

GENERAL INFORMATION

RO NUMBER	RMN-22-269	DESCRIPTION	RADOME
CUSTOMER	GALAXY AEROSPACE	PART NUMBER	355A81-1030-100
REMOVED FROM A/C REG	M502-1	SERIAL NUMBER	N/A

RECORD OF REVISION

Revision Number	Remark
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INSPECTION REFERENCE

- MTC STANDARD PRACTICE MANUAL 20-03-01-101 (Tap Test and Moisture Test)

FIGURE 1



PART & SERIAL NUMBER VERIFICATION

- Preliminary inspection found that P/N: 355A81-1030-100 matched.

FIGURE 2: UNIT OVERVIEW



FIGURE 3



FINDING:

- Found delamination on L/H front area size 105 mm x 155 mm 16275 sq mm or 25.2 sq inch.
- Found paint crack approximately 170 mm.

REFERENCE:

- A. 20-03-01-101 – General Repair Instruction: General
- B. 20-03-06-405 – Repairing radome anti-static coating
- C. 20-03-06-406 – Structure Repair Vacuum Bag Techniques
- D. 20-03-06-409 – Repair of Flaking of the Skin on a Monolithic or Sandwich Panel
- E. 20-03-06-418 – Repair of a perforation in a Kevlar / carbon / honeycomb skin
- F. 20-03-07-101 – Repair and machining of composite material
- G. 20-06-01-101 - Bonding with Adhesives
- H. 20-06-01-411 – Application of Hysol 9396
- I. 20-04-05-413 – Paint and Primer Application

CORRECTIVE ACTIONS:

Notes:

For secondary and tertiary structures, it is permissible to use general processes and standard repair procedure defined in the Standard Practices Manual

- Inspect Radome as per MTC 20-03-01-101.
- Sand all around damaged areas as per MTC 20-03-06-409
- Prepare the surfaces before bonding the repair parts as per MTC 20-06-01-101
- Repair by removing damaged honeycomb core and replacing core as per MTC 20-03-06-418 and 20-03-07-101
- Install Vacuum Bag MTC 20-03-06-40
- Repair by removing damaged delamination (outer and inner) and replacing delamination as per MTC 20-03-06-418 and 20-03-07-101
- Install Vacuum Bag MTC 20-03-06-406
- Unit to be painted as per Standard Practices Manual 20-04-05-413.
- Total repair area size 18 cm x 27 cm = 486 sq cm or 75.3 sq inch.

UNIT TO BE RELEASED WITH COC REPAIRED CONDITION

MATERIAL LIST

No.	Part Number	Skyways Recommended Alternate	Description	Quantity
1	RA153/T105/60M Kit	0986/2620	Antistatic Paint	MOQ
2	HRH10-3.0-1/8 7.8mm	HRH10-3.0-1/8 7.8mm	Honeycomb NOMEX	27 cm x 18 cm
3	AMS3902 Style 285	AMS3902 Style 285	Kevlar Fabric	60 cm x 45 cm
4	Hysol 9396	Hysol 9396 or LY 5052 Kit	Adhesive	MOQ
5	Araldite 252	Araldite 252	Surfacer	MOQ

END OF ASSESSMENT

DETAILED REPAIR COST

DESCRIPTION	LEAD TIME	TOTAL (USD)
LABOUR		3,600.00
PAINTING		1,400.00
MATERIAL		1,400.00
SUBTOTAL	2 WEEKS	USD 6,400.00

APPROVED BY

DATE of APPROVAL

Proceed with proposed work
SCRAP on site
Return As Is

If quote presents different options, kindly state which option is approved:

Quote valid 30 days. Repair parts availability and lead time to perform work to be confirmed upon quote approval receipt.

NOTE:

*** All unserviceable items replaced during repair process will be scrapped after work is performed and unless written instruction for the contrary is received at time of quotation approval.*

***By approving scrap on site work scope and quotation, customer acknowledges that Skyways Technics might keep some serviceable sub-assemblies of the component for its own use.*

*** By approving the present quotation, and in case work scope includes performance of Structural Repair Instruction (SRI), customer agrees to the terms of the SRI, and to the terms of subsequent Structural Repair Approval Sheet (SRAS)*

***Quotation for core unit repairs back from forward exchange transactions will be deemed accepted if no feedback is received from customer within 3 working days after quotation is sent.*