

General

1. Summary

This manufacturing specification defines the procedures for installation of the Lancair Evolution windshield and windows.

2. Standard Tolerances

The following standard tolerances apply to the rest of this document, unless otherwise noted:

Table 1 – Standard Tolerances

TABLE OF STANDARD TOLERANCES				
TEMPERATURE ± 5°F and ± 3°C	TIME Minutes ± 1 Seconds ± 1 Hours ± 0.5	WEIGHT .X ± .05 .XX ± .005 X ± .25 XX ± 0.5 XXX ± 5	DIMENSIONS .X ± .05 .XX ± .005 X ± .25 XX ± .5 XXX or more ± 5	ANGLES X = ± 2.0° .X = ± 1.0°
HUMIDITY ± 5% RH				

3. References:

- a. 012-0011, Surface Preparation for Bonding of Composite Material

4. Abbreviations and Definitions

Flox – Cotton fibers used with a two part epoxy resin to increase the viscosity of the epoxy.
For this procedures document “Flox” means a mixture of epoxy and cotton fibers.

Hysol – A two part epoxy resin used to structurally bond molded composite parts together.
For this procedures document “Hysol” means Hysol 9360 manufactured by Henkel Corporation, Aerospace Group, 2850 Willow Pass Road, Bay Point, CA 94565.

Prepreg – Resin impregnated fiber reinforced material, usually refrigerated to inhibit resin cure.

Release – A platform, pad, or surface made out of a mixture of flox and resin bonded to a composite material component. Studs for attachment of mechanical hardware may also be installed in the platform.

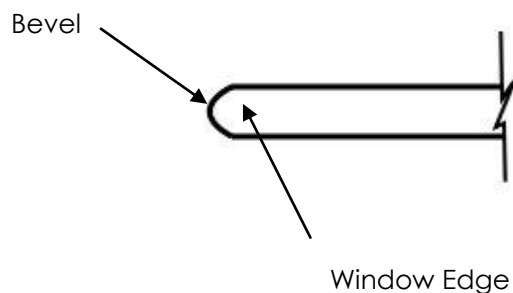
Resin – A mixture of resin and hardener used to make carbon and fiberglass layups. The resin may also be mixed with flox for structural applications or with micro for surface or cosmetic applications. For this procedures document “resin” means Rhino 1307-LV and hardener manufactured by Rhino Linings Corporation, 9151 Rehco Road, San Diego, CA 92121.

- e. Using a DA sander with 40 grit sandpaper roughen the windows and the windshield from the tape to the edge of the window. Do not disturb or damage the vinyl tape. Use the DA sander by first pressing the sander to the window then activating it. Bring the DA sander up to a high rate of speed and press firmly against the window.

Note: The window is properly roughened when it has a frosty appearance and NO shine or reflections from overhead lights can be seen.



- f. Create a rounded edge on each window and the windshield using a DA sander with 40 grit sandpaper.



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