

# MAINTENANCE ENGINEERING ORDER

(AMCOM Reg 750- 2 )

MEO NO. A6340

DATE OCT 1 2010

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### TITLE

Plastic Media Blasting (PMB) for Removal of Organic Coatings from Army Aircraft

### TOLERANCES

Unless otherwise noted, dimensions are in inches and tolerances are:

Fractional.....+/- 1/32

Decimal .....+/- .010

Angular .....+/- 1/2 degrees

### APPLICABILITY

ALMD, Ft. Campbell, KY

### CSI Critical Characteristic Affected ?

NO

### Impact Statement attached :

NO

### REFERENCES FOR RDECOM USE ONLY

### DATE

### DOCUMENT(S) AFFECTED

AGENX

PA

MEO A1116D

24 Jul 2008

### DOCUMENT CHANGE IS NOT REQUIRED

### PURPOSE OR PROBLEM

To authorize plastic media blasting (PMB) for removal of organic coatings from metal and composite airframe parts.

### PROJECT ENGINEER

LEMONS.CLAR  
K.D.1230978006

Digitally signed by LEMONS.CLAR.K.D.1230978006  
DN: cn=US, o=U.S. Government, ou=DoD, ou=PKI,  
ou=USA, cn=LEMONS.CLAR.K.D.1230978006  
Date: 2010.09.22 10:10:47 -0500

Clark Lemons LE Fort Campbell

### ENGINEERING REVIEW



Ron Horn ,Airframe Engineering TM LDR

### ENGINEERING RELEASE



Jim Shames, Branch Chief

1. Ft. Campbell, KY, ALMD, is authorized to deviate from TM 1-1500-344-23-2, paragraph 4-6.4.2.c. Coating removal using the PMB method may be used on metals and composite surfaces. This authorization is for the ALMD walk-in PMB facility only, and is not applicable for cabinet type equipment.

2. Authorized composite surfaces for which PMB may be utilized includes fiberglass, carbon fiber, boron and graphite epoxy, and Kevlar.

3. Performance will be IAW MEO A1116D, General Specification for Removing Organic Coatings from Army Aircraft using Plastic Media Blasting (PMB), with the following deviations:

a. Classification: The PMB media used will be US Technology Corporation, Magic® II Composite Blast Media.

b. The requirement for magnetic floor panels in the recovery system is waived.

c. The requirement for flashing safety warning lights to illuminate during PMB operation, located outside all PMB room doors, is waived. The ALMD facility utilizes a local safety approved auto shut-off system on all PMB room doors, which shuts down the shop air system - not the breathing air.

d. The requirement for a closed-head, wet/dry automatic sprinkler system in each room and enclosure is waived. Local safety requires the sprinkler system to be in the building, not in the booth. Local requirements are met.

e. The mapping procedure will not be used at this time. The media blasting parameters, Table I, will be followed. A restrictive 15 psi maximum will be applicable for all surfaces. Mapping is being developed, will be demonstrated, and the media blasting parameters further developed. When this has been verified, a revision to this MEO will be written to instate the mapping requirement and to reflect the new developed blasting parameters.

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f. The disposal guidelines are not applicable. Ft. Campbell, KY, ALMD utilizes the recycling services of US Technology Corporation.

4. All facilities, training, regulatory (federal, state, and local), safety, and certification requirements are the responsibility of ALMD, Ft. Campbell, KY.

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**TABLE I, MEDIA BLASTING (PMB) PARAMETERS**

(a) Material Thickness (inches)	(b) Supported/ Unsupported (Note 1)	(c) Air Pressure (psi) (Note 2)	(d) Media Flow Rate (LB/HR) (Note 3)	(e) Standoff Distance (inches)	(f) Impinge-ment Angle (deg)	(h) Dwell Time (seconds)	
<b>BARE ALUMINUM</b>							
> 0.031	Supported	10-15	450-600	6-18	0-90	≤ 1	
> 0.031	Unsupported	10-15	450-600	6-18	0-90	≤ 1	
<b>AL CLAD ALUMINUM SUBSTRATES</b>							
> 0.031	Supported	10-15	450-600	6-18	0-90	≤ 1	
> 0.031	Unsupported	10-15	450-600	6-18	0-90	≤ 1	
<b>THIN SKINS</b>							
0.010-0.031	Supported	10-15	450-600	6-18	0-90	≤ 1	
0.010-0.031	Unsupported	10-15	450-600	6-18	0-90	≤ 1	
<b>COMPOSITE SUBSTRATES (Note 4)</b>							
All	Supported	10-15	450-600	6-18	0-90	≤ 1	
All	Unsupported	10-15	450-600	6-18	0-90	≤ 1	
<b>Notes:</b>	1. Unsupported- No backing structure for surface being treated.						
	2. Taken at a 45 degree angle away from linear flow of the media using a hypodermic needle gauge.						
	3. All parameters based on a 1/2", 3/8" Double Venturi nozzle, or Flat nozzle.						
	4. Pressure determined by starting at 10 psi, increasing to no more than 15 psi.						

RDMR-AEM

**MEMORANDUM FOR RECORD:**

**SUBJECT:** Impact of AED Maintenance Engineering Order (MEO) A6340 on maintenance using MEO A1116D, dated, affecting system: ALL

1. Enclosed MEO A6340 will be issued by this office and is provided as part of our Technical Data user support mission. This MEO may impact maintenance contracts or repair parts acquisition decisions.

2. **OVERALL IMPACT:** No Significant Airworthiness Impact-Implement per standard procedures

**3. CLASSIFICATION:**

- New/Revised Procedure/Process
- Technical Requirement Clarification
- Suggestion Study/Test Results
- Parts Marking Implementation/Update
- MEO Review (Chg./Rev. Driven)
- Illustrated Parts Breakdown(IPB) Change
- Repairable Bill of Materials(RBOM) Impact
- Critical Safety Item(CSI) Review
- Environmental Review
- Other

**4. Critical Characteristic(s) Affected:**

- Dimension/Tolerance
- Finish/Material
- Process/Procedure
- None

**5. Readiness Impact:**

- Testing Required
- Special Tooling
- Special Process
- Part/Material Logistics Impact
- Inspection(s) Required
- None

**6. MATERIAL IMPACT:**

More	Less	None	Unknown	Cost/Usage
<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Labor/Processing
<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Parts/Materials Affected:

**7. Comments:**

Implements PMB process at Fort Campbell

**8. Point of contact for this action is**

Clark Lemons, 270-798-7966 DSN 635-7966

*Clark Lemons*