use of BAPS 160-032 is frozen at Revision C; The use of 180 Series BAPS shall be the frozen revision as of June 1, 2019. Subsequent BAPS revisions cannot be used.
- Specified use of BAERD GEN-018 is frozen at Revision E.
- Specified compressed air shall meet the requirements of BAERD GEN-023, Rev A.
- Added details on racking equipment.
- Specified to equip sealing and rinse tanks with inlet and outlet provisions to allow fresh de-ionized water to be added, as required, to maintain the baths within the limits specified in Table VI (CONTROL OF SOLUTIONS).

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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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- Specified one anodic sealing option (i.e., hot de-ionized water anodic seal). Deleted Bonderite M-CR T5900 Aero Seal, Metalast TCP-HF Seal, SurTec 650 Seal, Sodium or Potassium Dichromate Seal, Nickel or Cobalt Acetate Seal due to REACH.
- Added new Process Qualification section since this PPS is categorized as a controlled critical process.
- Defined new requirements for situations whereby suppliers are not processing DHC parts continuously.
- Added a summary of all the testing requirements required for production parts.
- Added 2024-T3 per QQ-A-250/4 (0.032" min) test panel as an option for determining coating weight in addition to LAB 065-1.
- Added 2024-T3 per QQ-A-250/4 (0.032" thick minimum) test panels as an option for corrosion resistance testing in addition to LAB 064-1.
- Revised visual sampling plan.
- Added detail on corrective action should testing fail. Added new Disposition section. Specified in addition to the number of times parts can be re-processed, ensure the total of material loss per part surface does not exceed 0.0010", providing dimensional tolerances permit such material loss.
- Specified solution test results should be maintained according to QDI-09-02.
- Deleted "Bright Dip Alternate" from Solutions Control table as there's no call out for the use of Bright Dip in the PPS.
- Added TDS requirements to hot de-ionized water sealing tank.
- Added new Disposal of Chemical Wastes and Maintenance of Equipment sections.

## **PPS 34.34, Issue 19 - Surface Finishing Compounds (F33)**

- Replaced throughout PPS where "Bombardier" is specified with "De Havilland Aircraft of Canada Limited" or "DHC".
- Allowed use of the following masking paper and masking tape, when masking is required:
  - Masking paper, non-adhesive (e.g., 3M #06539, 3M #06736 "Scotchlok" or Kraft paper). Secure masking paper in place using the masking tape specified below.
  - Masking tape utilizing rubber based adhesive (e.g., 3M #218 or 3M #8428).
- Deleted DSC 206-2 Huntsman Epibond 156 A/B as it is no longer approved for use under the DSC.
- Replaced all reference to Akzo Nobel with reference to AkzoNobel.

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- Replaced references to Akzo Nobel Aerospace Coatings 469-9CA-41B epoxy polyamine putty with reference to AkzoNobel Aerospace Coatings 467-9 composite filler putty; 467-9 composite filler putty is a 2 part compound comprising 467-9 base and CA-41B curing solution.
- Specified that the pot life specified in Table IV (Pot Life Data) is for a 100 gram mix unless otherwise specified. Specified a tolerance for both the application temperature and relative humidity pot life definition.
- Allowed use of DSC 206-2 compound instead of DSC 206-1 compound on aircraft exterior components (i.e., not limit the option to only subcontractors).
- Specified cure times specified in Table V (Curing Data) are minimum times and defined room temperature for curing to be  $75 \pm 5^{\circ}\text{F}$ .
- Added new Disposal of Chemical Waste section.
- Specified to always use the oldest stock first (i.e., first in/first out (FIFO) basis).

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