

P/N:

N/A

DESIGNATION

N/A

Prepared by: Marta Guerrero Ramos

Date: 10-05-2010

Approved by:

Date: 09-06-2010

DESCRIPTION:

REACTIVATION AND APPLICATION OF PRIMER P05

**REFERENCE DOCUMENTS.**

- **IFMA-389** PAINTING AIRCRAFT GENERAL INSTRUCTIONS
- **IFMA-195** APPLICATION OF STRONTIUM CHROMATE EPOXY PRIMER
- **IFMA-310** USE OF DEGREASING PRODUCTS

**- STL`s:**

332A2101001702 Ind.E  
332A2101021002 Ind.C  
332A2401370305  
332A2400311103 Ind.A  
332A2111240305 Rev 0  
332A2111170405 Rev 0

**- DRAWINGS:**

332A210100 AR  
332A210102 AM  
332A240137 Q  
332A240031 AO  
332A211124 R  
332A211117 U

**MATERIALS AND EQUIPMENT.****Thinners, bases, Catalyst and degreasing products:**

- Diestone
- HYSO 99.
- DHS186-111.20 BASE: 7835 NV yellow
- DHS186-111.21 CATALYST: 7835 NV Colourless
- DHS186-111.22 THINNER: 7928

} PRIMER: P05

**Equipment:**

- Vacuum cleaner and compressed air.
- White cotton cloths.
- Brush.
- Gun.
- Scott Brite.
- Abrasive paper (grit 400 or 320).
- Thermohygrograph

**Safety equipment:**

- Protective eyewear
- Disposable latex gloves
- Mask
- Disposable protective clothes

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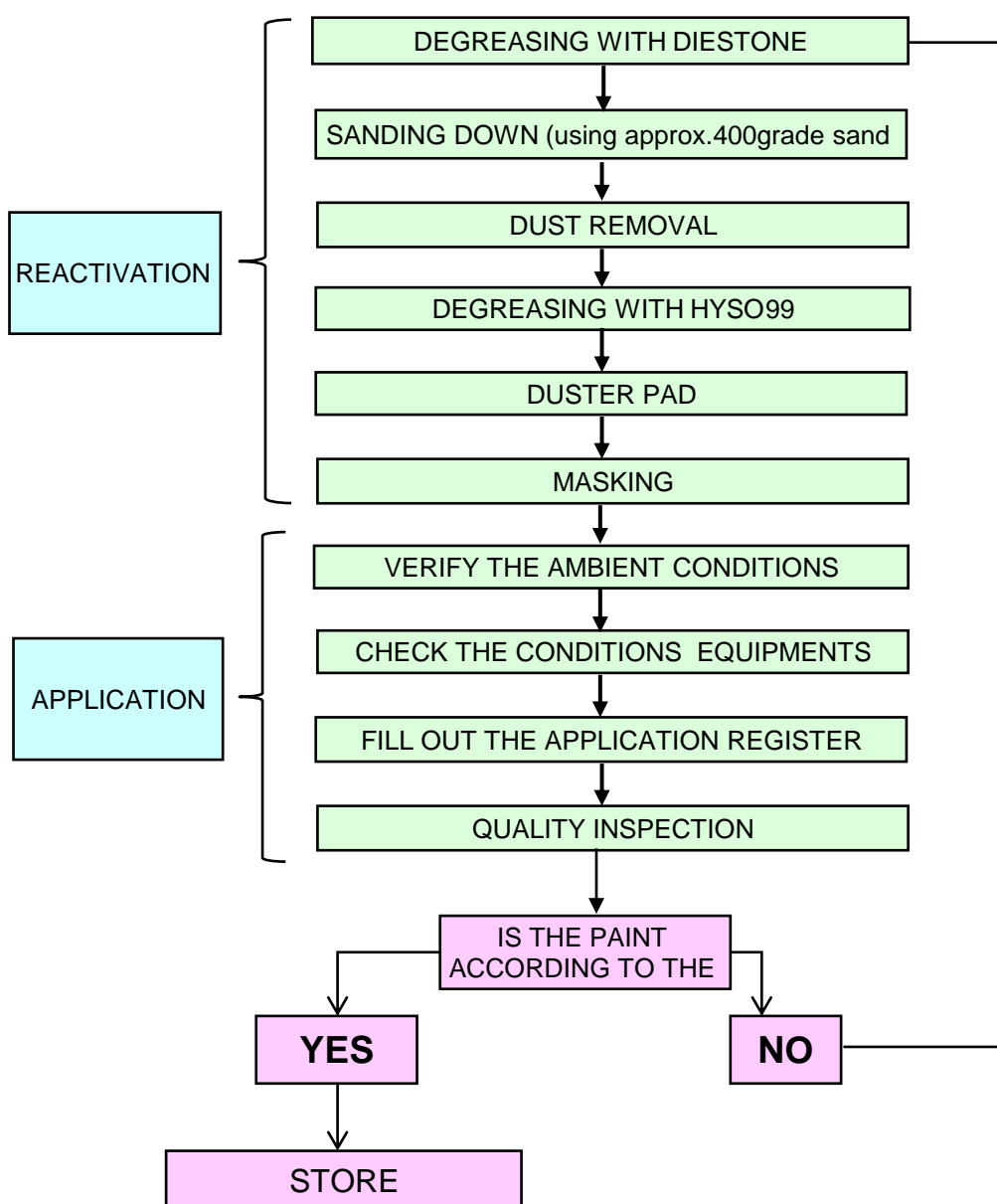
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**REACTIVATION (of a painted surface)**

