

ACCEPTANCE CATALOG

ELLE® Shells Acceptance Catalog Installation

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1. General Information

1.1 Change Description

The table below describes changes compared to the previous revision of the document.

Section	Change Description
Version 6.0	
All	New layout text and photo/sketches side by side.
1.4	Scope section added.
2.1	Remove text at the left side of the first image (Profile drawing).
2.1	Remove: ELLE® Straight Example.
2.1	Remove: ELLE® Transition Example.
2.2	Remove all text below the image (profile drawing) & Editorial text changes.
2.7	Remove the first 4 text lines in this section.
2.7	Remove: “..of more than 0,5 mm in height.” Located in the 1 st Line of the text section.
2.7.1	Headline removed and text moved to section 2.8.
2.10	Minor text change and only one photo left for illustration.
All	New template. (Version 5.0) Text and pictures reorganized.

1.2 Printing

If this document is printed it must be printed in color to ensure that the color-marked zones appear correctly.

1.3 Abbreviations and Terms

The table below defines the abbreviations and terms used in this document.

Abbreviation / Term	Change Description
ELLE®	Everlasting Leading Edge
LE	Leading Edge
PSA	Pressure-sensitive tape

1.4 Scope

The acceptance catalog for ELLE® Shells defines a set of requirements necessary to ensure the quality of the installation and thereby the performance of the product.

This document outlines the key acceptance criteria for the ELLE® Shells following installation and highlights critical aspects to be observed during the installation process. Factors that may affect installation quality and product performance are covered in this document.

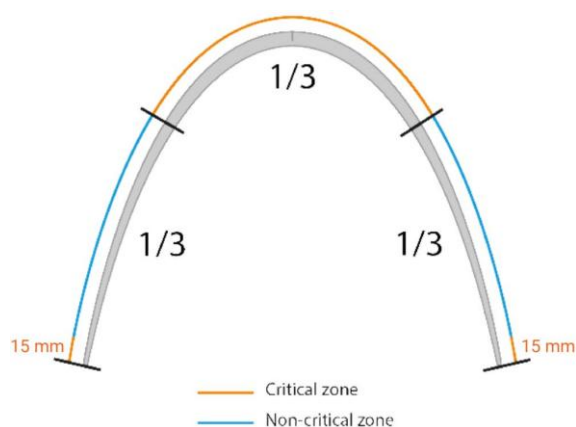
By adhering to the contents of this acceptance catalog, the best performance of ELLE® Shells is achieved.

2. Acceptance Criteria

All the following acceptance criteria must be evaluated individually; there is no combination factor.

2.1 Critical Zone of ELLE®

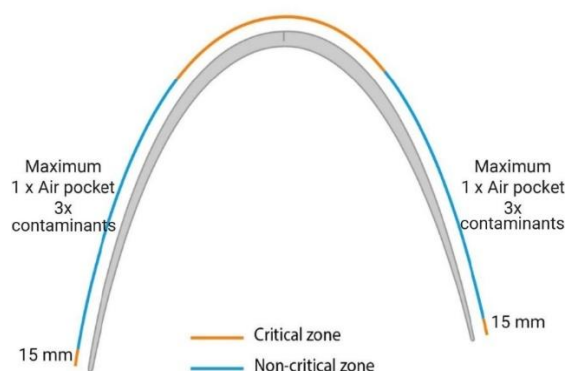
The critical zone is 1/3 of the arc length of ELLE® and 15 mm at the edge of ELLE®.
 The figure shows examples of the critical zone.



2.2 Air Pockets and Contaminants under ELLE®

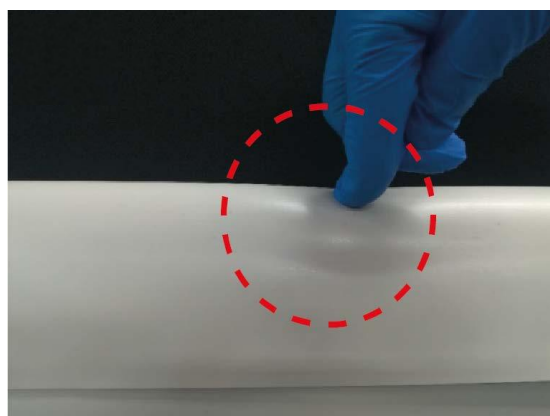
A maximum of 1 air pocket of Ø10 mm and 1 mm in height is allowed on each side of ELLE® in non-critical areas if they cannot be removed.
 A maximum of 3 small contaminations less than 1 mm in height are allowed for each side of the LE of ELLE® in non-critical areas if these cannot be removed.

If PSA has been activated and is damaged during the reposition, the ELLE® shells can be reattached in accordance with *LE-I003 Repair of Detached ELLE®* or be replaced by a new one.
 The figure shows the allowed air pocket and contaminants.

