

# CURE REPORT

## Job

103454

## Program

D11765

## Part

55010-100

Rev. C

GREMLINS SHROUD (AS MOLDED)

Qty: 1

## Cure

Start: 03-Feb-2021 | 8:41 AM

Finish: 03-Feb-2021 | 3:21 PM

Duration: 6h:40m

## Equipment

Autoclave | Controller: S2601

Air TC1: S2600 | Air TC2: S2603

PT: S2599 | VT2: S2598

VT3: S2595

## Cure Document

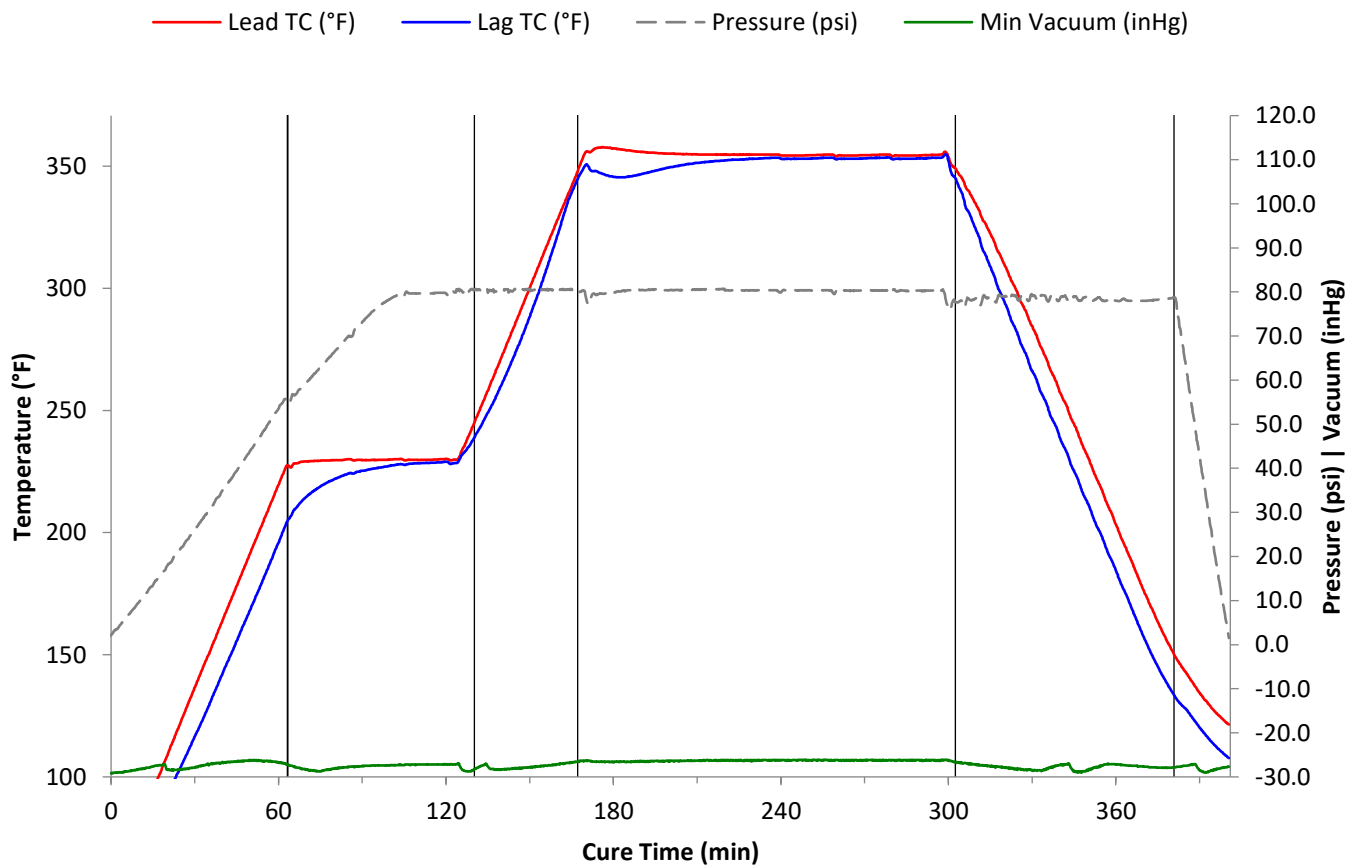
SPS-201

Rev. B

Profile: CURE A4

**FAIL**

All equipment used is calibrated and traceable to the SI through NIST.



