



PPS Revision Notice

As of May 31, 2021, the following PPS's have been released, having been revised as noted below:

PPS 31.05, Issue 30 - Surface Treatment of Corrosion Resistant Steel (C9)

- Specified this is a jointly owned PPS by both De Havilland Aircraft of Canada Limited and Bombardier Inc.
- Specified laboratories performing evaluation of DASH 8 parts must be approved according to DAGER-006.
- Specified use of BAPS 180-015 for passivation of parts must be at frozen Revision B for processing DASH 8 parts.
- Clarified immersion tanks requirements.
- Revised Facilities Requirements section.
- Allow use of alternate equivalent clean protective gloves when handling cleaned parts.
- Defined initial and final rinse controls.
- Revised tap water control to meet the following: 550 $\mu\text{S}/\text{cm}$ at $77 \pm 10^\circ\text{F}$ maximum; pH of 5.0 - 8.0; and 30 ppm maximum Chlorides (Cl^-).
- Added a note to every intermediate cleaning table specifying that to carry out "etching" before FPI only when specified by the engineering drawing or [PPS 20.03](#). Only parts that have undergone metal smearing operations or operations that will smear metal or otherwise close that have undergone metal smearing operations or operations that will smear metal or otherwise close surface openings must be etched prior to FPI. See [PPS 20.03](#) for a list of such operations. Ensure that the minimum part thickness is maintained in the etched area. Do not etch parts otherwise.
- Specified if FPI is required by the RNC, perform FPI according to [PPS 20.03](#).
- Specified that all parts should be oven dried prior to FPI.
- Deleted Ridoline 153 as an option for alkaline cleaning.
- Renamed Ridoline 53 with Bonderite C-AK 53 Aero. Revised solution control as per manufacturer's technical data sheet (TDS).
- Renamed alkaline cleaner Turco Airlion 4090 to current product name, Bonderite C-AK 4090 Aero. Revised solution control as per manufacturer's TDS.
- Renamed alkaline cleaner Turco 4215 NC-LT to current product name, Bonderite C-AK 4215 NC-LT Aero. Revised solution control as per manufacturer's TDS.

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 37.03, Issue 18 - Fusion Welding of Aluminum Alloys

- Specified this is a jointly owned PPS by both De Havilland Aircraft of Canada Limited and Bombardier Inc.
- Revised Facilities Requirements section.
- Specified all testing must be performed DHC/BA Toronto Materials Laboratory or by laboratories accredited according to DAGER-006 (DASH 8) or BAERD GEN-018 (Lear 45), as applicable.
- In addition to the requirements specified in PPS 13.39, added additional personnel requirements.

PPS 37.06, Issue 32 - Testing and Certification of Aircraft Fusion Welders

- Specified this is a jointly owned PPS by both De Havilland Aircraft of Canada Limited and Bombardier Inc.
- Specified that aircraft welders certified according to BAERD GEN-010 is considered certified to this PPS for Lear 45 program only.
- Specified for DASH 8 program, laboratories should be accredited according to DAGER-006.
- Added additional requirements regarding certification (see [paragraph 5.1.3](#), [paragraph 5.1.4.1](#), [paragraph 5.1.4.2](#)).
- Deleted allowance of using BCAR A8-10 as equivalent test joints to LAB 057 or LAB 058.
- Removed tube requirement from base metal form when certifying welders (see item e in [paragraph 5.1.8](#)).
- Where a welder is being certified to weld “non-standard” parts, added the requirement that all modification must be subject to the approval of the Welding Specialist.
- Revised maximum limit for visual examination defect limits for butt weld mis-match defect from 0.15T to 0.15" + 10% T or 0.040" maximum, whichever is less. See [Table IV](#).
- Specified the base metal thickness of weld test specimens is controlled by lab drawings LAB 057 (butt welds) and LAB 058 (fillet welds) for all facilities and not just DHC/BA site.
- Revised Base Metal Thickness ([section 5.4.3](#)) section as follows: For both butt welds and fillet welds, an acceptable test weld in a base metal of thickness “T” (sheet wall thickness) certifies welders to weld the base metal in the thicknesses range of 0.67T to 4T. Where the base metal thickness (T) for an acceptable test weld is greater than 1 inch, certify welder to weld material in the thicknesses range 0.67T to unlimited.

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- Added additional requirements for tensile testing (see [paragraph 6.4.3](#) and [paragraph 6.4.4](#)).
- Specified the value in [Table VII](#) for the acceptance limits for metallographic examination for incomplete root penetration applies to aluminum alloys only. For all other materials, complete fusion to the root of the weld is required.
- Revised Safety Precautions section.

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