



DOA - No. EASA.21J.020	Service Letter SL 32-2	Revision 1
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**Performance of Minor Infield Repairs of the Natural Composite MT-Propeller Blades
during the Operation Time Between Overhaul Periods**

Affected Propellers

All MT-; MTE- and MTV- Propellers with Natural Composite Blades

1. Background:

During the operation time between overhaul periods it is sometimes necessary to perform minor infield repairs of the natural composite MT-Propeller blades.

The larger areas of repair defined in this SL32-2, as compared to the owner/operator areas of repair allowed by SL32, are allowed to be performed by MT certified overhaul service centers or personnel approved by the MT service center on behalf of the manufacturer.

The extended areas described in this document **increase** the repair **size** limitations from Service Letter 32 chapters

- 2.5 Trailing Edge Damage
- 2.6 Blade Surface Damage
- 2.7 Blade Tip Damage

2. Extended repair limits

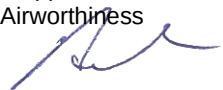
The extension of repair limits consists of three areas A to C which are shown in figure 1 and defined as follows:

- **Area A:**
Parallel to the trailing edge, a width of 0.75 in (19mm), 3 in (76mm) to 8 in (203mm) from the blade ferrule
- **Area B:**
Parallel to the trailing edge, a width of 1 in (25mm), 8 in (203mm) from the blade ferrule to the tip of the blade
- **Area C:**
A width of 2 in (51mm) parallel to the blade tip, excluding the area of the erosion sheath.

The Service Letter 32 defines the type and repair methods of damages which are also applicable for this document.

This Service Letter 32-2 extends the damage dimension limitations from Service letter 32 parallel to the blade edge acc. to the areas A to C, see figure 1.

A repair within the extended repair areas can also be performed for multiple damages which have a minimum distance of 6 in (152mm) to each other.

Prepared:  Lara Neitzel	Original Issue: December 21, 2018 Revision 1: March 8, 2024	Checked / Approved: Office of Airworthiness  Martin Albrecht
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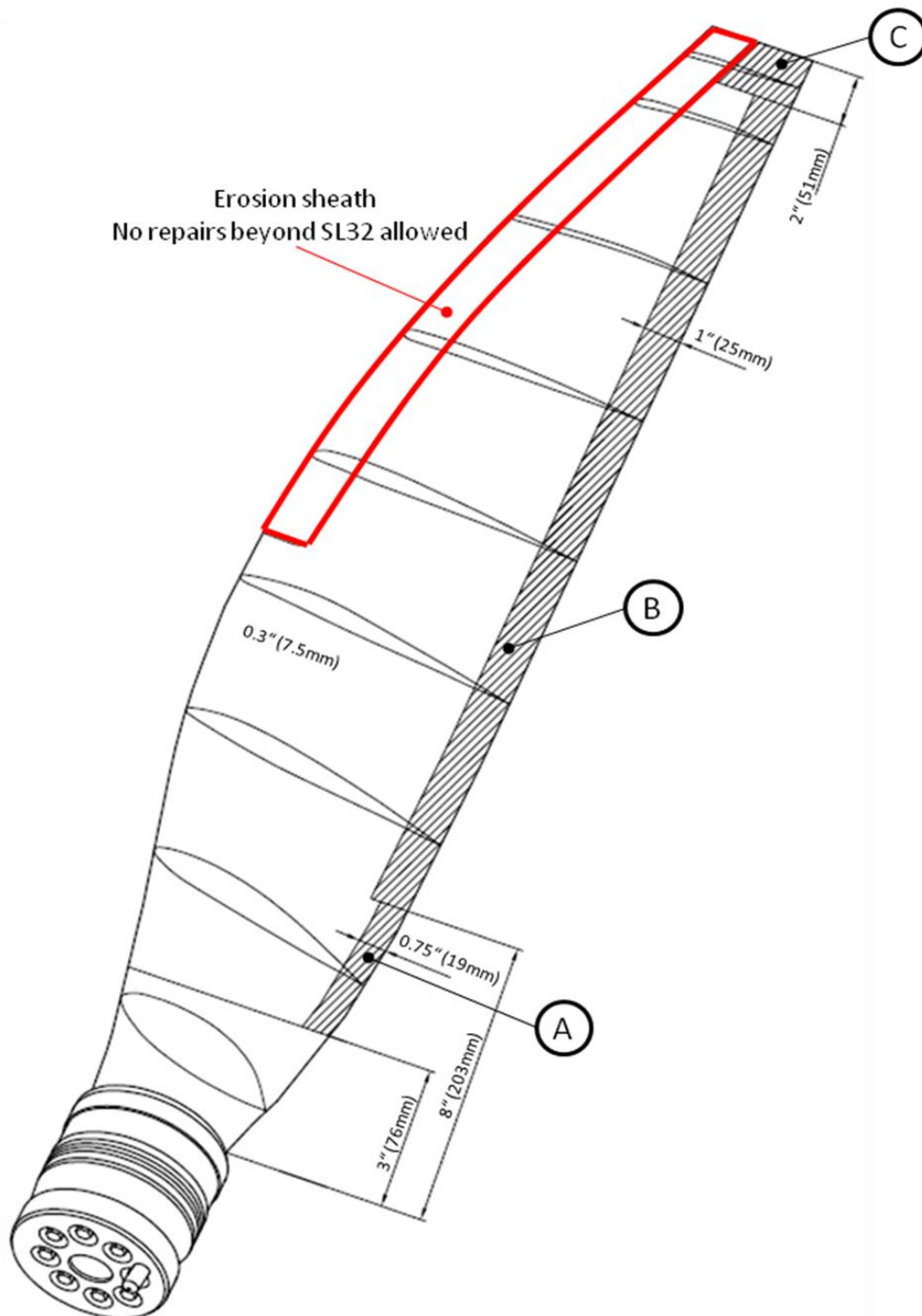
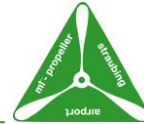


Figure 1: Areas of extended repairs performed by certified overhaul service centers



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List of recommended Materials:**Blade Root-Ferrule Seal**

Silicone Sealant RTV 109 General Electric or similar

Epoxy Resin Materials:

Quick Epoxy: Devcon 14210 (5 Minute Epoxy) or similar

Loctite 0151 Epoxy Patch or similar (Loctite Hysol 3430)

Scheufler: Resin 285 Hardener 500 or similar

Fuller: Resin A20 Hardener B20 (original MT-System)

Epoxy Structural Adhesive: 3M Scotch-Weld™ DP410 Off-White

Epoxy Adhesive: 3M Scotch-Weld™ DP110 Translucent

Epoxy Adhesive: Loctite EA 9330 AERO (known as Hysol EA 9330)

Erosion Sheath (V2A and Nickel) Bonding Epoxy:

EA-9309NA QT System Part A: Epoxy Adhesive; Hysol / Henkel

EA-9309NA QT System Part B: Epoxy Adhesive Hysol / Henkel

EA 9359.3 QT System Part A: Epoxy Adhesive; Hysol / Henkel

EA 9359.3 QT System Part B: Epoxy Adhesive Hysol / Henkel

EC 9323 QT System Part A: Epoxy Adhesive; 3M

EA 9323 QT System Part B: Epoxy Adhesive; 3M

Fiber Glass Material

Fiber Glass Cloth: Interglas Type 92110 Fiber Glass (twill 2/2 163g/m²) or similar

Filler Material:

Reladur 481 PU spraying filler, gray 48PU-7750 or similar

Feycopur 610 PU Priming color

Relonit priming, color grey 61-AC-9000 or similar