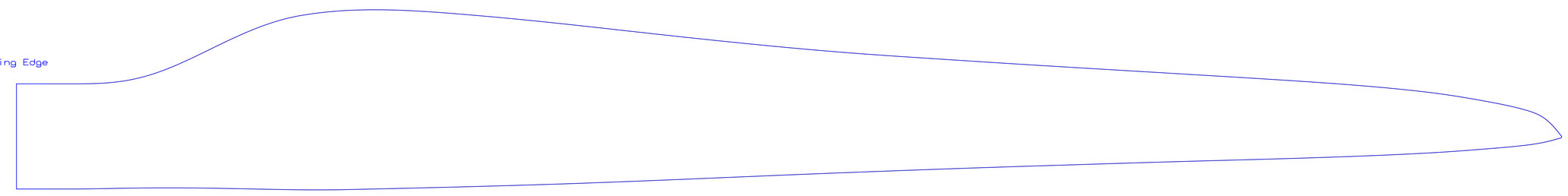
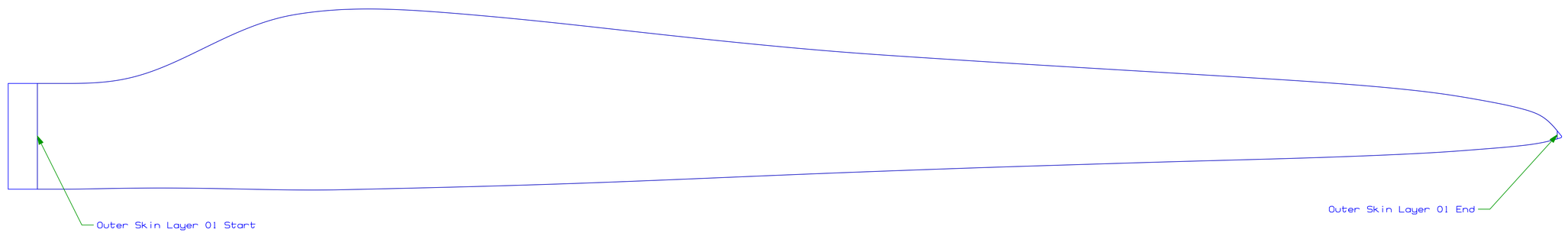


1 Mold Preparation

Clean and prepare master mold per manufacturer's standard procedures for vacuum assisted resin transfer molding (VARTM) processes

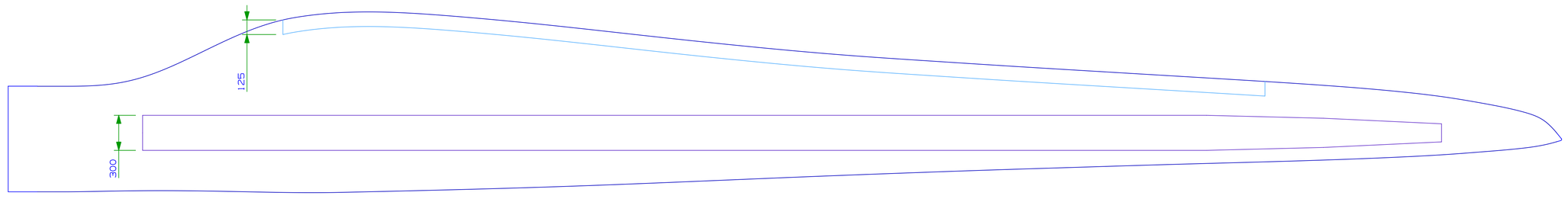


2 Outer Skin

Place outer skin plies. Wrap layers 01 & 02 onto master mold flange.

See 169.02.04.007 for outer skin lamination.

See document WEI 98.10.02.001 for details with respect to laminate quality.



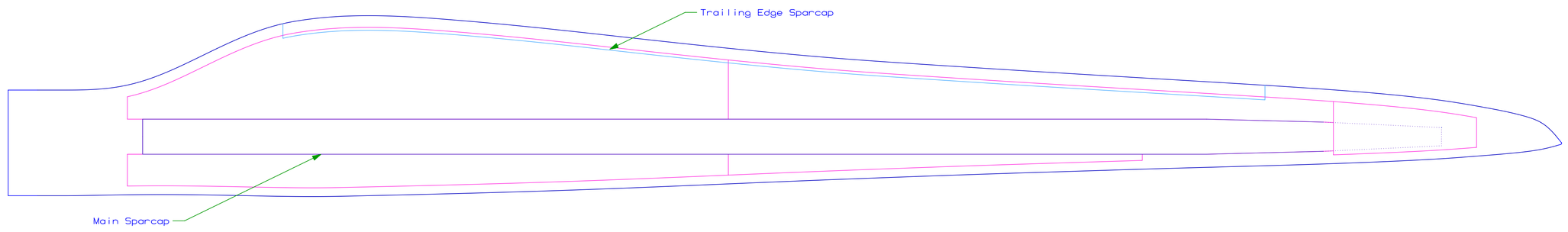
3 Sparcaps

Place plies for main sparcap and trailing edge sparcap in the master mold.

