

## **VENDOR SERVICE INFORMATION LETTER**

**SUBJECT:** 3M Adhesive Used to Install Goodrich Pneumatic and Electrothermal De-icers/Components

**APPLICABILITY:** All aircraft equipped with pneumatic and/or electrothermal de-icers and/or other elastomeric components manufactured by Goodrich Sensors and Integrated Systems—Ohio (SIS-Ohio), which were installed and/or repaired on or after September 2009 with a “Toluene free” 3M adhesive.

### 1. Purpose

- A. The purpose of this Service Information Letter is to inform owner/operators not to use “Toluene free” 3M Scotch-Weld™ Contact Rubber Adhesive 1300 L to bond Goodrich pneumatic and/or electrothermal de-icers and/or other elastomeric components to aircraft surfaces.

### 2. Background

- A. 3M Industrial Adhesives and Tapes Division (IATD) Europe has released a “Toluene free” Scotch-Weld™ Contact Rubber Adhesive 1300 L to certain markets since September, 2009. (For identification, see Figure 1.)
- B. The “Toluene free” 1300 L adhesive is a different formulation than the 3M Scotch-Weld™ Neoprene High Performance Rubber and Gasket Adhesive 1300L that is Goodrich SIS-Ohio tested and approved for installation of pneumatic and electrothermal de-icers and other Goodrich elastomeric components.
- C. The Swiss company, RUAG Aerospace, has issued Service Information Letter SI-228-085, dated November 15, 2010, which states that the “Toluene free” 1300 L “*was tested and achieved significant lower adhesive strength for bonding*”. The SIL further states that “*RUAG mandates to follow the approved SRM Repair Instructions using only the approved adhesive 3M Scotch-Weld™ 1300L with Toluene*”.
- D. Goodrich SIS-Ohio has not tested or approved the 3M “Toluene free” 1300 L adhesive.
- E. In 2009, 3M also published a document stating that trials of the “Toluene free” 1300 L showed some “*lower evaporation rates and some minor lower adhesion*”.
- F. Currently, the “Toluene free” 3M Scotch-Weld™ Contact Rubber Adhesive 1300 L container is identified with a red square to the right of the Scotch-Weld™ name. Text inside the red square identifies the product as “Toluene Free” (see Figure 1).



Figure 1. Differences in Product Labeling

### 3. Description

- A. Toluene free” 3M Scotch-Weld™ Contact Rubber Adhesive 1300 L has not been tested by Goodrich SIS-Ohio and is not recommended for use with Goodrich components. Use only the approved adhesives listed in paragraph 4B(1), below, or called out in Goodrich installation, maintenance, and repair documentation.

### 4. Action

- A. 3M USA still produces Scotch-Weld™ Neoprene High Performance Rubber and Gasket Adhesive 1300L with Toluene.

- B. Goodrich recommends that customers purchase the 3M Scotch-Weld™ Neoprene High Performance Rubber and Gasket Adhesive 1300L with Toluene from their distributor of choice.

(1) Goodrich Approved Products List

<u>3M Stock No.</u>	<u>Description</u>
62-1403-6543-8	3M Scotch-Grip™ Rubber And Gasket Adhesive EC-1300L, Yellow, 1 qt, 12 per case
62-1403-7530-4	3M Scotch-Weld™ Neoprene High Performance Rubber and Gasket Adhesive 1300L Yellow, 1 gal, 4 per case
62-1403-8531-1	3M Scotch-Weld™ Neoprene High Performance Rubber and Gasket Adhesive 1300L Yellow, 5 gal pail Pour Spout, 1 per case
62-1403-9530-2	3M Scotch-Weld™ Neoprene High Performance Rubber and Gasket Adhesive 1300L Yellow, 55 gal (54) Agit Drum, 1 per case
62-1403-6530-5	3M Scotch-Weld™ Neoprene High Performance Rubber and Gasket Adhesive 1300L Yellow, 1 qt, 12 per case
62-1403-6535-4	3M Scotch-Weld™ Neoprene High Performance Rubber and Gasket Adhesive 1300L, 1 qt Sample, 1 per case