

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 TOPCOAT (YELLOW)

REFERENCE DOCUMENTS.

- **IFMA-389** PAINTING AIRCRAFT GENERAL INSTRUCTIONS
- **IFMA-447-30** SHEETS FOR THE PREPARATION AND APPLICATION OF INTERIOR PAINTS
- **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.
 - BASE: 6346/3156 4080 (supplier PPG coatings)
 - THINNER: 0480/9000 4980 (supplier PPG coatings)
- } YELLOW

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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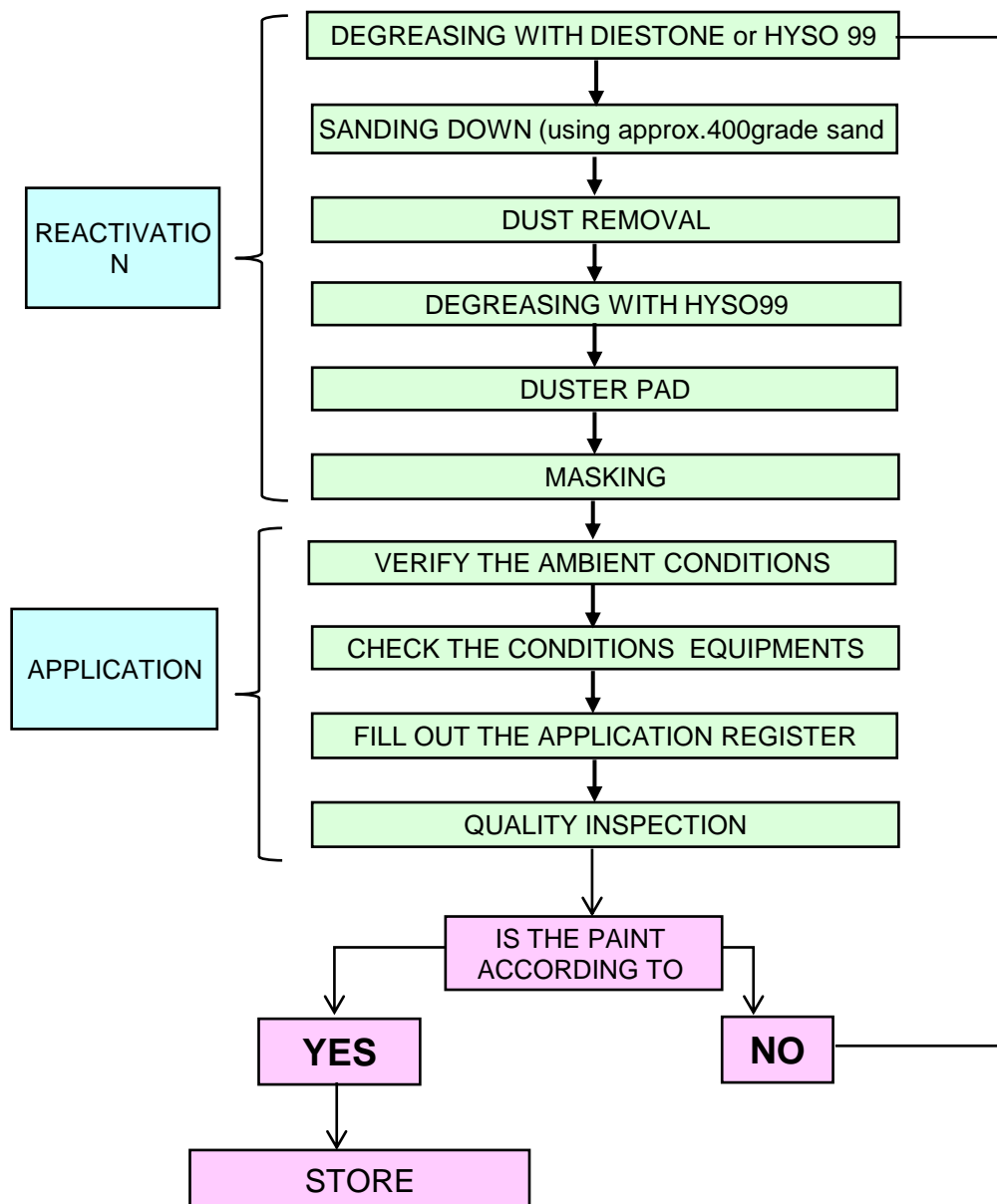
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REACTIVATION AND APPLICATION OF TOPCOAT (YELLOW)

