

**PERMANENT RECORD FOR AMM51-27-08-620-801**

**Source** comment GXCDM06-03-02 X-20 Xzilon

**Revision to:** task AMM51-27-08-620-801

**Manual Revision:** GX=27, GE=5, G5=8 **Source Issue:** **Writer:** Jennifer Singh (bam)

**Comment (Jennifer Singh from bam on 20060322):** Added a new task to apply Xzilon 3 to bright work surfaces.

**Source** engrep P.SPEC.929 Application of Clear Protective Finish Coating

**Revision to:** task AMM51-27-08-620-801

**Manual Revision:** GX=35, G5=16, GE=13 **Source Issue:** **Writer:** Simon Breault (bam)

**Comment (Simon Breault from bam on 20071214):** Revised the consumables table to add the H-38X pads. Revised note concerning the cleaning cycles. Revised step to use Sontara wipers instead of H-32 cloth to clean the bright work surfaces. Revised step concerning the repeating of the cleaning procedure. Revise the xzilon application step to use H-38X pads instead of Sontara wipers.

**Source** comment GXCDM07-12-12 Application of Aircraft Exterior Corrosion Inhibitor.

**Revision to:** task AMM51-27-08-620-801

**Manual Revision:** GX=35, G5=16, GE=13 **Source Issue:** **Writer:** Simon Breault (bam)

**Comment (Simon Breault from bam on 20071214):** Revised the consumables table to add the H-38X pads. Revised note concerning the cleaning cycles. Revised step to use Sontara wipers instead of H-32 cloth to clean the bright work surfaces. Revised step concerning the repeating of the cleaning procedure. Revise the xzilon application step to use H-38X pads instead of Sontara wipers.

EFFECTIVITY: ALL

**Change Description : Revised the consumables table to add the H-38X pads. Revised note concerning the cleaning cycles. Revised step to use Sontara wipers instead of H-32 cloth to clean the bight work surfaces. Revised step concerning the repeating of the cleaning procedure. Revise the xzilon application step to use H-38X pads instead of Sontara wipers.**

**TASK 51-27-08-620-801**

**1. Application of Aircraft Exterior Corrosion Inhibitor**

A. Reference Information

REFERENCE	DESIGNATION
TASK 12-21-00-110-808	Cleaning of the External Surfaces of the Aircraft
TASK 12-21-00-910-801	Cleaning Safety Precautions
TASK 51-25-00-110-801	Solvent Cleaning
TASK 55-10-00-140-801	Polishing of the Horizontal-Stabilizer Leading Edges
TASK 55-30-09-140-801	Polishing of the Vertical-Stabilizer Leading Edge
TASK 56-00-00-140-801	Polishing of Windshield and Side Window Frames and the Cabin Window-Surround Structure
TASK 57-40-00-140-801	Polishing of the Wing Leading Edges
TASK 71-11-01-140-801	Polishing of the Inlet Cowl Lipskin

B. Tools and Equipment

REFERENCE	DESIGNATION
Commercially Available	Goggles

**NOTE:** Refer to the BD-700 ILLUSTRATED TOOL AND EQUIPMENT MANUAL to make sure that you use the correct equipment configuration.

C. Consumable Materials

REFERENCE	DESIGNATION	MANUFACTURERS' REFERENCE AND/OR SPECIFICATION
05-175	Gloves, Protective Latex	Commercially Available
05-500	Tape, Masking	Commercially Available

EFFECTIVITY: ALL

REFERENCE	DESIGNATION	MANUFACTURERS' REFERENCE AND/OR SPECIFICATION
05-785	Kit, Protector	Granitize Aviation X-3500 Xzilon Aircraft Exterior Protector Kit
05-786	Protector and Corrosion Inhibitor	Granitize Aviation X-20 Xzilon 3 AECI
05-787	Cloth, Cotton	Granitize Aviation H-32 Cloth
05-788	Cloth, Wiping	DuPont Sontara EC Wipers AC1213WWA
07-012	Alcohol, Isopropyl	Commercially Available
05-790	Pad Applicator	Granitize Aviation H-38X Pad

D. Job Set-Up

Subtask 51-27-08-910-001

- (1) Obey the safety precautions that follow:
  - (a) Obey all the cleaning safety precautions (TASK 12-21-00-910-801).
  - (b) Make sure that the work area is safe.
  - (c) Make sure that the work area has a good flow of clean air.