See 169.02.04.006 for trailing edge sparcap lamination.

See 169.02.04.005 for main sparcap lamination.

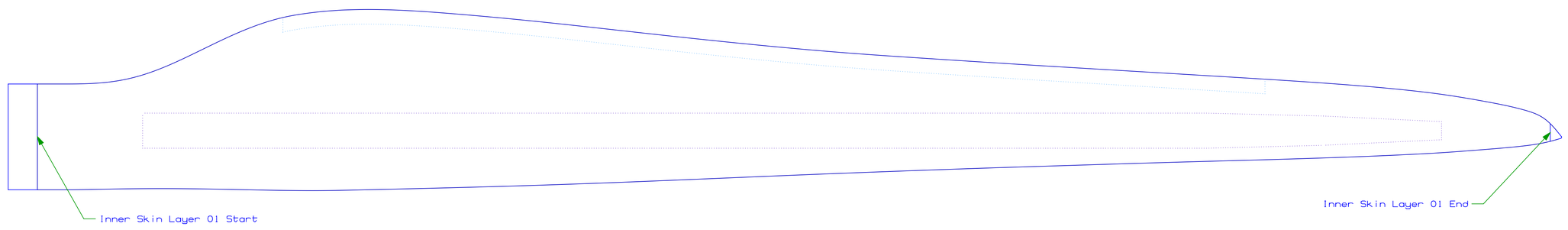
See document WEI 98.10.02.001 for details with respect to laminate quality.



4 Shell Core

Place shell core in master mold.

See 169.02.04.009 for core details.

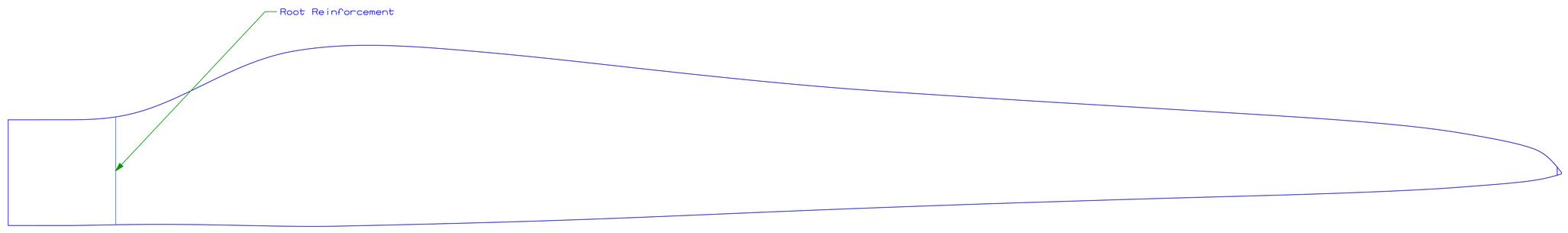


5 Inner Skin

Place inner skin in master mold. Wrap layers 01 & 02 onto master mold flange.

See 169.02.04.008 for inner skin lamination.

See document WEI 98.10.02.001 for details with respect to laminate quality.

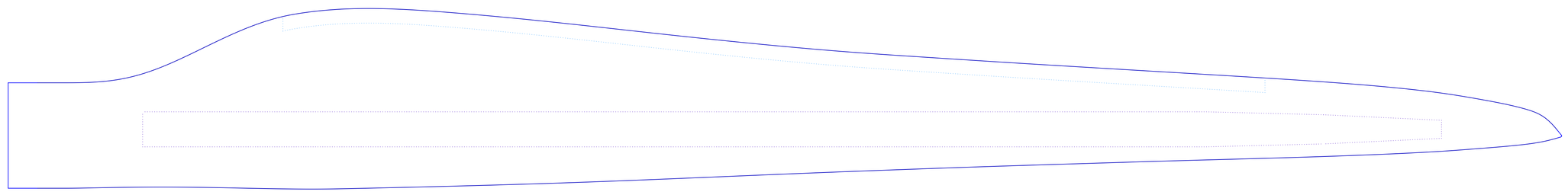


6 Root Reinforcement

Lightly sand premolded root reinforcement to remove infusion residue and clean with acetone to remove dust or other foreign contaminates.

Place premolded root reinforcement in the master mold.

See 169.02.04.004 for root reinforcement lamination.



7 Infuse Shell

Prepare laminate for infusion by applying VARTM materials.

Infuse suction side shell.

Remove VARTM materials.

See 169.02.04.003 for Pressure Side Shell Assembly Procedure.

See 169.02.04.001 for Blade Assembly Procedure.

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WETZEL ENGINEERING

SNL 13m-225K-A Blade

Release History

Rel	Date	Description of Change
A	04/22/2016	Original

Suction Side Assembly Procedure

Sheet 1/1			
Drawing No. 169.02.04.002	Release 1	Drawn By ASE	Date 04/18/2016
		Reviewed By ART	Date 04/18/2016
Release Date 04/18/2016	Units mm	Checked By RMB	Date 04/21/2016
Scale 1:20	Size A0	Approved By KKW	Date 04/22/2016