Degreasing/ cleaning with DIESTONE.



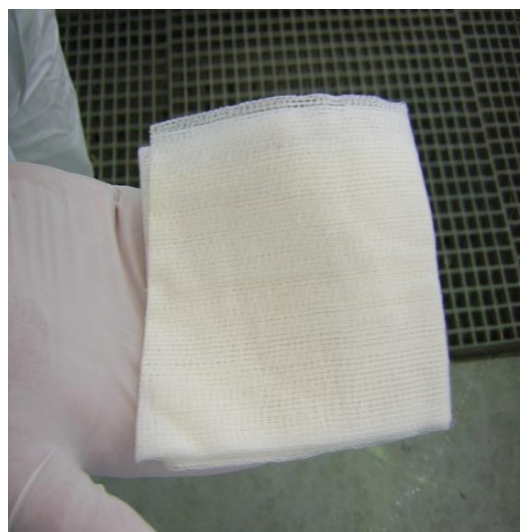
Sanding using approx. 320/400 grit abrasive paper.



After sanding of primer P05. Deagreasing/ cleaning with HYSO 99.



Wiping with an "anti-dust" cloth.



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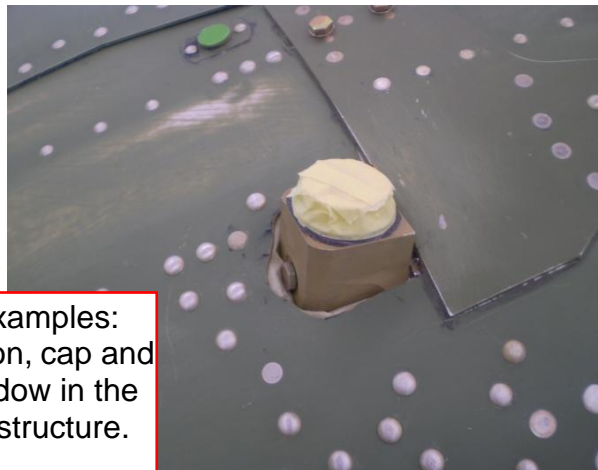
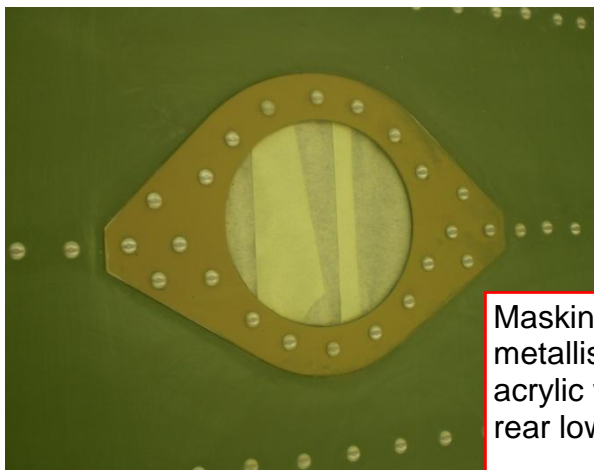
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### MASKING MATERIAL

Protect all surfaces which will be not painted with primer.  
All metallizations, acrylic windows, tires, etc., must be masked with adhesive tape or stickers to prevent deposition of primer.