REACTIVATION AND APPLICATION OF TOPCOAT



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DESCRIPTION:

REACTIVATION AND APPLICATION OF TOPCOAT (YELLOW)

REACTIVATION (of a painted surface)

Degreasing/ cleaning with DIESTONE or HYSO



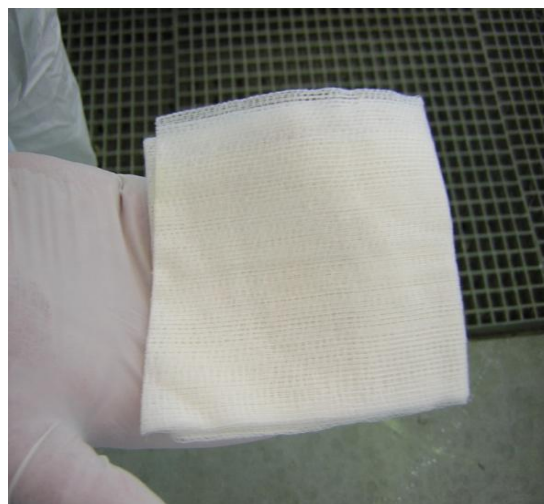
Sanding using approx. 320/400 grit abrasive



After sanding. Deagreasing/ cleaning with HYSO 99.



Wiping with an "anti-dust" cloth.



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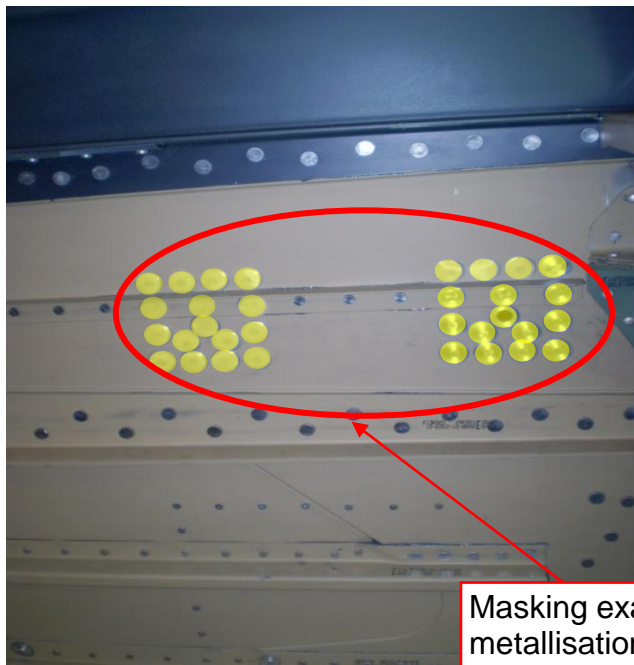
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REACTIVATION AND APPLICATION OF TOPCOAT (YELLOW)

MASKING MATERIAL

Protect all surfaces which will be not painted with topcoat.

All metallizations, acrylic windows, tires, etc., must be masked with adhesive tape or stickers to prevent deposition of topcoat.



Masking examples:
metallisation with
yellow stickers.

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APPLICATION OF TOPCOAT

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%

TOPCOAT is mixed according to the TI **G6-SP-002**.

Before the application of topcoat, 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 painting.

Apply the mixture in coats, number of coats: even film.
 Thickness of dry film is **25 µm** maximum
 Application is done with nozzle diameter between 1.2 mm and 1.4mm, air pressure: 2 to



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
- n) inspectors sign

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

The following are areas where TOPCOAT (blue) is applied: front lower structure, rear lower

