

COMPOSITE PROPELLER - CLEANING/PAINTING

1. General

A. Composite propeller cleaning/painting consists of repainting the propeller.

2. Composite Propeller Painting

A. Paint Propeller.

- (1) Roll on one coat of 13 parts spray fill D61-A-23 and 1 part V66V27 catalyst. Allow to dry.
- (2) Sand with vibrator type sander with appropriate grit paper as required, leaving minimum thickness for purpose of filling pits and blemishes only.
- (3) Spray one coat of 13 parts E65A4 Polane primer sealer with 1 part V66V29 catalyst, (and V66VB11 accelerator as needed). Wipe with acetone soaked cheese cloth to smooth down any pronounced Kevlar fiber. Sand with appropriate grit paper as required (dry sand).
- (4) Spray face and camber with one light coat of 13 parts E65A4 Polane primer sealer with 1 part V66V29 catalyst, (and V66VB11 accelerator as needed). Sand with No. 400 grit sandpaper until desired finish is achieved, leaving no more than 4 mils total Polane primer sealer thickness.
- (5) Tape nickel leading edge, both face and camber, 0.75 inch aft from leading edge radius.
- (6) Spray with Spraylat (copper) Lightning Guard (P/N 599SA-A8574-1) 8 parts (A) with 1 part (B). Minimum thickness of 1 mil recommended.
- (7) Remove tape and feather edge of paint line.
- (8) Allow to dry 30 minutes and sand with variable grit sandpaper until smooth.
- (9) Spray light coat of 13 parts E65A4 Polane primer sealer with 1 part V66VB29 catalyst (and V66VB11 accelerator as needed) on both face and camber. Repeat second light coat on both face and camber, to achieve full coverage, but no lead or trail buildup. Total thickness not to exceed 2 mils dry.
- (10) Spray one light coat of 6 parts Polane black F63B8 with 1 part V66V29 catalyst, (and V66VB11 accelerator as needed) on both face and camber. Repeat second light coat on both face and camber so as to have full coverage but no lead or trail buildup. Total thickness of approximately 4 mils is recommended.
- (11) Tip (1), spray with 6 parts white plane 299WB612 with 1 part V66V29 catalyst, on camber side only.