Masking examples:  
metallisation, cap and  
acrylic window in the  
rear lower structure.



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## APPLICATION OF PRIMER P05

Verify that the ambient conditions for the application of primer in the paint booth are within specified parameters.

**TEMPERATURE: 15°C~25°C**  
**RELATIVE HUMEDITY: 40%~70%**

PRIMER P05 is mixed according to the TI G6-SP-001.

Before the application of primer, check the perfect cleaning of the area of application, and that the application equipment is clean and dry.

**It s obligatory to wear latex gloves and mask during the application of the**

Apply the mixture in one coat, i.e. 2 crossed films (1 vertical pass, 1 horizontal pass)  
Thickness of dry film is about 12 to 20microns for one coat.  
Aplication is done with nozzle diameter between 1.4mm and 1.6mm, air pressure: 1,5 to 2bars.

**Fill out all data required in Application Register**



- a) Mixing number
- b) Date / Time of application start
- c) Product
- d) Touch-up
- e) Paint type
- f) Relative Humidity
- g) Temperature
- h) End time of application
- i) Time of application start drying
- j) End time of application drying
- k) Drying temperature
- l) Operators (painter) sign
- m) Verification of thickness and paint adhesion

Quality Requirements after application of the primer: dry coat must be even and of uniform colour, with no surface irregularities such as blistering, pronounced "orange peel", grain, dullness, etc...

The following are areas where PRIMER P05 is applied: front lower structure, rear lower



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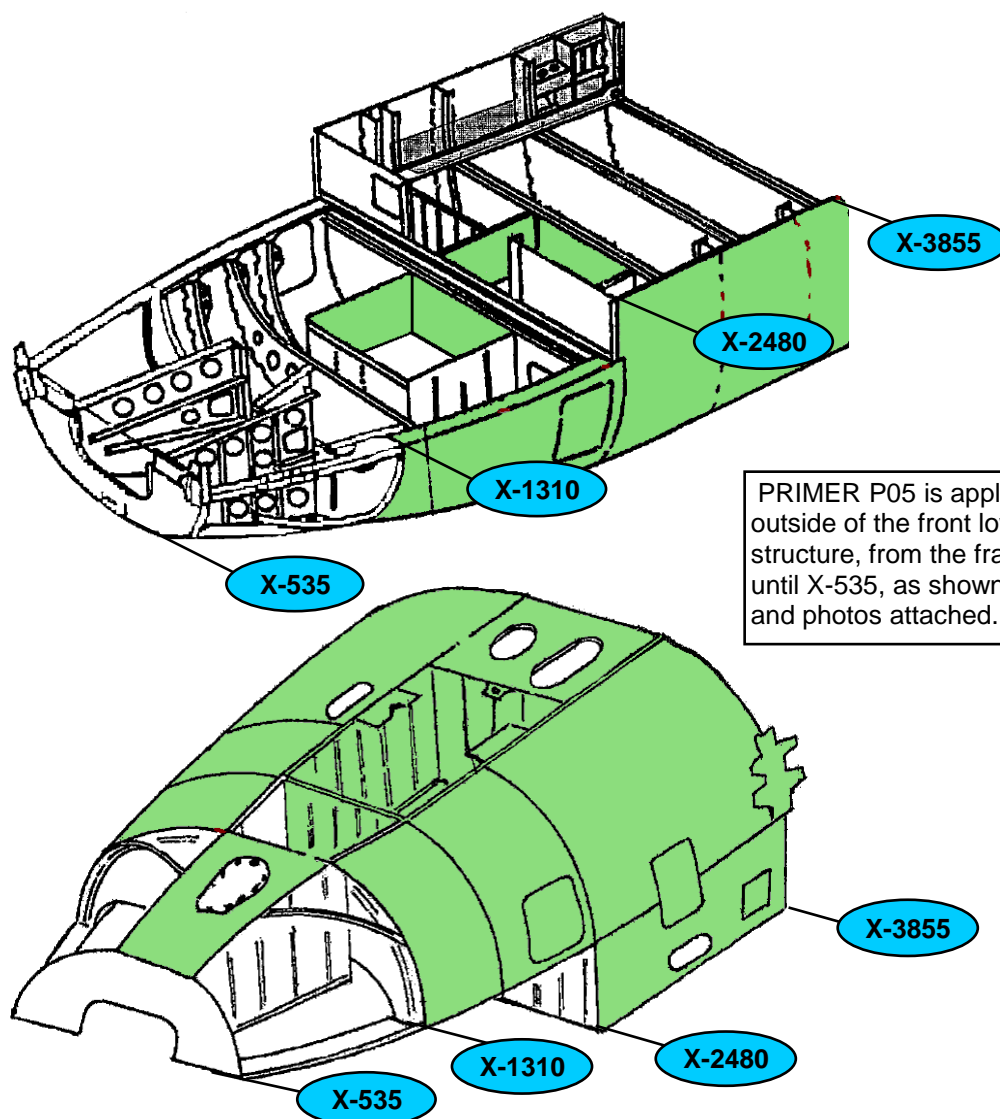
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## APPLICATION OF PRIMER IN FRONT LOWER STRUCTURE



