

# BAC5514

REVISION  
AP  
9/10/1999

COMMON BONDING  
REQUIREMENTS FOR STRUCTURAL  
ADHESIVES



THIS SPECIFICATION ESTABLISHES THE REQUIREMENTS COMMON TO THE STRUCTURAL BONDING OF METAL-TO-METAL AND SANDWICH-TYPE ASSEMBLIES

<u>BAC 5514 DEPARTURES</u>	<u>EFF DATE</u>	<u>SUBCONTRACTOR(S) AFFECTED</u>	<u>ON MODELS</u>	<u>MFG DEPTS OF DIV BELOW AFFECTED</u>	<u>REASON</u>
6-164	5/1/1995	ALL	707 AND DERIVATIVES (DOES NOT INCLUDE KC-135)	BCAG AND SUPPORTING	TO PROVIDE A HAND CLEANING PROCEDURE FOR 350 F CURING ADHESIVES.
6-168	10/27/1995	ALL PEOPLE'S REPUBLIC OF CHINA SUBCONTRACTORS	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	TO ALLOW CHINESE SUBCONTRACTORS TO USE CHINA GOVERNMENT STANDARDS FOR BAC5514 CHEMICALS.
6-176	11/7/1997	AEROSPACE TECHNOLOGIES, INC	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	TO ALLOW CLEANING HONEYCOMB CORE DETAILS WITHOUT VAPOR DEGREASING.
6-187	12/20/1999	AVCORP INDUSTRIES, INC.	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	TO ALLOW CLEANING HONEYCOMB CORE DETAILS WITHOUT VAPOR DEGREASING.
6-189	6/8/2000	FUJI HEAVY INDUSTRIES (FHI)	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	TO ALLOW AN ALTERNATE VAPOR DEGREASING SOLVENT AND DEGREASING PROCESS.
6-190	8/29/2000	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCAG AND SUPPORTING	TO CLARIFY THERMOCOUPLE REQUIREMENTS FOR MULTIPLE TOOLS UNDER ONE VACUUM BAG.
6-191	9/27/2000	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCAG AND SUPPORTING	TO ADD NEW MATERIALS AND METHOD TO CLEAN THE CONTROLLED CONTAMINATION AREA.
6-192	10/20/2000	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCAG AND SUPPORTING	TO ADD NEW MATERIALS TO SECTION 5.3 TO HOLD HONEYCOMB CORE DURING MACHINING
6-193	2/6/2001	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCAG AND SUPPORTING	TO ADD POLYETHYLENE, NYLON, PVC, AND NITRILE TO THE APPROVED GLOVES LIST.
6-194	6/8/2001	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCAG AND SUPPORTING	TO ADD ALLOWANCE TO USE SOLDERING IRONS TO REMOVE ADHESIVE FLASH.
6-199	3/11/2002	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCAG AND SUPPORTING	TO ADD COMPOSITE SHIELD AND WATERWORKS AS APPROVED PARTING AGENTS.
6-204	10/1/2002	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCAG EXCEPT WICHITA	TO ALLOW USE OF MPK.
