

1Mold Preparation

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

Tip

2Outer 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 99.10.02.001 for details with respect to laminate quality.

3Sparcaps

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 99.10.02.001 for details with respect to laminate quality.

4Shell Core

Place shell core in master mold.
See 169.02.04.009 for core details.

5Inner 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 99.10.02.001 for details with respect to laminate quality.

6Leading Edge Clip and Trailing Edge Clip

Attach removable leading edge lip mold surface to leading edge of the master mold.
Place leading edge clip plies with half of ply width on pressure surface, and half on removable mold surface.
Attach removable trailing edge lip mold surface to trailing edge of the master mold.
Place trailing edge clip plies with half of ply width on pressure surface, and half on removable mold surface.
See 169.02.04.012 for more details on trailing edge clip placement.
See 169.02.04.013 for more details on leading edge clip placement.

7Root Reinforcement

Lightly sand premolded root reinforcement to remove infusion residue and clean with acetone to remove dust or other foreign contaminants.
Place premolded root reinforcement in the master mold.
See 169.02.04.004 for root reinforcement lamination.

8InFuse Shell

Prepare laminate for infusion by applying VARTM materials.
InFuse suction side shell.
Remove VARTM materials.

See 169.02.04.002 for Suction Side Shell Assembly Procedure.
See 169.02.04.001 for Blade Assembly Procedure.

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SNL 13m-225K-A Blade				Pressure Side Assembly Procedure			
Rev	Date	Release History		Sheet	Revision		
		Description of Change	Original		By	Date	Reason
A	04/22/2016	Original	1	1120	1	04/18/2016	Initial Release
					2	04/18/2016	Revised
					3	04/21/2016	Revised
					4	04/22/2016	Revised