
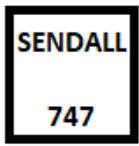

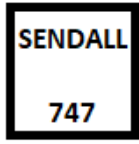

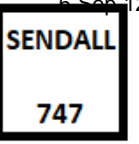

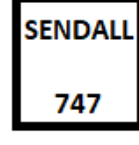

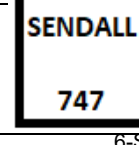


# Non Routine Job Card

Work Pack Reference:	8756221-001	REV NO:	01
A/C Type:	B777-200		
REGISTRATION:	EI-GSK	PAGE:	Page 1 of 3
MSN:	23456	VISIT NO:	
WORK ORDER:	5377754-1	Location/Dept.	SNN

TITLE	Flame Sprayed Panel RH pylon panel upper fwd No, 123EXAMPLE damaged flame spray.		CRITICAL TASK	MULTIPLE AND/OR REPEAT ERROR
Source Card	8756221-12	POSITION	NO	NO
		WTB RH Aircon		
ACCESS PANEL REQUIREMENTS		ZONE	TASK	DEFECT
		100	ATA	52
			INTERVAL	ONE TIME

**ENSURE THAT ALL SETUP PROCEDURE AND SAFETY PRECAUTIONS IDENTIFIED WITHIN THE APPLICABLE TASKS ARE FOLLOWED**

STEP	TASK DESCRIPTION / REQUIREMENT	CERTIFICATION	
		MECH Sign/Date	INSP Sign/Stamp Date
1.	Panel removed for access Panel 123EXAMPLE and noted flame spray peeling please evaluate		6-Sep-12 
2.	flame spray not permitted to be damaged and requires requires repair prior to installation refer to SRM 54-52-70 repair 1 Step C		6-Sep-12 
3.	IAW SRM 51-70-14 Repair 1 as referred to from SRM 54-52-70 carried out Category B Repair of Aluminum Flame-Sprayed Coatings. note re inspect 400 FH until perm repair carried out.		6-Sep-12 
4.	close up inspection and re installed post repair iaw amm 20-11-00		6-Sep-12 
5.	Updated dent and buckle for dent to reflect damage as item 65.		

INDEPENDENT INSPECTION REQUIRED

YES ☐

NO ☐

**NOTE: INDEPENDENT INSPECTIONS MUST BE RECORDED AND CERTIFIED IN AN APPROVED MANNER.**

1 <sup>ST</sup> INSPN			2 <sup>ND</sup> INSPN		
(NAME)	SIGN & APPROVAL STAMP	DATE/TIME	NAME	SIGN & APPROVAL STAMP	DATE/TIME

# Non Routine Job Card

<b>Work Pack Reference:</b>	8756221-001	<b>REV NO:</b>	01
<b>A/C Type:</b>	B777-200		
<b>REGISTRATION:</b>	EI-GSK	<b>PAGE:</b>	Page 2 of 3
<b>MSN:</b>	23456	<b>VISIT NO:</b>	
<b>WORK ORDER:</b>	5377754-1	<b>Location/Dept.</b>	SNN

*Please Record Details of any Independent Inspections Performed Below*

## ASSOCIATED DOCUMENTS / RELATED CARDS

NRCs raised	NRC No(s):	Add Work Sheets raised:	AWS No(s):	ASSOCIATED TECH LOG PAGE	CARD CLEAR
YES <input type="checkbox"/>	NIL	YES <input type="checkbox"/>	NIL		<div>SENDALL</div> <div>747</div>
NO <input type="checkbox"/>		NO <input type="checkbox"/>			

# Non Routine Job Card

Work Pack Reference:	8756221-001	REV NO:	01
A/C Type:	B777-200		
REGISTRATION:	EI-GSK	PAGE:	Page 3 of 3
MSN:	23456	VISIT NO:	
WORK ORDER:	5377754-1	Location/Dept.	SNN

MATERIALS & PARTS REQUIREMENT					
DESCRIPTION			PART NUMBER		QTY
PART(S) / MATERIALS USED					
DESCRIPTION	PART NO. OFF	SERIAL NO. OFF	PART NO. ON	SERIAL NO. ON	BATCH NO./ GRN

TOOLING REQUIREMENTS			
DESCRIPTION		PART NUMBER	QTY
CALIBRATED TOOLING USED			
DESCRIPTION	PART NUMBER	SERIAL NUMBER	CALIBRATION DUE DATE

MAN HOURS		
OPEN/ CLOSE ACCESS	TASK HOURS	RECORD ACTUAL MAN HOURS TAKEN



## 777-200 STRUCTURAL REPAIR MANUAL

### REPAIR 1 - PROCEDURES FOR THE REPAIR OF ALUMINUM FLAME-SPRAYED COATINGS

#### 1. Applicability

- A. Repair 1 is applicable to the repair of damage to aluminum flame-sprayed components. Refer to 51-70-14, GENERAL for the locations and drawing numbers for these parts.
- B. For repairs to the composite plies below the electrically protective coating, refer to the applicable Chapter-Section-Subject for the component.

#### 2. General

- A. You can repair aluminum flame spray coatings also with expanded aluminum foil mesh (BMS 8-336). Refer to Repair 4 for the repair procedures.
- B. Make sure that you use approved facilities when you apply aluminum flame-spray coatings.
- C. The Category B repair given in Paragraph 4./REPAIR 1 must be inspected at or before every 400 flight cycles.

