

Task 51-77-11-911-023

Curing

Weight Variant Number: A321-100 WV000, A321-100 WV002, A321-100 WV003, A321-100 WV004, A321-100 WV005, A321-100 WV006, A321-100 WV007, A321-100 WV008, A321-200 WV000, A321-200 WV001, A321-200 WV002, A321-200 WV003, A321-200 WV004, A321-200 WV005, A321-200 WV006, A321-200 WV007, A321-200 WV008, A321-200 WV009, A321-200 WV010, A321-200 WV011

Effective on: ALL

WARNING: OBEY THE MANUFACTURER'S INSTRUCTIONS WHEN YOU USE CLEANING AGENTS, ADHESIVES, SEALANTS AND PAINTS. THESE MATERIALS ARE DANGEROUS.

WARNING: WEAR THE CORRECT PROTECTIVE GLOVES AND FILTER MASK WHEN YOU CUT, ABRASE OR DRILL COMPOSITE MATERIALS. THE DUST FROM COMPOSITE MATERIALS CAN GET INTO YOUR LUNGS OR ON TO YOUR SKIN AND CAN BE THE CAUSE OF INJURY AND SKIN IRRITATION.

WARNING: CARBON DUST IS ELECTRICALLY CONDUCTIVE AND CAN CAUSE AN EXPLOSION. WHEN YOU WORK WITH CFRP COMPOSITE MATERIALS IMMEDIATELY REMOVE DUST WITH A VACUUM CLEANER.

WARNING: USE AN ISOLATION TRANSFORMER WHEN YOU USE MAINS ELECTRIC POWER ON THE AIRCRAFT. YOU MUST ONLY USE POWER TOOLS AND EQUIPMENT THAT ARE EXPLOSION PROOF.

NOTE: There are risks to you and other persons when you work with composite repair materials. To prevent any risks, read and obey the warnings given above.

1. Task Supporting Data

A. General

- (1) The information in this topic is about the general procedures for the preparation of the repair areas and the repair materials. General data for the procedures are included. The applicable material data is also provided.
- (2) When you make permanent repairs the material must, as a general rule, match the original material as follows:
 - only carbon fiber material to repair carbon fiber structures.
 - only glassfiber material to repair glassfiber and aramid fiber structures.
- (3) The content of this chapter is applicable for material application of curing.

B. Area of Applicability

C. Weight Variant Applicability

D. Limits/Restrictions

E. Repair Category

F. Inspections

G. Job Set Up Information

- (1) Material References
- (2) References
Chapter 51-77-10

2. Repair Procedure

CAUTION: DURING THIS STEP THE TEMPERATURE MUST BE STRICTLY CONTROLLED.

A. Room Temperature (RT) Repair - Accelerated Cure by Heating

A321 Structural Repair Manual

D Kirk



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