

CURE REPORT

Job

103827

Program

D11765

Part

56745-100

Rev. B

HINGE COVER, UPPER (AS-MOLDED)

Qty: 1

Cure

Start: 27-Jan-2021 | 9:15 AM

Finish: 27-Jan-2021 | 2:44 PM

Duration: 5h:30m

Equipment

Autoclave | Controller: S2601

Air TC1: S2600 | Air TC2: S2603

PT: S2599 | VT6: S2596

Cure Document

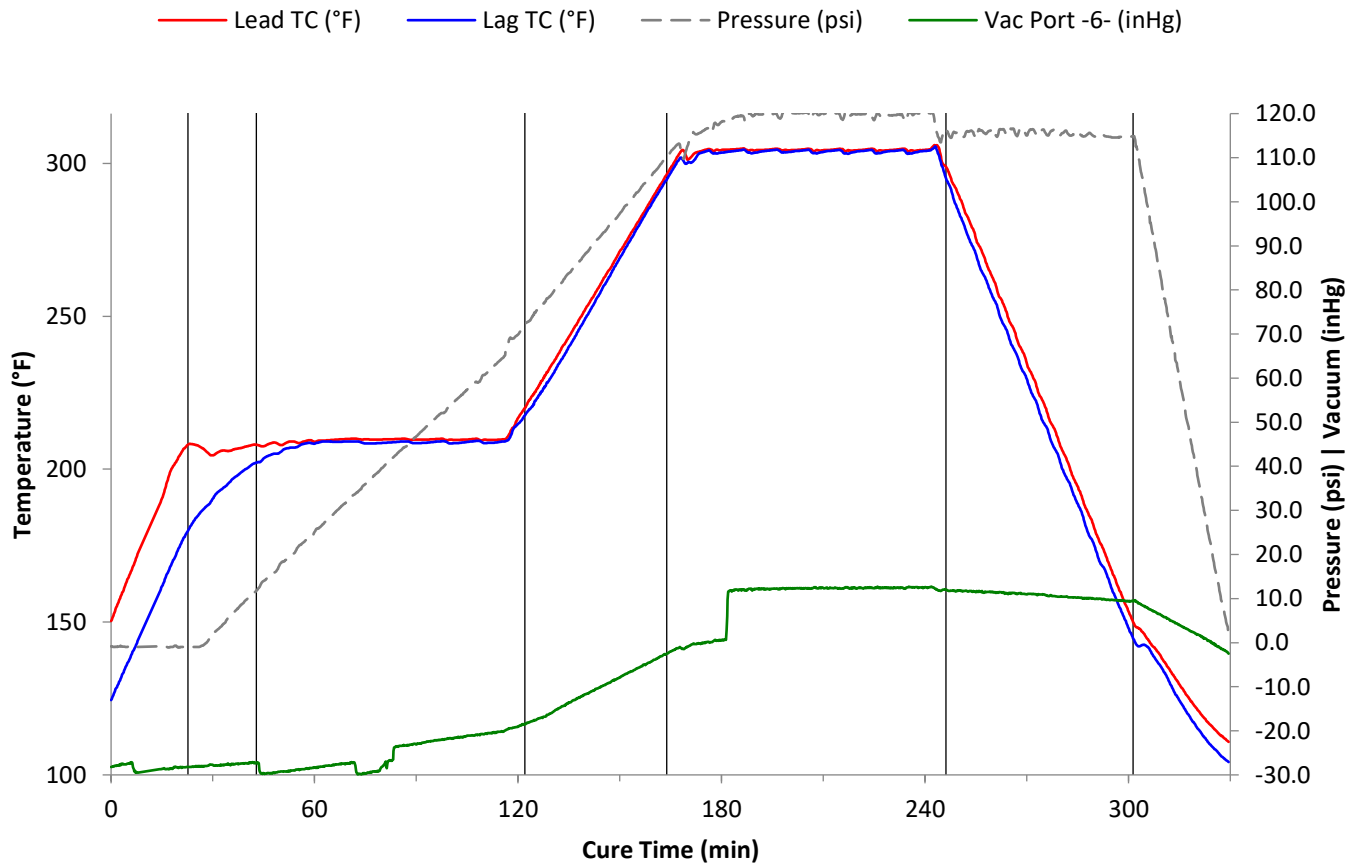
SPS-201

Rev. B

Profile: CURE A3 120 PSI

FAIL

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



Completed By: Andrei Branga

Date: 1/27/2021

QA Signoff: Zac Kambarn

Date: 1/28/2021

CURE REPORT

Step	Requirements	Result	NCR
Temp Ramp (PASS) Start: 0.0 min Finish: 22.7 min Duration: 22.7 min	Temperature Max 220°F Temp. Ramp 5°F/min +0/-10°F/min Vacuum Min -15 inHg <u>Terminate</u> Lag > 180°F	Temperature (°F) Max 208 Temp. Ramp (°F/min) Max 2.7 Min 2.5 Vacuum (inHg) Min -27.1	
Temp Hold (PASS) Start: 22.8 min Finish: 42.8 min Duration: 20.0 min	Temperature 200°F ±20°F Vacuum Min -15 inHg <u>Terminate</u> After 20 min AND > 2 psi	Temperature (°F) Max 208 Min 188 Avg 198 Vacuum (inHg) Min -27.1	
Ramp Pressure (PASS) Start: 43.0 min Finish: 122.0 min Duration: 79.0 min	Temperature 200°F ±20°F Pressure: Max 130 psi Pressure Ramp 1.5 psi/min ±1 psi/min Vacuum Min -15 inHg <u>Terminate</u> Time continued from previous step. AND Lead > 220°F	Temperature (°F) Max 214 Min 202 Avg 209 Pressure (psi) Max 72.2 Pressure Ramp (psi/min) Max 1.1 Min 0.7 Vacuum (inHg) Min -18.4	