**NOTE:** If the inspection shows deterioration, you must do the Category B repair again, or replace it with a Category A repair.

- D. Refer to Table 201/REPAIR 1 for a list of references for the different types of repairs.

**Table 201:**

PARAGRAPH REFERENCES FOR THE DIFFERENT TYPES OF REPAIRS THAT APPLY TO ALUMINUM FLAME-SPRAYED PARTS	
TYPE OF REPAIR	PARAGRAPH
Category B Repair of Aluminum Flame-Sprayed Coatings	Paragraph 4./REPAIR 1
Category A Repair of Aluminum Flame-Sprayed Coatings - Full Conductivity	Paragraph 5./REPAIR 1
Procedure to Fully Replace an Aluminum Flame-Sprayed Coating on a Flat or Single Contoured Surface With Aluminum Flame-Spray and PVA	Paragraph 6./REPAIR 1
Procedure to Fully Replace an Aluminum Flame-Sprayed Area on a Flat or Single Contoured Surface With Aluminum Foil	Paragraph 7./REPAIR 1
Repair of Fastener Holes in Aluminum Flame-Sprayed Components	Paragraph 8./REPAIR 1
Repair of the Surface Coatings or finishes After the Repair	Paragraph 9./REPAIR 1

- E. Keep the resin systems between 40°F (4°C) and 80°F (27°C) in sealed containers. Keep the conductive coating material (BMS 10-21) between 40°F (4°C) and 90°F (32°C) in sealed containers.
  - (1) Identify the material container with a label that includes the data that follows:
    - (a) BMS specification
    - (b) Type
    - (c) Class
    - (d) Name of the supplier and the product designation
    - (e) Batch number
    - (f) Date of the preparation.
- F. Refer to 51-30-03, GENERAL for the sources of the materials.

#### 3. References

Reference	Title
51-00-06, GENERAL	Structural Repair Definitions

# 51-70-14

REPAIR 1

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# 777-200 STRUCTURAL REPAIR MANUAL

(Continued)

Reference	Title
51-20-01, GENERAL	Protective Treatment - Metal Structure
51-30-03, GENERAL	Sources For Non-Metallic Repair Materials
51-40-05, GENERAL	Fastener Hole Sizes
51-40-08, GENERAL	Countersink Data and Procedures for Metal Structures
51-70-04, REPAIR GENERAL	Repair Procedures for Wet Layup Materials
51-70-05, REPAIR GENERAL	Repair Procedures for Preimpregnated Materials
51-70-09, GENERAL	Metal-To-Metal Structural Repair Adhesive Bond Procedures
51-70-14, GENERAL	Structures with Aluminum Coatings and Foils
AMM 51-21-10 P/B 701	DECORATIVE EXTERIOR PAINT SYSTEM - CLEANING/PAINTING
AMM 51-24-02 P/B 701	CONDUCTIVE COATING FOR EXTERNAL SURFACES - CLEANING/PAINTING
AMM 51-24-13 P/B 701	ABRASION-RESISTANT TEFLON FINISH - CLEANING/PAINTING
SOPM 20-30-03	General Cleaning Procedures
SOPM 20-41-02	Standard Overhaul Practices Manual

## 4. Category B Repair of Aluminum Flame-Sprayed Coatings

**CAUTION:** DO NOT SAND INTO THE PLIES BELOW THE FLAME-SPRAY COATING. IF YOU DO, DAMAGE TO THE STRUCTURE WILL OCCUR.

- A. Lightly sand the damaged area with 180-grit or finer abrasive paper. Remove all the loose flame-sprayed aluminum.
- B. Remove the finish up to minimum of 1.00 inch (25 mm) around the edge of the damage with 240-grit or finer abrasive paper. Do not sand through the flame-sprayed aluminum.

**WARNING:** KEEP THE SOLVENTS AWAY FROM SOURCES OF HEAT, FIRE OR SPARKS. IF YOU DO NOT, AN EXPLOSION CAN OCCUR.

DO NOT PERMIT THE SOLVENTS TO TOUCH YOUR SKIN, EYES OR CLOTHING. DO NOT BREATHE THE VAPORS. WEAR PROTECTIVE CLOTHING AND EYE PROTECTION. MAKE SURE THERE IS A GOOD FLOW OF CLEAN AIR. IN A CONFINED SPACE, USE MECHANICAL VENTILATION FOR RESPIRATORY PROTECTION. INJURY TO PERSONS CAN OCCUR.

- C. Solvent clean the sanded areas. Remove all of the dust and other unwanted materials. Refer to SOPM 20-30-03 for applicable solvents and procedures.
- D. Apply a chemical conversion coating to the flame-sprayed aluminum. Refer to 51-20-01, GENERAL.
- E. Apply BMS 10-21, Type 3 conductive coating. Refer to AMM PAGEBLOCK 51-24-02/701.
- F. Apply a finish coating as applicable. Refer to Paragraph 9./REPAIR 1
- G. Inspect the repair every 400 flight cycles or more frequently. If there is deterioration, do the Category B repair again or replace it with a Category A repair.

# 51-70-14

REPAIR 1

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