6-205	8/6/2003	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCAG AND SUPPORTING	TO ADD OPTION TO REMOVE ADHESIVE FLASH USING BONDBLAST MEDIA. ADD MANDATORY REQUIREMENT FOR FACILITIES CONTROL OF BLASTING EQUIPMENT.
6-206	6/12/2003	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCAG AND SUPPORTING	TO ADD ECONOBREAKER FLASH CONTROL TAPE.
6-208	9/9/2003	ALL	737-600, -700, -800, -900, 747, 757, 767, 777	ALL BCAG AND SUPPORTING	TO ADD LEAK REWORK METHOD AND INSPECTION REQUIREMENTS FOR SANDWICH PANELS OF WEDGE DESIGN.
6-209	11/30/2004	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCAG AND SUPPORTING	TO CLARIFY MANUFACTURING PLAN REQUIREMENTS
6-210	4/20/2006	TRIUMPH AIRBORNE STRUCTURES INC.	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	TO ALLOW CLEANING HONEYCOMB CORE DETAILS WITHOUT VAPOR DEGREASING.
6-213	5/29/2007	SPIRIT AEROSYSTEMS, INC - WICHITA, DIVISION	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	TO ALLOW USE OF MPK AT SPIRIT WICHITA.
6-214	6/8/2007	YOKOHAMA RUBBER CO., LTD	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	TO ALLOW AN ALTERNATE VAPOR DEGREASING SOLVENT AND DEGREASING PROCESS.
6-217	1/23/2009	BRENNER AEROSTRUCTURES	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	TO ALLOW CLEANING HONEYCOMB CORE DETAILS WITHOUT VAPOR DEGREASING. NAME CHANGE FROM BRENNER TOOL & DIE TO BRENNER AEROSTRUCTURES.
6-218	11/3/2009	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCA AND SUPPORTING	ADD FLASHPAC L101P TO SECTION 5.2 PARTING AGENTS.... ADD E-C TFE PARTING FILMS. DELETE PMP PARTING FILM FROM ALL SOURCES DUE TO RESIDUE TRANSFER. ALLOW WRIGHTLON 4600 RELEASE FILM ...
6-220	4/4/2012	ALL	787 ONLY	ALL BCA AND SUPPORTING	TO REVISE TITANIUM SURFACE PREPARATION PROCESS, ADD FACILITY QUALIFICATION REQUIREMENT FOR THIS PROCESS, AND ALLOW FOR METAL TO NON-METAL AND NON-METAL TO NON-METAL BONDING.
6-221	4/4/2012	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCAG AND SUPPORTING	TO INCLUDE CURED AIRPAD AS AN ACCEPTABLE MATERIAL UNDER RUBBER PRESSURE PADS.
6-222	4/4/2012	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCAG AND SUPPORTING	TO REVISE AND ADD BLEEDERS AND BREATHERS.
6-223	4/4/2012	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCA AND SUPPORTING	TO ADD JAPANESE STANDARD FOR MEK THAT IS EQUIVALENT TO ASTM.
6-224	8/20/2012	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCA AND SUPPORTING	ALLOWANCE OF RIGID AND FLEXIBLE SWEEPS IN CONTACT WITH FILM ADHESIVE.