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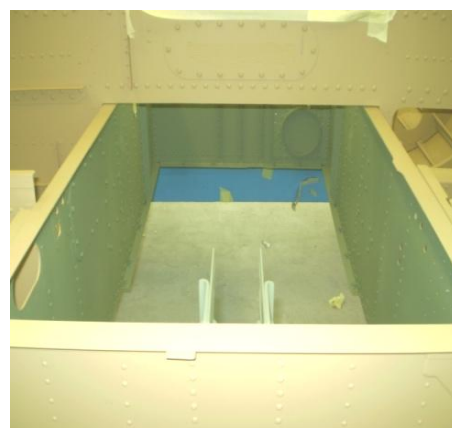
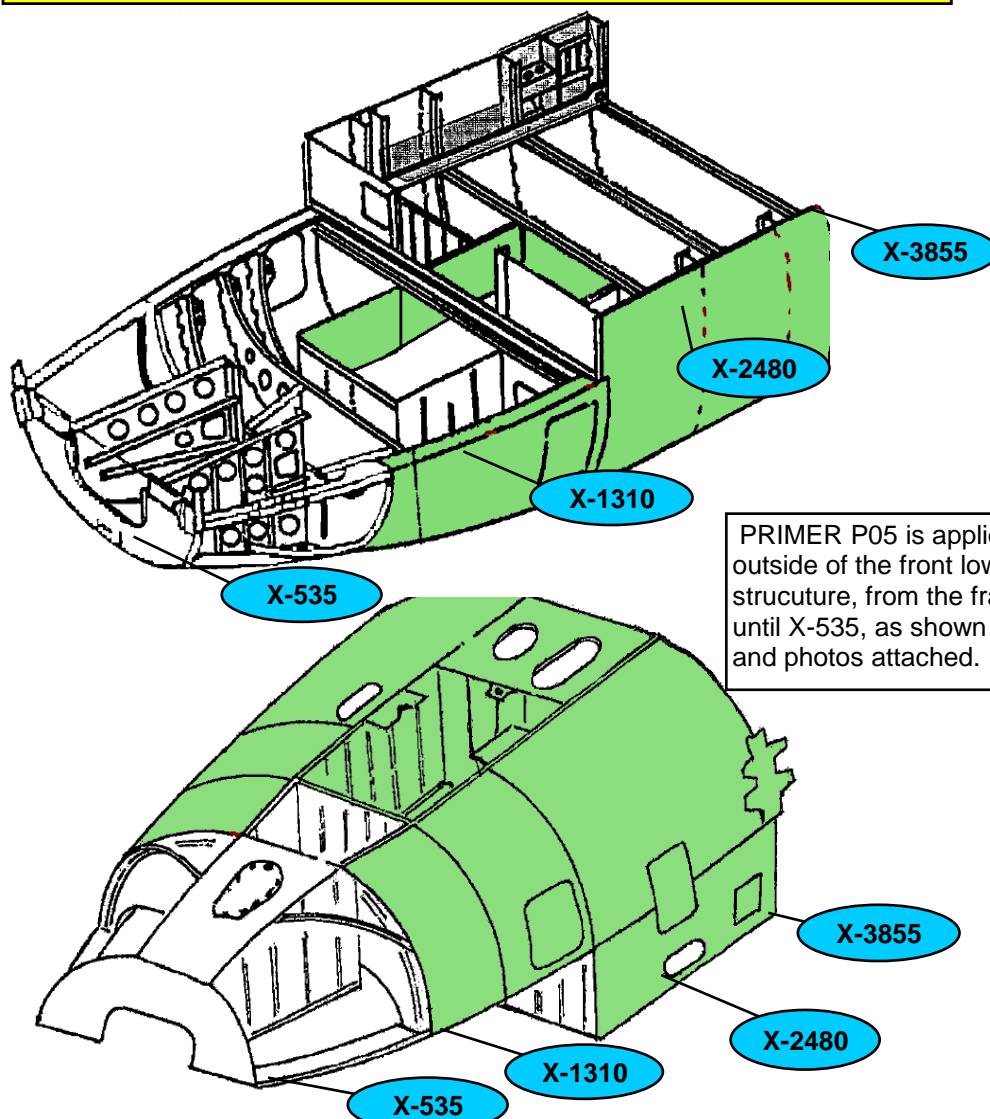
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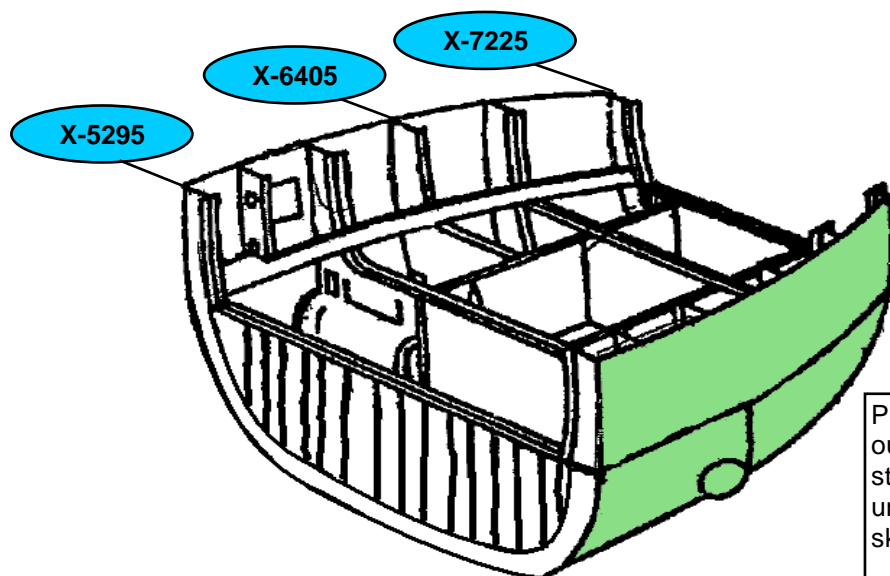