E. Procedure

**NOTE:** It is recommended to remove condensation and rain from the bright work before it dries, especially in coastal and industrial environments.

Any evidence of corrosion and/or pitting on the bright work must be reported to Bombardier Aerospace, Business Aviation Services, Customer Support Engineering, Montreal, who will then recommend a repair procedure as required.

Subtask 51-27-08-950-001

- (1) Apply masking tape to the area adjacent to the area to be treated.

EFFECTIVITY: ALL
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Subtask 51-27-08-110-001

(2) Apply Xzilon 3 to the bright work surface as follows:

(a) Do the polishing of the bright work surface if necessary as follows:

NOTE: Polishing is required if the surface has not been treated previously with Xzilon 3.

Xzilon 3 must be applied within 12 hours after the completion of the polishing operation.

- 1 If applicable, do the polishing of the horizontal-stabilizer leading edges (TASK 55-10-00-140-801).
- 2 If applicable, do the polishing of the vertical-stabilizer leading edge (TASK 55-30-09-140-801).
- 3 If applicable, do the polishing of windshield and side window frames and the cabin window-surround structure (TASK 56-00-00-140-801).
- 4 If applicable, do the polishing of the wing leading edges (TASK 57-40-00-140-801).
- 5 If applicable, do the polishing of the inlet cowl lipskin (TASK 71-11-01-140-801).
- 6 If applicable, for all other bright work surfaces, do the polishing (TASK 12-21-00-110-808).

(b) Clean the bright work surface as follows:

NOTE: A minimum of three cleaning cycles are necessary to make sure that you remove all the polishing residue.

- 1 With Sontara EC wipers, apply 100% isopropyl alcohol on the surface.
- 2 Remove the polishing residue with Sontara EC wipers.
- 3 Discard the used Sontara EC wipers.
- 4 Repeat steps 1 to 3 a minimum of two times, until all the polishing residue is removed.

EFFECTIVITY: ALL

- (c) Apply Xzilon 3 to the surface as follows:

NOTE: Apply Xzilon 3 at a temperature between 45°F and 90°F (7°C and 32°C) and not in direct sunlight.

Do not apply Xzilon 3 when visible moisture is present on the surface.

Keep the Xzilon 3 container sealed when not in use.

Agitate the bottle lightly (do not shake) to keep solids in solution during the application process.

Apply Xzilon 3 to small surfaces at a time to make sure that the Xzilon 3 will not dry. For the application of Xzilon 3 on the lipskin surface, the surface is divided into 12 specific surface areas (four quadrants containing each three surfaces: inner flank, outer flank and highlight).

- 1 Apply a small quantity of Xzilon 3 to a H-38X applicator pad.
- 2 Apply a thin film of Xzilon 3 to the working surface area.

NOTE: Do not let the Xzilon 3 dry.

NOTE: It is normal to get a small polish residue on the applicator pad when the first coat is applied. This is normal, no cleaning is necessary.

- 3 Immediately wipe and buff the treated area with a H-32 cloth until the wet film is not visible.

NOTE: Rotate the H-32 cloth regularly when absorbency decreases.

If streaking occurs, re-wet the surface with a thin film of Xzilon 3.

- 4 Do steps 1 to 3 again until the entire surface has been treated and make sure that the coating is overlapped between sequential surfaces.
- 5 Let the Xzilon 3 layer cure for 60 minutes.

EFFECTIVITY: ALL

- 6 Do steps 1 to 5 again three times.

NOTE: Four layers are mandatory for maximum protection on polished surfaces.

A 12 hour cure time is mandatory after the final Xzilon 3 layer is applied before flight.

The starting position for each application of a Xzilon 3 layer must be varied. For the application of Xzilon 3 on the lipskin, Index the starting radial location on the lipskin by approximately 15° for each subsequent layer of Xzilon 3.

Subtask 51-27-08-950-002

- (3) Remove the masking tape.

F. Close Out

Subtask 51-27-08-942-001

- (1) Remove all tools, equipment, and unwanted materials from the work area.

EFFECTIVITY: ALL