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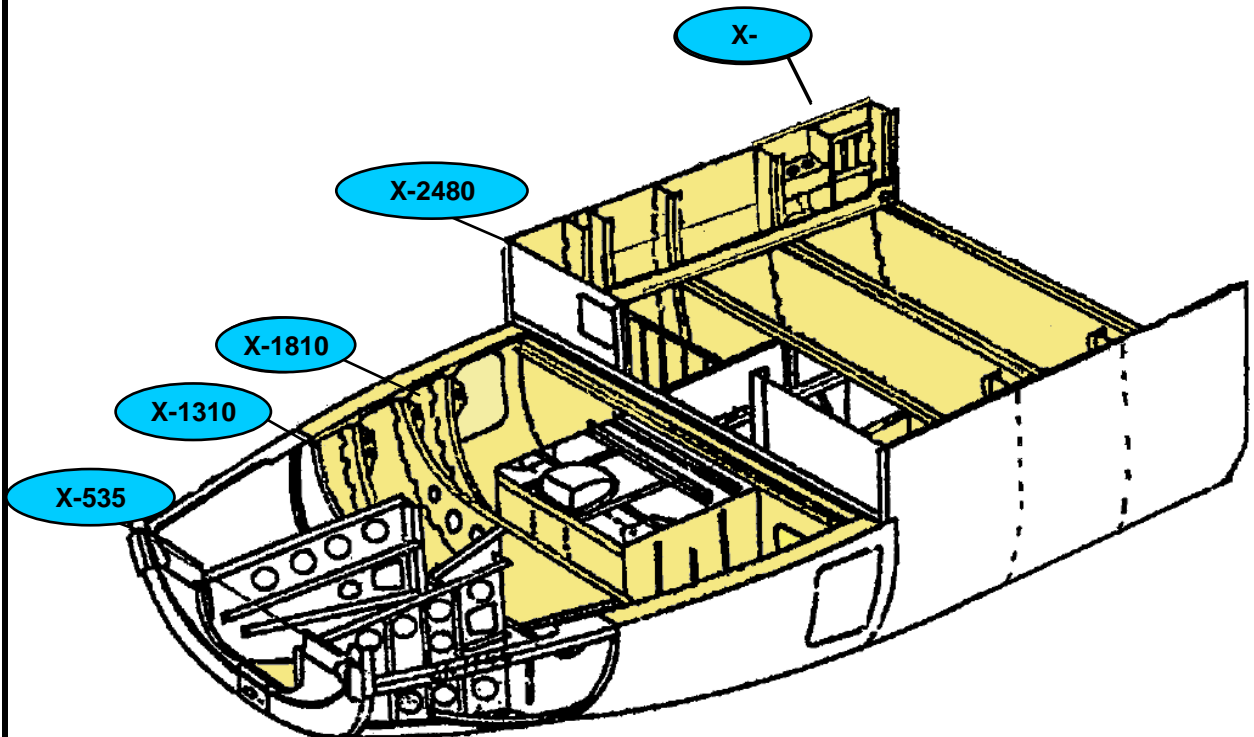
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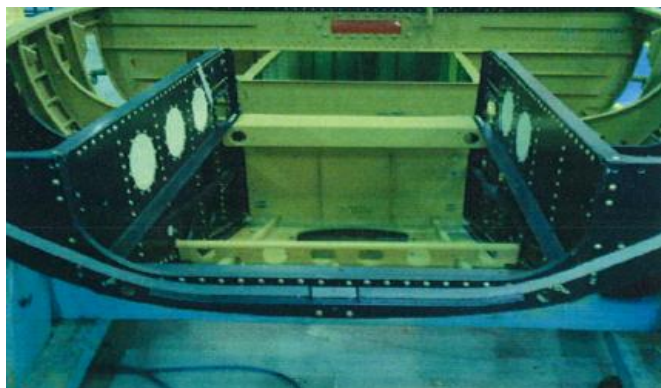
DESCRIPTION:

REACTIVATION AND APPLICATION OF TOPCOAT (YELLOW)

APPLICATION OF TOPCOAT IN FRONT LOWER STRUCTURE



TOPCOAT (yellow) is applied on the inside of the front lower structure, from the frame X-535 until X-3855 , as shown in sketches and photos



