

CURE REPORT

Job

103770

Program

D11897

Part

49551-100

Rev. E

DLAS RIGHT, AS MOLDED

Qty: 1

Cure

Start: 29-Jan-2021 | 10:14 AM

Finish: 29-Jan-2021 | 2:30 PM

Duration: 4h:15m

Equipment

Autoclave | Controller: S2601

Air TC1: S2600 | Air TC2: S2603

PT: S2599 | VT2: S2598

Cure Document

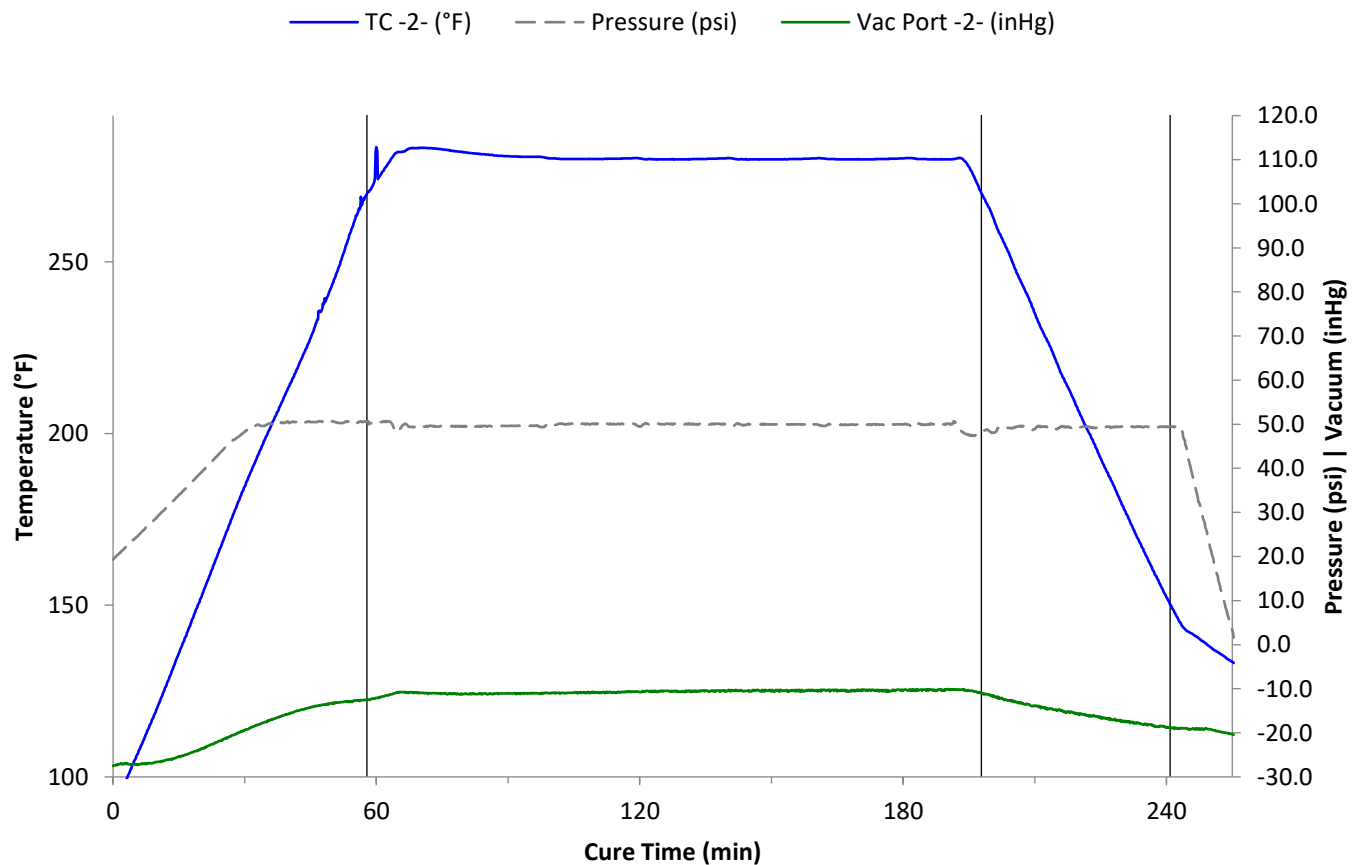
SPS-201

Rev. B

Profile: CURE A2

FAIL

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



Completed By: Andrei Branga

Date: 1/29/2021

QA Signoff: Zac Kambarn

Date: 2/2/2021

CURE REPORT

| Step | Requirements | Result | NCR |
|-----------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|
| Ramp Up (FAIL) Start: 0.0 min Finish: 57.8 min Duration: 57.8 min | Temperature Max 295°F Temp. Ramp 5°F/min +0/-5°F/min Pressure: Max 60 psi Pressure Ramp 1.5 psi/min ±1 psi/min Vacuum Min -15 inHg <u>Terminate</u> Lag > 270°F AND > 40 psi | Temperature (°F) Max 270 Temp. Ramp (°F/min) Max 3.5 Min 2.8 Pressure (psi) Max 50.7 Pressure Ramp (psi/min) Max 1.0 Min 1.0 <u>Vacuum (inHg)</u> <u>Min -12.5</u> | DMR 2453 |
| Dwell (PASS) Start: 58.0 min Finish: 197.8 min Duration: 139.8 min | Temperature 275°F +20/-5°F Pressure: 50 psi ±10 psi <u>Terminate</u> Lag < 270°F AND After 120 min | Temperature (°F) Max 283 Min 279 Avg 280 Pressure (psi) Max 50.7 Min 47.4 Avg 49.8 | |
| Ramp Down (PASS) Start: 198.0 min Finish: 240.8 min Duration: 42.8 min | Temperature Max 295°F Temp. Ramp -5°F/min +10/-0°F/min Pressure: 50 psi ±10 psi <u>Terminate</u> Lead < 150°F | Temperature (°F) Max 270 Temp. Ramp (°F/min) Max -2.6 Min -2.9 Pressure (psi) Max 49.6 Min 48.0 Avg 49.2 | |
| Ramp Down Pressure (PASS) Start: 241.0 min Finish: 254.3 min Duration: 13.3 min | Temperature Max 150°F Pressure: Max 60 psi Pressure Ramp -10 psi/min +15/-0 psi/min <u>Terminate</u> < 5 psi | Temperature (°F) Max 142 Pressure (psi) Max 49.5 Pressure Ramp (psi/min) Max -3.5 Min -4.0 | |