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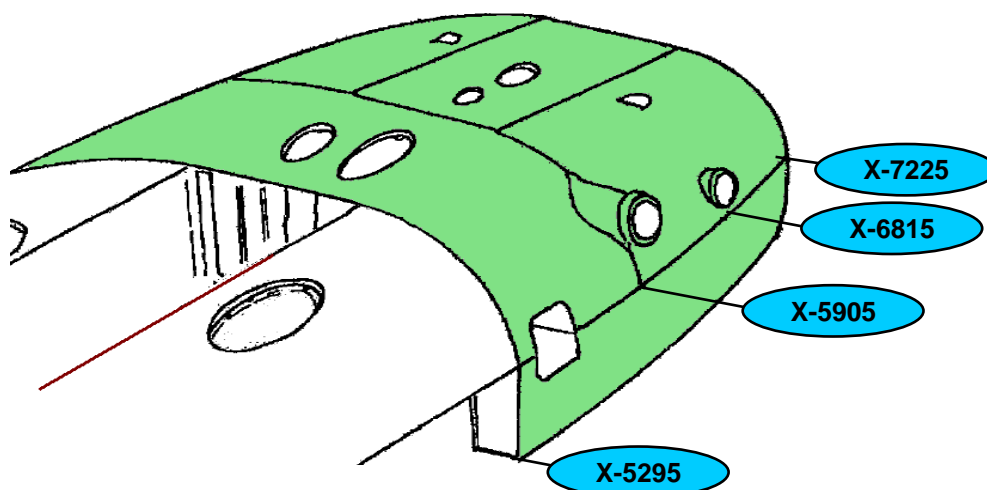
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## APPLICATION OF PRIMER IN REAR LOWER STRUCTURE



