

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