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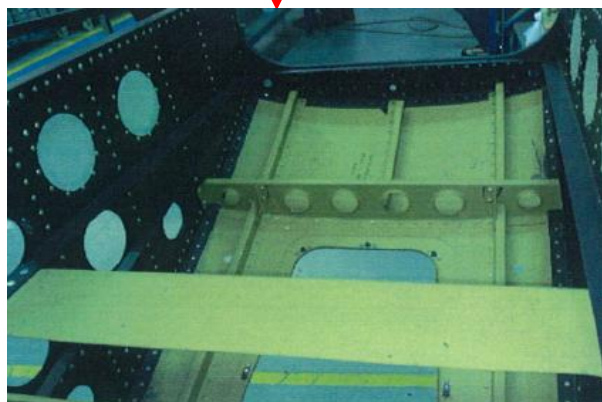
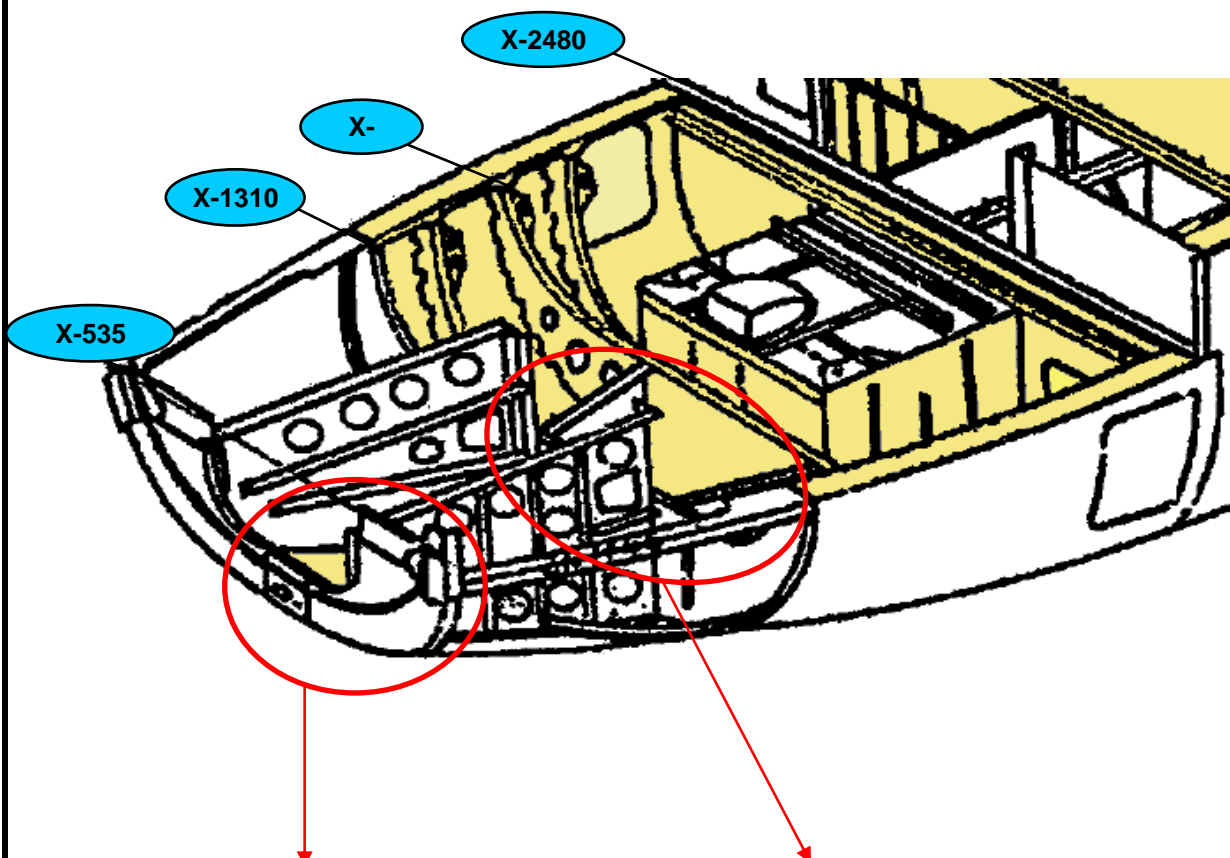
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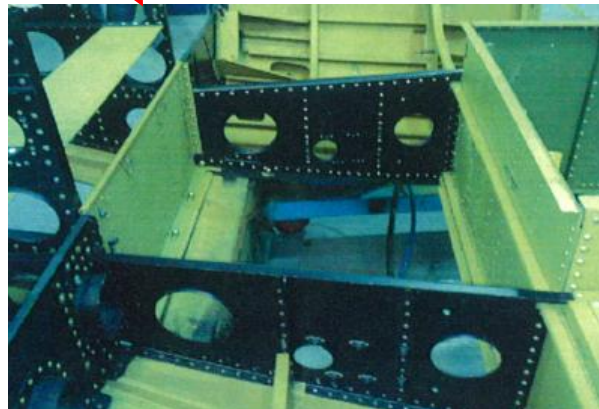
DESCRIPTION:

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APPLICATION OF TOPCOAT IN FRONT LOWER STRUCTURE



TOPCOAT (yellow) is applied on the inside of the front lower structure, from the frame X-535 until X-1310, as shown the photo.



TOPCOAT (yellow) is applied in the central frame X-1310, as

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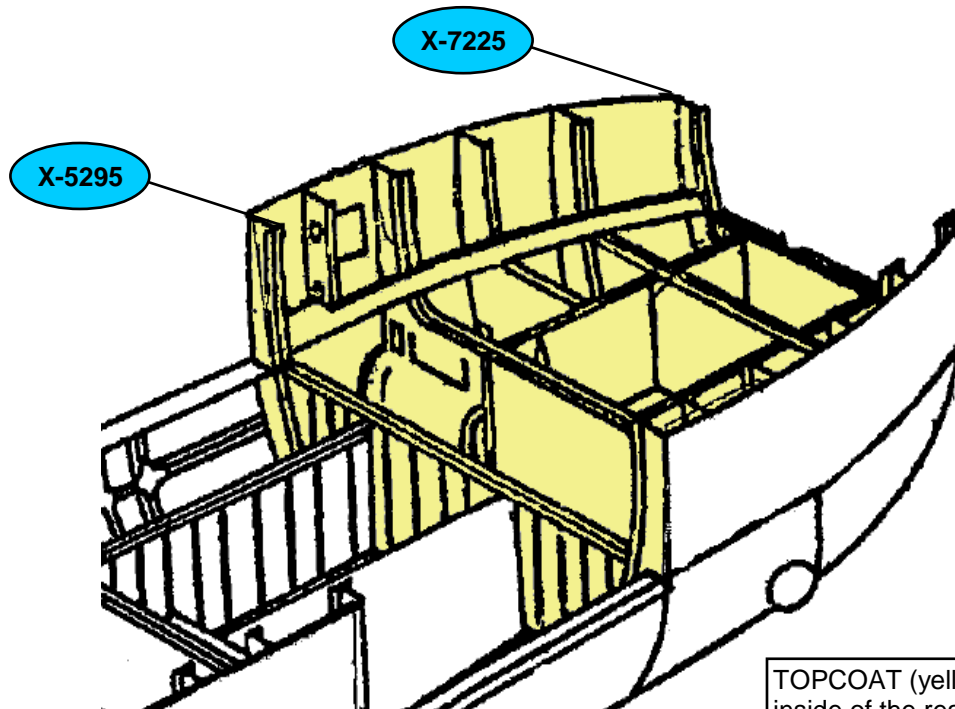
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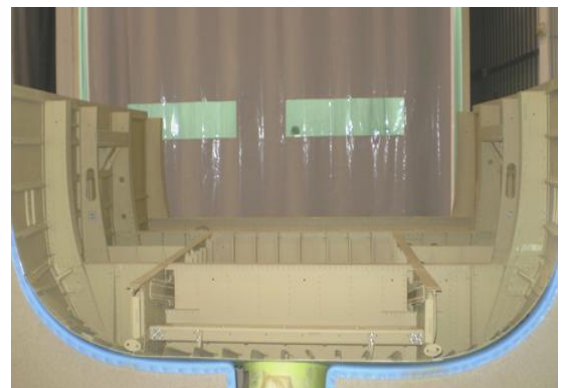
DESCRIPTION:

REACTIVATION AND APPLICATION OF TOPCOAT (YELLOW)

APPLICATION OF TOPCOAT IN REAR LOWER STRUCTURE



TOPCOAT (yellow) is applied on the inside of the rear lower structure, from the frame X-5295 until X-7225, as shown in sketches and photos