PRIMER P05 is applied on the outside of the rear lower structure, from the frame X-5295 until X-7225, as shown in sketches and photos attached.





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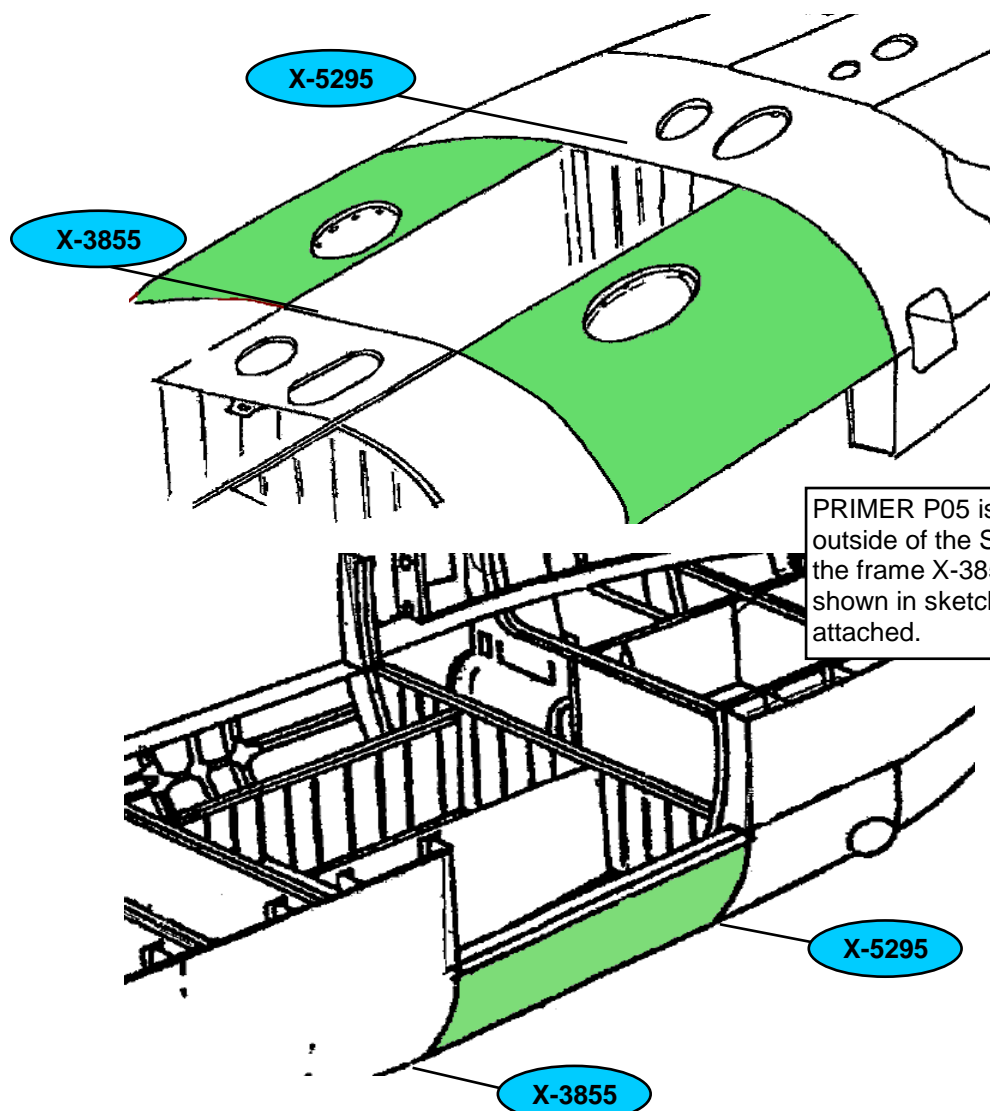
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## APPLICATION OF PRIMER IN SKIN RH/LH



