

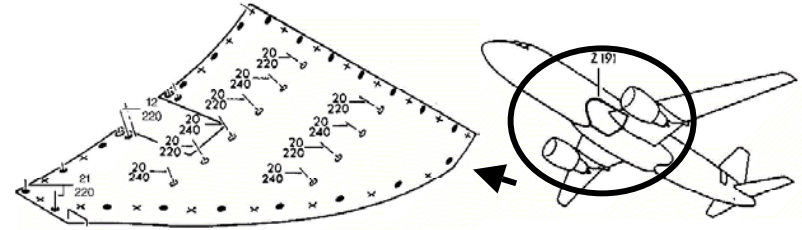
A320F Wing-to-Body Fairing

Wing-to-Body Fairing (WTBF) Panels

WTBF panels are fixed sandwich core structures located forward though aft and above/ below the wing assembly -to- fuselage interface.

-OEM supplied composite materials in a WTBF are:

- 3/16", 3.0 lb hexagonal Nomex honeycomb core (HRH 10-3/16-3.0)
- 250°F/121.11°C cure, 285 style aramid fiber prepreg (50-60% resin)
- 250°F/121.11°C cure, aluminum cloth epoxy prepreg



Acetek's Repair Service

Typical Damage:

- Impact: delaminations, cracks, holes
- Moisture Ingress
- Lightning Strike
- Stress/Strain/Fatigue

Inspection Techniques:

- Tap Test and Visual – Standard
- Thermal Graphic
- Through Transmission Ultrasonic (TTU)

Repairable Scenario:

- Assess damage repair requirements vs BER Limits.
- Maximum damage size is 7.874 inches in diameter (SRM 53-25).
- As long as the unit is within the SRM repairable limits, a core splice and wet lay-up repair may be performed.

Repair Materials:

- 181 style, 8H dry glass fabric
- Laminating resin Hysol 9396A/B or Araldite LY/HY5052
- 3/16, 3.0lb hexagonal Nomex honeycomb core (HRH 10-3/16-3.0)
- Low density void filler compound EC-3524B/A
- Adhesive paste Hysol 9321

WTBF Repair Process

Inspect

Remove Paint (local)

Prepare Repair Disposition (Eng.)

Remove Damaged Materials

Clean & Dry Structure (standard)

Inspect - In Process

Taper/Step-Sand Repair Zone Skin Plies

Fabricate Core Plug

Install Core Plug - Cure Cycle

Inspect - In Process

Close Out Core - Cure Cycle

Inspect - In Process

Prepare Skin Ply Repair Materials Kit

Lay-up Skin Plies - Cure Cycle

Sand and Seal Repair Zone(s)