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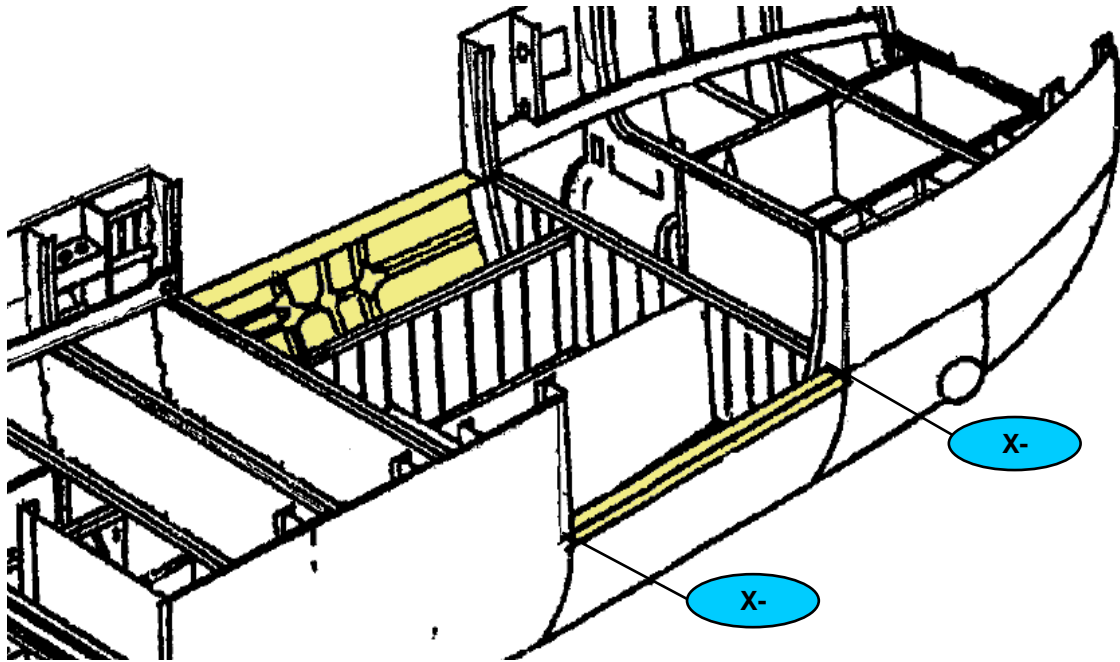
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DESCRIPTION:

REACTIVATION AND APPLICATION OF TOPCOAT (YELLOW)

APPLICATION OF TOPCOAT IN SKIN RH/LH



TOPCOAT is applied on the inside of the SKIN RH/LH, from the frame X-3855 until X-5295, as



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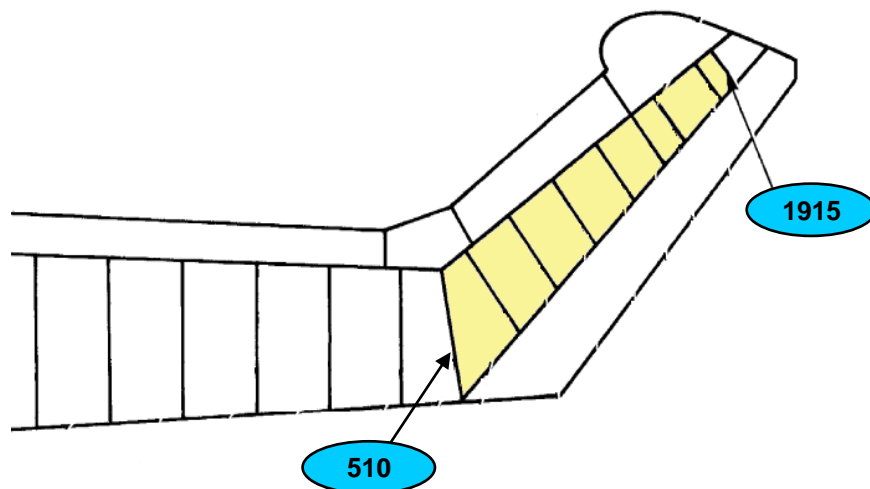
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DESCRIPTION:

REACTIVATION AND APPLICATION OF TOPCOAT (YELLOW)

