

Why Replace, When You Can Repair?

U.S. ARMY
AWR
ISSUED

US Army UH-60/L/V/M Helicopter Rotor Blade Repair Patch

Replacing a single rotor blade can cost upwards of \$200,000* when factoring in materials, labor and downtime.

With 3M™ Polyurethane Protective Tape SJ8542HS, you can repair blades for a fraction of the replacement cost and help extend the life of the part by helping protect against environmental factors such as rain, dust, sand and wind.



Easy to Install In the Field



Helps Reduce Costs



Resistance to Harsh Environments

Protect Blades. Prevent Downtime



3M™ Polyurethane Protective Boot SJ8542HS, FP641, Matte Black, 4 in x 6 in

- Air Worthiness Release (AWR) 2235* issued to authorize the installation of Polyurethane Blade Tape on UH-60L/V/M and HH-60M helicopters
- High strength acrylic adhesive enables aggressive bond to protect rotor blades and against erosion caused by Foreign Object Debris (FOD) such as rain and sand
- Helps prevent surface damage and delamination
- Reliable protection for leading edge metal and composite surfaces

Supporting Materials



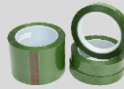
3M™ Adhesion Promoter 86A
A liquid “primer” designed to promote faster initial adhesion to surfaces



3M™ Primer
One-part primer that promotes adhesion of urethane adhesives



3M™ Scotch-Weld™ Repair Paste RP-2110
A two-part urethane repair paste system that cures to an erosion resistant elastomer.



3M™ Polyester Tape 8403
ideal for masking in high temperature applications and adheres well to silicone coated surfaces.



3M™ Scotch-Weld™ EPX Plus II Manual Applicator
Dispenses two-component 3M™ Scotch-Weld™ Structural Adhesives



3M™ Scotch-Weld™ EPX Mixing Nozzle
Provides thorough mixing and precise placement of two-component structural adhesives.



3M™ Protective Tape Application Solution
A pre-mixed, water-based application solution in ready-to-use spray bottles.

Ordering Information

Repair Patch Components

Protective Film

Material Desc.	3M ID	Part No.	Boot No.	Finish/Color	QTY	UOM	NSN No.	GSA Adv.
3M™ Polyurethane Protective Boot SJ8542HS, 4"x6" Pre-cut Roll	7100207048	SJ8542HS	FP641	Matte / Black	8	EA/CS	9390016852501	Pending
3M™ Polyurethane Protective Tape 8542HS, Configurable								
Width Range: 1"-24" (0.5" Increments) Length Range: 36, 72, or 108 yds	7100012231	8542HS	N/A	Matte / Black	1	Roll/CS	7510015997828	No

Supporting Materials

Material Desc.	3M ID	Part No.	QTY	UOM	NSN No.	GSA Adv.
3M™ Primer 08682, Single Step, 30 mL	7100079772	08682	6	EA/CS	8040013613132	Yes
3M™ Adhesion Promoter 86A Transparent, 7 in x 7 in, 5 Pads/Pack	7010290333	86A	100	PAK/CS	6850014484791	Pending
3M™ Scotch-Weld™ Repair Paste RP-2110 48.5 mL	7100160078	RP-2110	6	EA/CS	8030016641100	Yes
3M™ Protective Tape Application Solution: Shipped with (1) one-quart bottle, (1) sprayer head and (1) squeegee	7100069168	56800	1	EA/CS	N/A	Yes
3M™ Polyester Tape 8403, Green, 2 in x 72 yd, 2.4 mil,	7000001173	8403	24	Roll/CS	4940016332376	Yes
3M™ Scotch-Weld™ EPX Plus II Manual Applicator, Universal Plunger, 50 mL	7100148764	EPX PLUS II	10	EA/CS	5120016774494	Yes
3M™ Scotch-Weld™ EPX Mixing Nozzle, Square Green, 1:1 and 2:1, 48.5mL and 50mL	7100104991	NOZ-GR-2:1/1:1	36	EA/CS	6810015440866	Yes

