



	Service Letter SL 51 R1	DO - No. EASA.21J.020
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Installation of Protective Erosion Tape on De-Ice Boots

Affected Aircraft: DO228 series / SA-227-AT/-AC/-BC/-TT/ SA-226-TB / Metro 3 / Merlin 4 / PA-42 1000 / Jetstream 31/32

Affected Propeller: MTV-27-1-E-C-F-R(G)/CFRL250-55b / CFR/L250-103

Required Material:

1. 3M Erosion Tape
2. 3M Adhesive Promoter

Part No:

- 8672 (2 in width)
- Promoter 86, Optional

Expandable Material:

Clean Lint-Free Cloths
Cleaning Solvents, MEK, Toluene or Isopropyl Alcohol

Note:

Application of erosion tape must be performed at or above 16° C (60°F).

Hands must be kept clean at all times!

1. In case the optional promoter is applied, use a tape to mask the area where the erosion tape is installed to apply the promoter.
2. Cut pieces of 490 mm (19,3 inch) lengths of protective erosion tape.
Radius the corners to (12.7 mm ½ inch) to prevent any sharp corners from remaining.
3. Measure and mark a centerline lengthwise on the non-adhesive side of the erosion tape sections using a ball point pen. This will assist in positioning the tape during installation.
4. Clean the de-ice boot surfaces thoroughly with a clean cloth saturated with solvent (MEK, Toluene or Isopropyl Alcohol). Clean the application area, immediately wiping dry with a lint-free cloth. Allow to dry. Repeat cleaning and drying of the application area. **It is imperative that the de-ice boot be completely clean!** Do not allow solvent to come in contact with the de-ice boot edge seal!
5. Apply optional Promoter 86 adhesive to the propeller blade:

Note: Promoter 86 will increase the adhesive strength between the erosion tape and the de-ice boot.

 - a) Apply a thin of Promoter 86 to the bonding surface. Use only a minimum amount that will fully coat the contact surface. Remove plastic tape used to mask off the perimeter area.
 - b) Allow the promoter to air dry for no less than 15 minutes, and no more than 60 minutes at room temperature.
 - c) Apply 3M Tape 8672 on the de-ice boot.

Note: The promoter will begin to lose effective adhesion after 60 minutes at room temperature.

Check/Approved by MPL Martin Albrecht Date: March 17, 2016	Issued by: Andreas Seperant Date: March 17, 2016	Page No 1 of 1
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