Completed By: Andrei Branga

Date: 2/3/2021

QA Signoff: \_\_\_\_\_

Date: \_\_\_\_\_

# CURE REPORT

Step	Requirements	Result	NCR
<b>Temp Ramp</b> <b>(FAIL)</b> Start: 0.0 min Finish: 63.2 min Duration: 63.2 min	Temperature Max 245°F Temp. Ramp 5°F/min +0/-10°F/min Pressure: Max 1 psi Vacuum Min -15 inHg <u>Terminate</u> Lag > 205°F	Temperature (°F) Max 228 Temp. Ramp (°F/min) Max 2.9   Min 1.6 <u>Pressure (psi)</u> <u>Max 55.7</u> Vacuum (inHg) Min -26.2	
<b>Temp Hold</b> <b>(FAIL)</b> Start: 63.3 min Finish: 63.3 min Duration: 0.0 min	Temperature 225°F ±20°F Pressure: Max 2 psi Vacuum Min -15 inHg <u>Terminate</u> After 60 min OR > 2 psi	Temperature (°F) Max 228   Min 205   Avg 220 <u>Pressure (psi)</u> <u>Max 54.8</u> Vacuum (inHg) Min -27.3	
<b>Ramp Pressure</b> <b>(PASS)</b> Start: 63.5 min Finish: 130.2 min Duration: 66.7 min	Temperature 225°F ±20°F Pressure: Max 90 psi Pressure Ramp 1.5 psi/min ±1 psi/min Vacuum Min -15 inHg <u>Terminate</u> Time continued from previous step. AND Lead > 245°F	Temperature (°F) Max 232   Min 205   Avg 228 Pressure (psi) Max 80.7 Pressure Ramp (psi/min) Max 0.7   Min 0.6 Vacuum (inHg) Min -27.0	
<b>Ramp Up</b> <b>(PASS)</b> Start: 130.3 min Finish: 167.2 min Duration: 36.8 min	Temperature Max 370°F Temp. Ramp 5°F/min +0/-6°F/min Pressure: Max 90 psi Vacuum Min -15 inHg <u>Terminate</u> Lag > 345°F AND > 70 psi	Temperature (°F) Max 348 Temp. Ramp (°F/min) Max 3.6   Min 2.2 Pressure (psi) Max 80.7 Vacuum (inHg) Min -26.5	
<b>Dwell</b> <b>(PASS)</b> Start: 167.3 min Finish: 302.5 min Duration: 135.2 min	Temperature 350°F +20/-5°F Pressure: 80 psi ±10 psi Vacuum Min -15 inHg <u>Terminate</u> Lag < 345°F AND After 120 min	Temperature (°F) Max 358   Min 345   Avg 353 Pressure (psi) Max 80.7   Min 75.8   Avg 80.2 Vacuum (inHg) Min -26.1	

# CURE REPORT

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## Ramp Down

(PASS)

Start: 302.7 min

Finish: 380.8 min

Duration: 78.2 min

*Temperature Max 370°F*

*Temp. Ramp -5°F/min +10/-0°F/min*

*Pressure: 80 psi ±10 psi*

**Terminate**

*Lead < 150°F*

**Temperature (°F)**

Max 349

**Temp. Ramp (°F/min)**

Max -2.1 | Min -3.0

**Pressure (psi)**

Max 79.5 | Min 76.5 | Avg 78.4

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## Ramp Down

**Pressure**

(PASS)

Start: 381.0 min

Finish: 399.5 min

Duration: 18.5 min

*Temperature Max 150°F*

*Pressure: Max 90 psi*

*Pressure Ramp -5 psi/min +10/-0 psi/min*

**Terminate**

*< 5 psi*

**Temperature (°F)**

Max 141

**Pressure (psi)**

Max 78.7

**Pressure Ramp (psi/min)**

Max -4.0 | Min -4.1