APPENDIX B. Basic Elements

Basic Element	Basic Element Step(s)
189	REMOVAL OF PEEL PLY FROM GRAPHITE COMPOSITE LAMINATES. NOTES: (1) REMOVAL OF PEEL PLY FROM SURFACE SHALL BE VERIFIED BY QUALITY CONTROL STAMP ON SOIR. (2) SURFACES WHICH HAVE HAD THE PEEL PLY REMOVED SHALL BE PROTECTED FROM CONTAMINATION. (3) CLEAN STARCH FREE, COTTON OR NYLON GLOVES SHALL BE WORN DURING THE PEELING OPERATION. (4) IF THE SURFACE OF THE LAMINATE HAS BEEN CONTAMINATED AFTER THE PEEL PLY HAS BEEN REMOVED, THEN THE SURFACE SHALL BE SOLVENT CLEANED PER 135, SANDED WITH 280 OR FINER GRIT WET OR DRY SANDPAPER, SOLVENT CLEAN PER 135 AND WIPE DRY, THEN TACK-RAG TO REMOVE LINT. A) LOCATE PLY DIRECTION OF TOP LAYER OF COMPOSITE SKIN. B) MAKE A CUT APPROXIMATELY 1" LONG THRU PEEL PLY USING A SHARP LEWIS OR EXACTO KNIFE HOLDING THE KNIFE AT A 45 DEGREE ANGLE ALONG THE PLY DIRECTION WHILE MAKING THE CUT. DO NOT USE ENOUGH PRESSURE ON KNIFE TO CUT COMPOSITE SKIN. C) THEN INSERT THE EDGE OF A SHARP LINOLEUM KNIFE UNDER THE CUT MADE IN THE PEEL PLY. USE AN UPWARD MOTION TO PULL THE PEEL PLY LOOSE. CONTINUE PULLING UNTIL A SECTION LARGE ENOUGH TO GRASP WITH THE FINGERS IS PEELED UP. D) REMOVE PEEL PLY FROM THE COMPOSITE SKIN BY PULLING PARALLEL TO THE FIBER ORIENTATION WITH AN UPWARD MOTION AND TOWARD THE EDGE(S) OF THE LAMINATE.
201	APPLY ONE COAT OF FMS-3027, MIL-PRF-23377, OR MIL-PRF-85582 PRIMER TO ALL SURFACES. THE PRIMER COATING MAY BE DELAYED TO A SUBSEQUENT ASSEMBLY LEVEL WHEN THE ENTIRE LENGTH OF FAYING SURFACE OVERLAPS IS REQUIRED FOR ELECTRICAL BONDING. THE EQUIVALENT THICKNESS OF TWO COATS OF PRIMER IS PERMISSIBLE ON THOSE AREAS THAT ARE COVERED WITH TOPCOAT.
202	APPLY ONE COAT OF FMS-3027, MIL-PRF-23377, OR MIL-PRF-85582 PRIMER TO SPECIFIED SURFACE. THE PRIMER COATING MAY BE DELAYED TO A SUBSEQUENT ASSEMBLY LEVEL WHEN THE ENTIRE LENGTH OF FAYING SURFACE OVERLAPS IS REQUIRED FOR ELECTRICAL BONDING. THE EQUIVALENT THICKNESS OF TWO COATS OF PRIMER IS PERMISSIBLE ON THOSE AREAS THAT ARE COVERED WITH TOPCOAT.