6-226	9/20/2012	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCA AND SUPPORTING	ADDITION OF TOOL HOLE FILLERS TO APPROVED MATERIALS.
6-227	3/18/2013	EXPANDED RUBBER AND PLASTICS CORP.	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	TO ALLOW CLEANING HONEYCOMB CORE DETAILS WITHOUT VAPOR DEGREASING.
6-228	9/4/2013	XI' AN AIRCRAFT INDUSTRY (GROUP) COMPANY LTD	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	TO ALLOW CLEANING HONEYCOMB CORE DETAILS WITHOUT VAPOR DEGREASING.
6-233	12/12/2016	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCA AND SUPPORTING	TO ADD INSPECTION AND REJECTION REQUIREMENTS FOR ROUGH SURFACE APPEARANCE OF BAKED PRIMER.
6-234	6/20/2017	KAWASAKI HEAVY INDUSTRIES (KHI)	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	TO ALLOW AN ALTERNATE VAPOR DEGREASING SOLVENT AND DEGREASING PROCESS.
8-9	10/25/2006	PRECISION AERO SERVICES	ALL BH	NONE	TO ALLOW ALTERNATE CORE CLEANING PROCESS.
8-10	6/29/2011	ALL	ALL BDS PHILADELPHIA	ALL BDS PHILADELPHIA AND SUPPORTING	ADD BMS8-196 AND MATERIAL HANDLING CONTROLS
8-11	1/13/2014	AVCORP INDUSTRIES, INC.	CH-47	NONE	TO ALLOW CLEANING HONEYCOMB CORE DETAILS WITHOUT VAPOR DEGREASING.
8-12	2/20/2015	AVCORP INDUSTRIES, INC.	CH-47	NONE	ADD OPTION TO REMOVE ADHESIVE FLASH USING BONDBLAST MEDIA. ADD MANDATORY REQUIREMENT FOR FACILITIES CONTROL OF BLASTING EQUIPMENT.
8-14	2/25/2015	ALL	ALL BOEING PHILADELPHIA	ALL BOEING PHILADELPHIA AND SUPPORTING	ALL DETAIL LEVEL DEFECTS AT THE BONDED ASSEMBLY LEVEL.
8-15	7/22/2015	ALL	ALL BOEING PHILADELPHIA	ALL BOEING PHILADELPHIA AND SUPPORTING	ADD POLYETHELENE, NYLON, PVC, AND NITRILE TO THE APPROVED GLOVES LIST. ADD ALLOWANCE TO USE POLYETHYLENE FILM AS TEMPORARY PROTECTION OF PREPARED TOOLS.
9-10	11/12/1999	ROHR INDUSTRIES, INC.	C/KC-135	NONE	UPDATE TO REV AP.
9-11	11/12/1999	ALL	C/KC-135, B-52	BOEING DEFENSE AND SPACE GROUP - WICHITA DIVISION	UPDATE TO REV AP.
9-12	11/12/1999	ALL	ALL BOEING DEFENSE AND SPACE GROUP	BOEING DEFENSE AND SPACE GROUP AND SUPPORTING	UPDATE TO REV AP.
9-14	8/8/2002	NOT AVAILABLE			
9-15	1/16/2003	AEROSPACE TECHNOLOGIES, INC.	DEFENSE AND SPACE GROUP	NONE	TO ALLOW CLEANING HONEYCOMB CORE DETAILS WITHOUT VAPOR DEGREASING. REF: PSD 6-176.
9-17	6/20/2004	NOT AVAILABLE			
9-18	3/10/2005	ALL	ALL INTEGRATED DEFENSE SYSTEMS - PS/W/H	INTEGRATED DEFENSE SYSTEMS AND SUPPORTING	ADD LEAK REWORK METHOD AND INSPECTION REQUIREMENTS FOR SANDWICH PANELS OF WEDGE DESIGN. REFERENCE PSD 6-208.
9-21	4/9/2009	ALL	ALL IDS-PS/W/H	INTEGRATED DEFENSE SYSTEMS AND SUPPORTING	TO ALLOW USE OF MPK.
9-22	8/28/2009	ALL	C/KC-135	INTEGRATED DEFENSE SYSTEMS - WICHITA	TO REVISE INSPECTION REQUIREMENTS. COPY PSD 9-17 TO APPLY TO C/KC-135.
9-23	12/16/2010	ALL	BDS-WICHITA	BDS-WICHITA	TO REVISE INSPECTION REQUIREMENTS. COPY PSD 6-199 TO APPLY TO BDS-WICHITA.
9-24	11/13/2012	AVIATION EQUIPMENT PROCESSING	409 (E6), 204 (E3A)	NONE	TO ALLOW CLEANING HONEYCOMB CORE DETAILS WITHOUT VAPOR DEGREASING.
9-25	2/21/2013	ALL	BDS-WICHITA	BDS-WICHITA	ADD OPTION TO REMOVE ADHESIVE FLASH USING BONDBLAST MEDIA. ADD MANDATORY REQUIREMENT FOR FACILITIES CONTROL OF BLASTING EQUIPMENT (SAME AS PSD 6-205).
9-26	4/3/2013	AVCORP INDUSTRIES	KC-135	NONE	TO ALLOW OPTIONAL CLEANING OF HONEYCOMB CORE DETAILS WITHOUT VAPOR DEGREASING (SAME AS PSD6-187).
9-27	9/14/2015	HCOA	KC-135, B52, 204, 409	NONE	TO ALLOW HONEYCOMB COMPANY OF AMERICA TO CLEAN HONEYCOMB CORE DETAILS WITHOUT VAPOR DEGREASING. REMOVE REFERENCE TO A SPECIFIC REVISION LEVEL OF HWI40801-6.