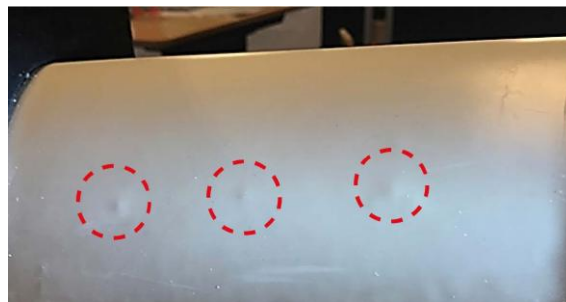


Keep ELLE® in original packaging until use to avoid contamination

Before sealing of ELLE®, Polytech recommends that the quality of the installation is ensured and documented. All air pockets or contaminants, such as sand grain, dirt, a bug and so on, under ELLE® in the critical zone must be removed before application of sealant. If an air pocket is found during installation, the shell must be lifted and the air entrapment must be removed by gently pressing ELLE® from LE to edge of shell.



If an error is found, check whether it is encapsulated air or contamination/irregularity under ELLE®. Use a finger to press the affected area and compare it to non-affected areas. An air pocket will be compressible while a contamination/irregularity under ELLE® will not be compressible. In poor lightning conditions, a flashlight can be used to check the quality of the installation.

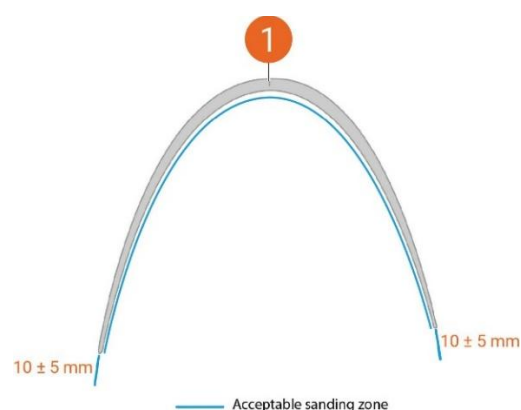


2.3 Sanding Tolerance

Sanding must be done under ELLE® and 10 ± 5 mm from the edge of ELLE®.

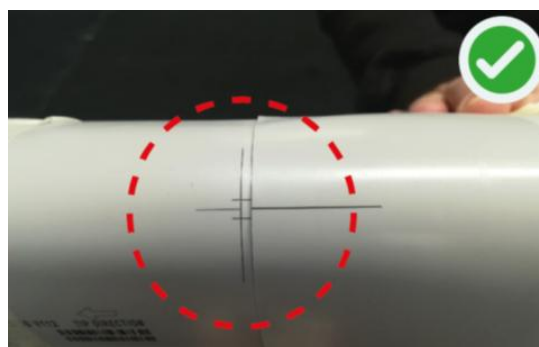
The figure shows the acceptable sanding zone.

(1) Leading edge (reference point).



2.4 Alignment of ELLE®

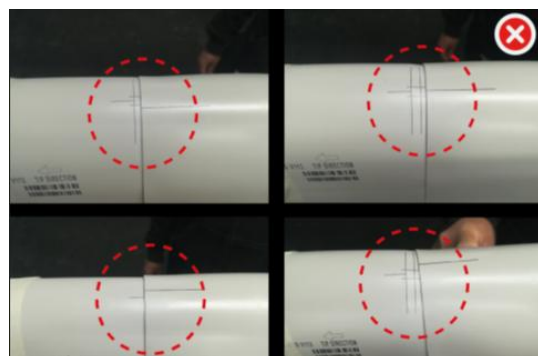
ELLE® must be positioned within the tolerances given by the alignment marks.



If ELLE® is not correctly positioned it must be repositioned.

ELLE® can be repositioned if PSA has not been activated.

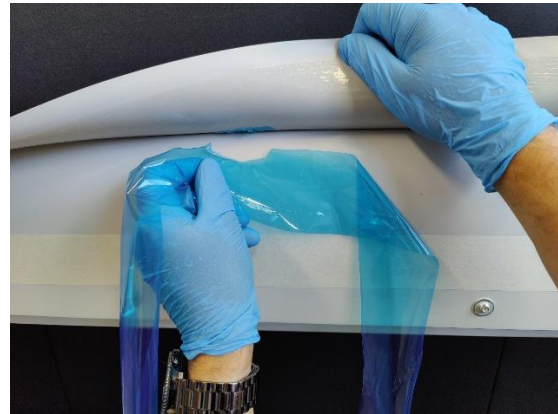
If PSA has been activated and is damaged during the reposition, the ELLE® shells can be reattached in accordance with *LE-I003 Repair of Detached ELLE®* or be replaced by a new one.



2.5 Removal of Liner Under ELLE®

Remaining liner under ELLE® is **not** acceptable.

When removing the liner, ensure that the whole liner comes off. Be aware of rupture of the liner since this indicates the possibility that liner is stuck under the ELLE® shells. If a piece of the liner is missing, it must be found under ELLE® and removed.