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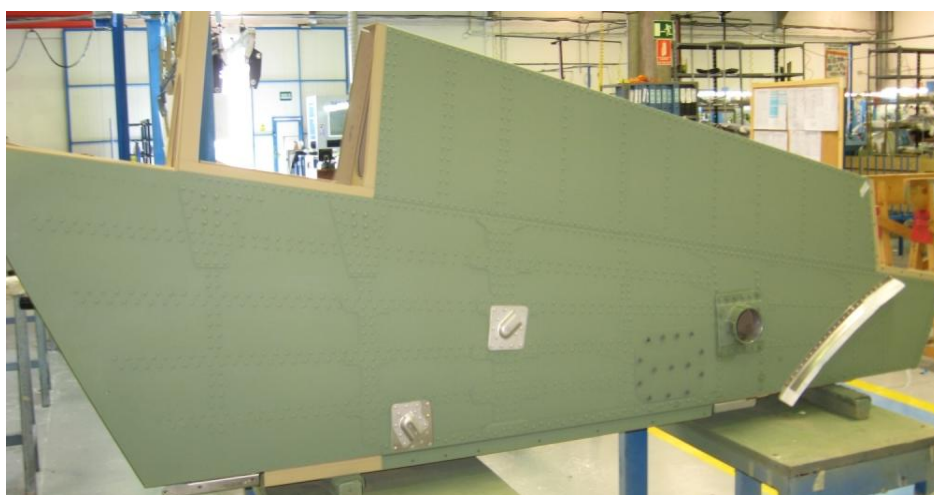
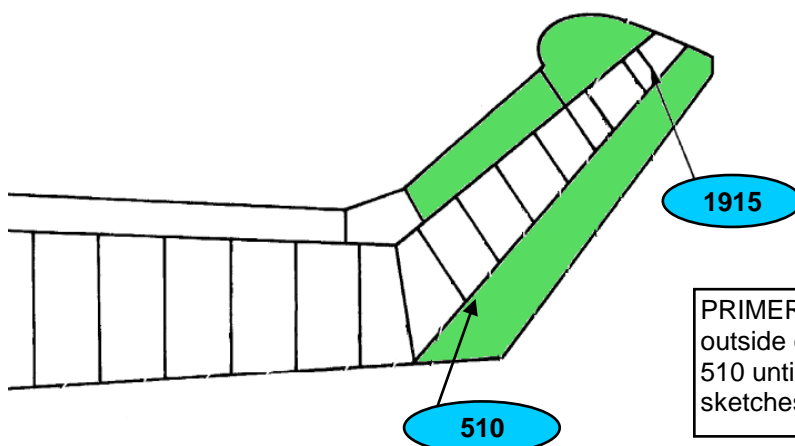
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## APPLICATION OF PRIMER IN PYLON



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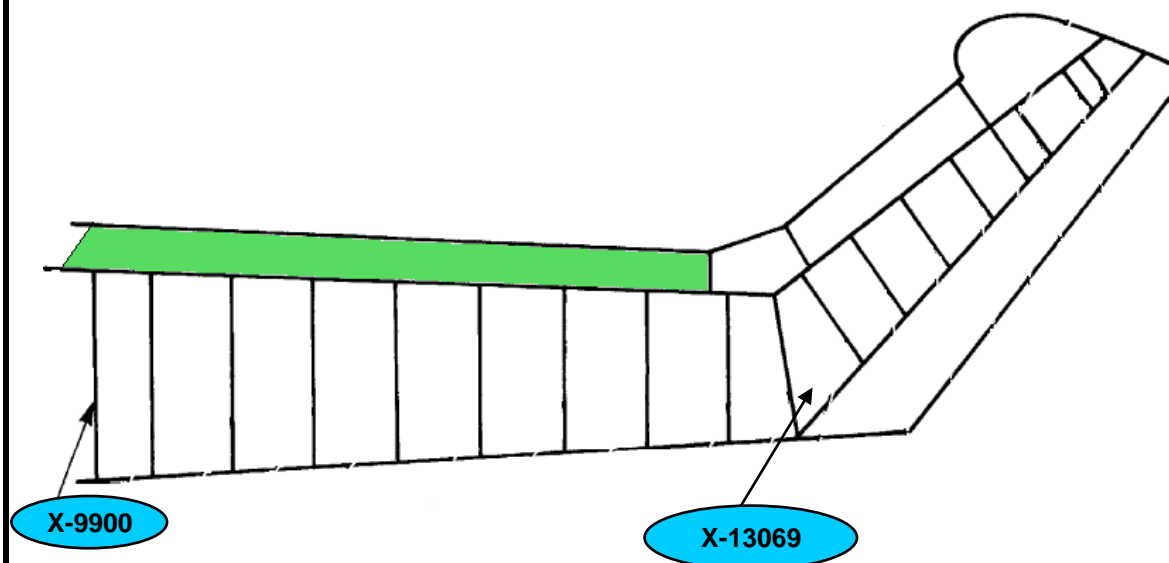
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DESCRIPTION:

