

CURE REPORT

Job
104355
Program
D11675

Part
48777-100
Rev. H
ARRW COMPOSITE SHROUD (AS MOLDED)
Qty: 1

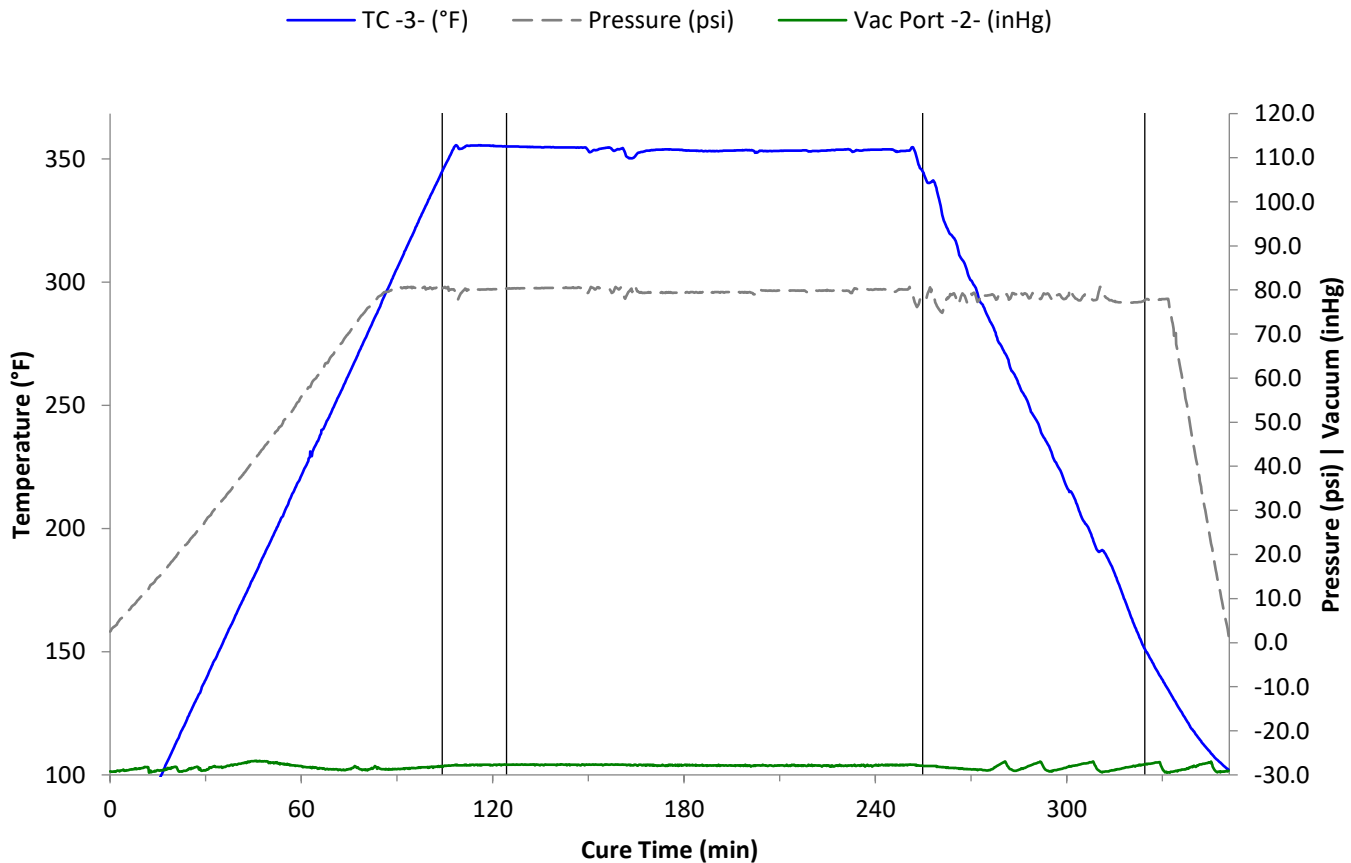
Cure
Start: 02-Feb-2021 | 10:15 AM
Finish: 02-Feb-2021 | 4:06 PM
Duration: 5h:51m

Equipment
Autoclave | Controller: S2601
Air TC1: S2600 | Air TC2: S2603
PT: S2599 | VT2: S2598

PASS

Cure Document
SPS-201
Rev. B
Profile: CURE A1

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



Completed By: Andrei Branga

Date: 2/2/2021

QA Signoff: Zac Kambarn

Date: 2/3/2021

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Step	Requirements	Result	NCR
Ramp Up (PASS) Start: 0.0 min Finish: 104.2 min Duration: 104.2 min	Temperature Max 370°F Temp. Ramp 5°F/min +0/-5°F/min Pressure: Max 90 psi Pressure Ramp 1.5 psi/min ±1 psi/min Vacuum Min -15 inHg <u>Terminate</u> Lag > 345°F AND > 70 psi	Temperature (°F) Max 345 Temp. Ramp (°F/min) Max 2.8 Min 2.4 Pressure (psi) Max 80.7 Pressure Ramp (psi/min) Max 1.0 Min 0.8 Vacuum (inHg) Min -26.8	
Dwell W/Vac (PASS) Start: 104.3 min Finish: 124.3 min Duration: 20.0 min	Temperature 350°F +20/-5°F Pressure: 80 psi ±10 psi Vacuum Min -15 inHg <u>Terminate</u> After 20 min	Temperature (°F) Max 356 Min 354 Avg 354 Pressure (psi) Max 80.7 Min 77.7 Avg 80.0 Vacuum (inHg) Min -27.6	
Dwell (PASS) Start: 124.5 min Finish: 254.8 min Duration: 130.3 min	Temperature 350°F +20/-5°F Pressure: 80 psi ±10 psi <u>Terminate</u> Lag < 345°F AND After 100 min	Temperature (°F) Max 355 Min 350 Avg 354 Pressure (psi) Max 80.7 Min 76.1 Avg 79.9	
Ramp Down (PASS) Start: 255.2 min Finish: 324.5 min Duration: 69.3 min	Temperature Max 370°F Temp. Ramp -5°F/min +10/-0°F/min Pressure: 80 psi ±10 psi <u>Terminate</u> Lead < 150°F	Temperature (°F) Max 344 Temp. Ramp (°F/min) Max -2.0 Min -3.5 Pressure (psi) Max 80.7 Min 74.8 Avg 78.3	
Ramp Down Pressure (PASS) Start: 325.0 min Finish: 349.8 min Duration: 24.8 min	Temperature Max 150°F Pressure: Max 90 psi Pressure Ramp -10 psi/min +15/-0 psi/min <u>Terminate</u> < 5 psi	Temperature (°F) Max 139 Pressure (psi) Max 78.0 Pressure Ramp (psi/min) Max -0.8 Min -4.1	