


Revision No. 1	Page 1 of 2	Technical Definition Machining – Room Temperature Carbon Fiber Composite
		
Kit Machining PTP 2021		

You shall respect the HSE policy of your laboratory for each performed test.

Instructions to participant laboratories

Please read carefully these instructions BEFORE starting the tests.

1. One panel (300 x 150 x 2 mm) is supplied to each participant. 7 compression strength specimens shall be **machined** – 7 specimens must be **sent back to PTP**.
If one sample is missing, your test will be considered as an outlier. A RCA shall be completed.
2. **7 B1** specimens (compression strength) shall be **machined** in accordance with the requirements of **EN 2850 (2017)**.

Tabs of the same material of the specimens should be used. The provided panel is big enough to obtain all parts (specimens + tabs).

Adhesive for tabs bonding should be selected by the machining laboratories, the preferred alternatives are:

- Loctite EA9394 paste or equivalent for low curing temperature (RT-70°C).
- FM300-2M film or equivalent for medium curing temperature (120°).
- Loctite EA9695 film or equivalent for high curing temperature (135-180°C).

The samples machining shall be performed respecting the following conditions:

- One operator only
- One machining equipment only (saw, mechanical mill, etc.)
- One finishing equipment only (milling, sanding, etc.)
- One tabbing equipment only (hot plates, autoclave, cold adhesive, etc.)


The manufacturing laboratory should provide a manufacturing report indicating the procedures and manufacturing step details (cutting, finishing, tabbing) indicating the key parameter used (saw disc rpm, water cooling, milling rpm, tabs curing temperature, etc.).

3. The samples will be controlled following the below process :
 - Inspection of packaging by PTP
 - Visual inspection of the samples by Airbus technical experts
 - Dimensional checks on 5 random specimens performed by an independent laboratory
 - Tests of 5 random specimens according to **EN 2850 (2017)** performed by an independent laboratory

Test results will be analysed according to the algorithm A and S (ISO 13528 – 2015) and evaluated using z-score.

4. Machining shall start **as soon as test panel is received**. Please contact the following e-mail address for any technical or administrative query.

Submission date :	July 1st, 2021
Technical and administrative support :	info@ptpscheme.com

Revision No. 1	Page 2 of 2	Technical Definition Machining – Room Temperature Carbon Fiber Composite
		
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5. Instructions for participation are detailed on the website:

<https://ptpscheme.com/>

6. To ensure the confidential treatment of your results in the final report, you will be allocated a unique identity number when you register for the program.

7. Collusion and falsification of your PTP results are totally forbidden. In case of identification or suspicion of collusion or falsification, the laboratory will be excluded from the program and the sponsors will be immediately informed. The sponsors could ask you proofs of your records and analyses, so be sure to conserve data, curves and specimens.

8. Machined specimens shall be sent back before July 1st, 2021, in an appropriate packaging and identified with your confidential number (COM-2021-XXXX) to :

PTP
17 Avenue Didier Daurat
Immeuble Thalès
31700 BLAGNAC
France

REVISION HISTORY

Issue Date	Issue N°	Changes
30/11/2020	1	Document creation