

CURE REPORT

Job

103755

Program

D11897

Part

49481-100

Rev. E

DLAS LEFT, AS MOLDED

Qty: 1

Cure

Start: 04-Feb-2021 | 10:16 AM

Finish: 04-Feb-2021 | 2:50 PM

Duration: 4h:34m

Equipment

Autoclave | Controller: S2601

Air TC1: S2600 | Air TC2: S2603

PT: S2599 | VT3: S2595

Cure Document

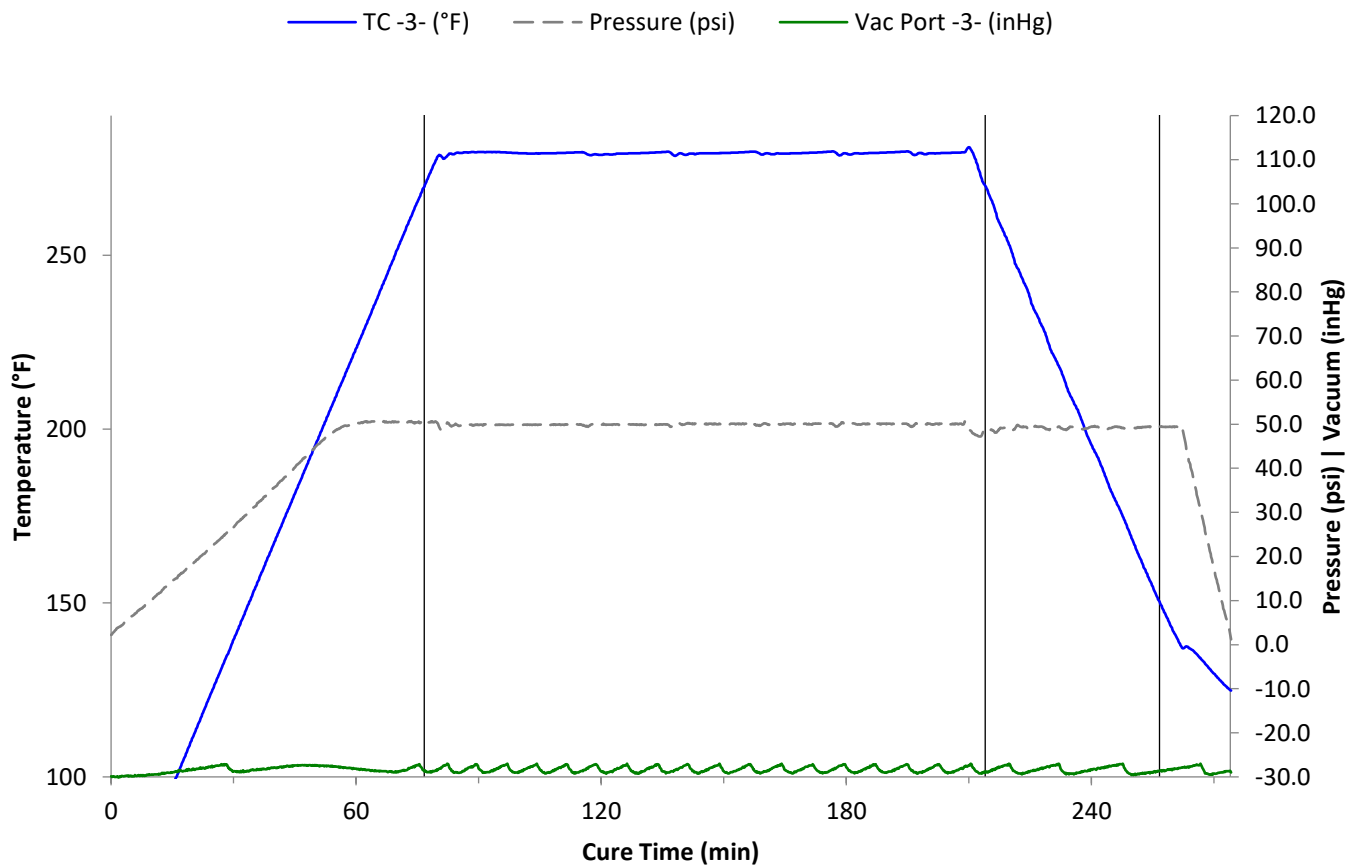
SPS-201

Rev. B

Profile: CURE A2

PASS

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



Completed By: Andrei Branga

Date: 2/4/2021

QA Signoff: Zac Kambarn

Date: 2/4/2021

CURE REPORT

Step	Requirements	Result	NCR
Ramp Up (PASS) Start: 0.0 min Finish: 76.7 min Duration: 76.7 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 2.8 Min 2.2 Pressure (psi) Max 50.7 Pressure Ramp (psi/min) Max 0.9 Min 0.8 Vacuum (inHg) Min -27.1	
Dwell (PASS) Start: 76.8 min Finish: 214.0 min Duration: 137.2 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 281 Min 278 Avg 279 Pressure (psi) Max 50.6 Min 47.2 Avg 49.9	
Ramp Down (PASS) Start: 214.2 min Finish: 256.7 min Duration: 42.5 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 -2.7 Min -3.0 Pressure (psi) Max 49.8 Min 48.1 Avg 49.2	
Ramp Down Pressure (PASS) Start: 256.8 min Finish: 273.2 min Duration: 16.3 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 138 Pressure (psi) Max 49.5 Pressure Ramp (psi/min) Max -1.9 Min -4.0	