APPLICATION OF TOPCOAT IN PYLON



TOPCOAT (yellow) is applied on the inside of the pylon, from frame 510 until 1915, as shown in sketches and



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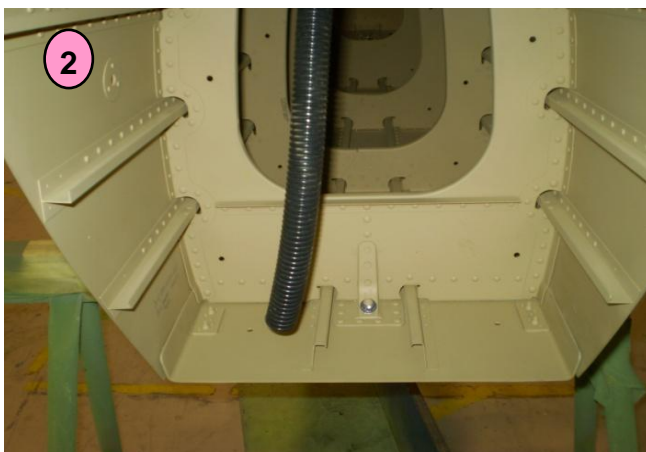
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DESCRIPTION:

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APPLICATION OF TOPCOAT IN PYLON



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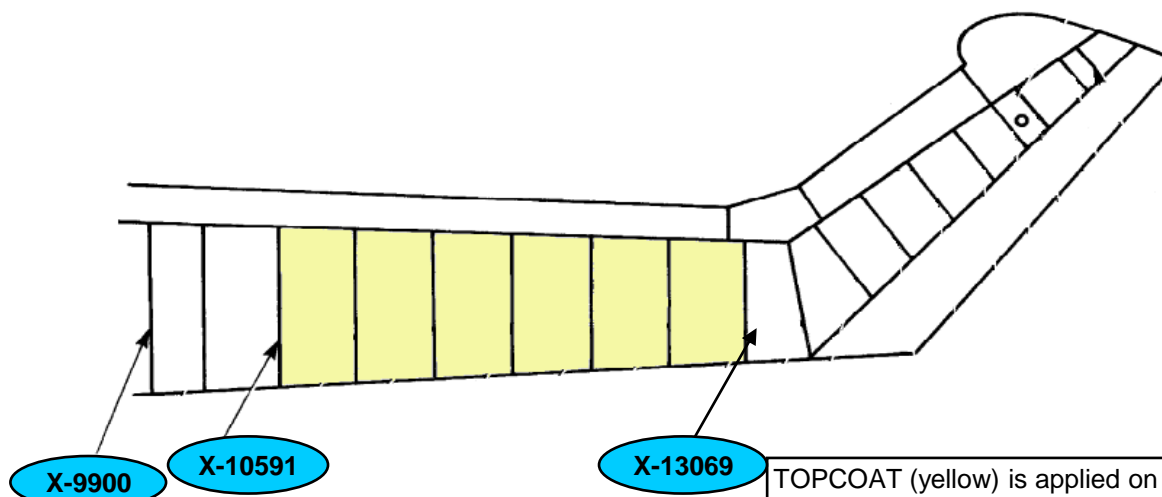
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DESCRIPTION:

REACTIVATION AND APPLICATION OF TOPCOAT (YELLOW)

APPLICATION OF TOPCOAT IN TAIL CONE



TOPCOAT (yellow) is applied on the inside of the tail cone, from frame X-10591 until X-13069, as shown in sketches and photos attached.



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DESCRIPTION:

REACTIVATION AND APPLICATION OF TOPCOAT (YELLOW)

REQUIREMENTS FOR TREATMENT OF WASTE AND PROTECTION EQUIPMENT.**utilization of the product standards**PRODUCT
DIESTONE

HARMFUL



FLAMMABL



MASK

DISPOSABLE
LATEXPROTECTIV
E**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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DESCRIPTION:

REACTIVATION AND APPLICATION OF TOPCOAT (YELLOW)

REQUIREMENTS FOR TREATMENT OF WASTE AND PROTECTION EQUIPMENT.**Utilization of the product standards**PRODUCT
HYSO 99

HARMFUL



FLAMMABLE



MASK

DISPOSABLE
LATEXPROTECTIVE
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

- HYSO 99 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.