

## REPAIR KIT E-PROPS CARBON BLADES

The **E-Props repair kit** is used to repair some small epoxy resin chips on the carbon blades. The damaged area has to be maximum 25mm<sup>2</sup> (5mm x 5mm). If the damages are more important, or if the foam is apparent, the repair must be done at E-Props.

If you have any doubts, please send some pictures of the damaged area.

### 1- Kit contents

Kit Double / Bubble Epoxy HARDMAN extra fast setting : 1 part resin + 1 part hardener

Transparent box with black powder (pigments + Nanostrength)

Spatula

Gloves

3 sanding sheets grit : fine / medium / big



### 2- Procedure

Well clean the zone to be repaired. Scratch the defect with a cutter.  
Clean locally the defect with a little acetone (very slightly - not soak).

Bound and protect the zone of the area to be repaired with the paper adhesive tape.

Delicately open the transparent box containing the black powder. Mix the resin and the hardener (both parts of the kit) in the box which contains the black powder.

With the spatula, mix the resin + hardener + black powder until the obtaining of a homogeneous dough.

BE CAREFULL: the work time of this dough is **3 to 5 minutes**. Then it is not usable.

Apply the mixture to the impact. Well make penetrate on the damaged zone. Do not put too much resin because then it will be necessary to sand this surplus.

Let harden **24 hours** in 15°C (longer if T° is less than 15°C, less if T° more than 15°C)

Delicately sand the aera (big grit then medium then fine) to remove the surplus of resin. Use a flat hold, until you find the initial form of the aera.

If you have a polisher, slightly polish the aera.

### **3- Impact of the repair on the balancing**

On a 25mm<sup>2</sup> (5mm x 5mm) damaged aera at 800mm of the axis, a resin thickness of 0,5 mm (worst case of a repair) would represent an unbalanced of 0,01 gr.m, what is negligible.

For example : the Rotax tolerance is 0,5 gr.m, the E-PROPS toterance is 0,25 gr.m.

### **4- For any question :**

Helices E-Props ZA Aerodrome 04200 VAUMEILH France

Phone : +33 4 92 34 00 00

Email : helices@e-props.fr

Website : www.e-props.fr