Ramp Up (FAIL) Start: 122.2 min Finish: 163.8 min Duration: 41.7 min	Temperature Max 320°F Temp. Ramp 3°F/min +0/-6°F/min Pressure: Max 130 psi Vacuum Min -15 inHg <u>Terminate</u> Lag > 295°F AND > 110 psi	Temperature (°F) Max 296 Temp. Ramp (°F/min) Max 2.0 Min 1.7 Pressure (psi) Max 110.1 <u>Vacuum (inHg)</u> <u>Min -2.5</u>	
Dwell (FAIL) Start: 164.0 min Finish: 246.2 min Duration: 82.2 min	Temperature 300°F +20/-5°F Pressure: 120 psi ±10 psi Vacuum: 0 inHg +10/-31 inHg <u>Terminate</u> Lag < 295°F AND After 60 min	Temperature (°F) Max 306 Min 300 Avg 304 <u>Pressure (psi)</u> <u>Max 120.7 Min 109.7 Avg 118.5</u> <u>Vacuum (inHg)</u> <u>Max 12.7 Min -2.4 Avg 9.5</u>	DMR 2445

CURE REPORT

Ramp Down

(FAIL)

Start: 246.3 min
Finish: 301.3 min
Duration: 55.0 min

Temperature Max 320°F

Temp. Ramp -5°F/min +10/-0°F/min

Pressure: 120 psi ±10 psi

Vacuum: 0 inHg +10/-31 inHg

Terminate

Lead < 150°F

Temperature (°F)

Max 299

Temp. Ramp (°F/min)

Max -2.6 | Min -2.9

Pressure (psi)

Max 116.6 | Min 114.4 | Avg 115.5

Vacuum (inHg)

Max 12.0 | Min 9.3 | Avg 10.8

Ramp Down

Pressure

(PASS)

Start: 301.5 min
Finish: 328.7 min
Duration: 27.2 min

Temperature Max 150°F

Pressure: Max 130 psi

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

Terminate

< 5 psi

Temperature (°F)

Max 143

Pressure (psi)

Max 114.9

Pressure Ramp (psi/min)

Max -4.0 | Min -4.2