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## APPLICATION OF PRIMER IN TAIL CONE



PRIMER P05 is applied on the outside of the tail cone, from frame 9900 until 13069, as shown in sketches and photos attached.



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REACTIVATION AND APPLICATION OF PRIMER P05

**REQUIREMENTS FOR TREATMENT OF WASTE AND PROTECTION EQUIPMENT.**

**utilization of the product standards**

PRODUCT  
DIESTONE



HARMFUL



FLAMMABLE



MASK



DISPOSABLE  
LATEX GLOVES



PROTECTIVE  
EYEWEAR

**HOW TO USE**

- Avoid prolonged contact with skin (use gloves)
- Use mask (semimáscara) with replaceable filter for respiratory protection
- Use the minimum amount necessary, avoid accumulating rags soaked in the workplace. Because is a flammable liquid must be controlled any possible sources of ignition (electrical, sparks with tools, smoke ..)

**MEASURES OF HYGIENE**

- Wash hands before eating and smoking
- Do not use for cleaning of stains on the skin

**FIRST AID**

**INHALATION** : Move affected person to breathe clean air, call for medical attention.

**SKIN** : Wash contaminated skin with soap and water. If irritation persists, call for medical attention.

**EYES** : Act quickly. Flush eyes with water. call for medical attention immediately.

**INGESTION** : Do not induce vomiting. Whenever the person is conscious give water to drink. If there isn't a fast recovery, call for medical attention.

**IN CASE OF LEAKAGE**

- Absorb or prevent the spread of liquid product. Wash contaminated area with water.

**IN CASE OF FIRE**

- Can be used dry chemical powder and / or carbon dioxide. Not suitable water jet.

**STORAGE**

- Keep away from sources of heat or ignition. Do not smoke.

**WASTE TREATMENT**

- Do not throw residues down the drain.

**COMMENTS**

- DIESTONE is a solvent that can cause skin irritation on prolonged contact. Its vapors are flammable and inhalation of the same harmful.
- Keep container correctly closed.

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**REQUIREMENTS FOR TREATMENT OF WASTE AND PROTECTION EQUIPMENT.**

**utilization of the product standards**

PRODUCT HYSO 99		
	HARMFUL	FLAMMABLE
		
MASK	DISPOSABLE LATEX GLOVES	PROTECTIVE EYEWEAR

**HOW TO USE**

- Avoid prolonged contact with skin (use gloves)
- Use mask (semimáscara) with replaceable filter for respiratory protection
- Use the minimum amount necessary, avoid accumulating rags soaked in the workplace. Because is a flammable liquid must be controled any possible sources of ignition (electrical, sparks with tools, smoke ..)

**MEASURES OF HYGIENE**

- Wash hands before eating and smoking
- Do not use for cleaning of stains on the skin

**FIRST AID**

**INHALATION** : Move affected person to breathe clean air, call for medical attention.

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**IN CASE OF LEAKAGE**

- Absorb or prevent the spread of liquid product. Wash contaminated area with water.

**IN CASE OF FIRE**

- Can be used dry chemical powder and / or carbon dioxide. Not suitable water jet.

**STORAGE**

- Keep away from sources of heat or ignition. Do not smoke.

**WASTE TREATMENT**

- Do not throw residues down the drain.

**COMMENTS**

- HYSO99 is a solvent that can cause skin irritation on prolonged contact. Its vapors are flammable and inhalation of the same harmful.
- Keep container correctly closed.