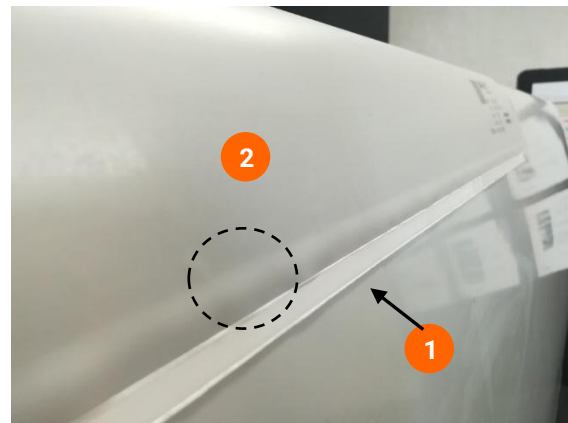
2.6 Edge sealing finish

Edge of sealant towards blade is **not** accepted (1). The edge must be smoothened out under the scraping and afterwards by wiping with isopropanol.

Too much or too little sealant at the edge of ELLE® is **not** accepted.

If too much sealant is applied (2), this must be squeezed out.

If too little sealant is applied, the ELLE® shells will detach from the blade and more sealant must be applied.



2.7 Width of Sealant at Edge of ELLE®

The chamfer must be 10 ± 5 mm from the edge of ELLE®.

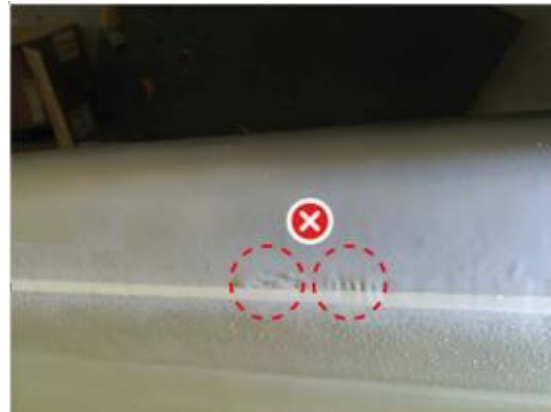


2.8 Wrinkles and Air Pockets at Sealed Edge of ELLE®

Air pockets or wrinkles at the edge of ELLE® is **not** accepted.

If these are present, they must be repaired. If it is not possible to achieve full adhesion to ELLE® after repair, the ELLE® shells in question must be replaced.

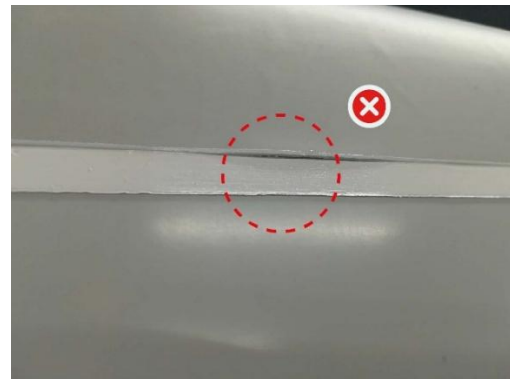
Air pockets located at the sealed edge of ELLE® can be repaired in accordance with instruction *LE-1003 Repair of Detached ELLE®*.



2.9 Voids and Contaminants at Sealed Edge of ELLE®

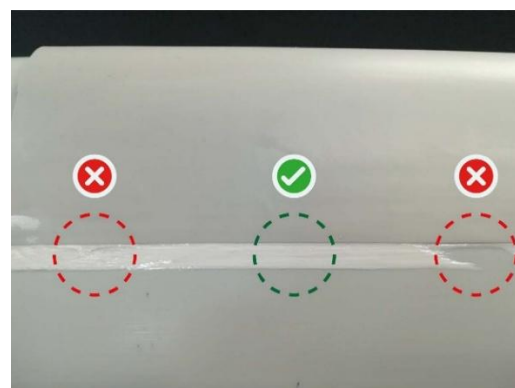
Voids between ELLE® and sealant as well as between sealant and blade are **not** accepted.

Voids must be removed by for example attaching ELLE® onto the sealant by applying more sealant to make sure full adhesion is achieved.



The chamfer of sealant must be even, unbroken and smooth without contaminants.

If contaminants are present, these must be evened out with isopropanol or by applying a little more sealant followed by smoothing. If sealant has been removed under the scraping or smoothing, it must be repaired.



2.10 Cleaning of ELLE® and Blade

ELLE® and blade must be cleaned after application.



Remains of Centaur 960 sealer on ELLE® or blade is **not** accepted.



3. Technical Support

E-mail

support@polytech.com

Answers will be sent within one working day.

Please include the following information in your support request:

- Product name.
- Product type.
- Serial number.
- Description of the problem, including detailed, high-resolution pictures.