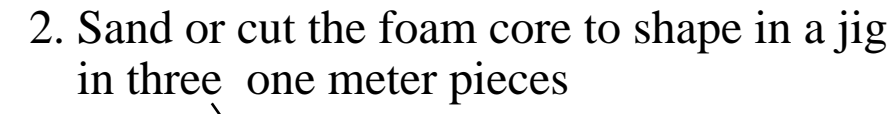
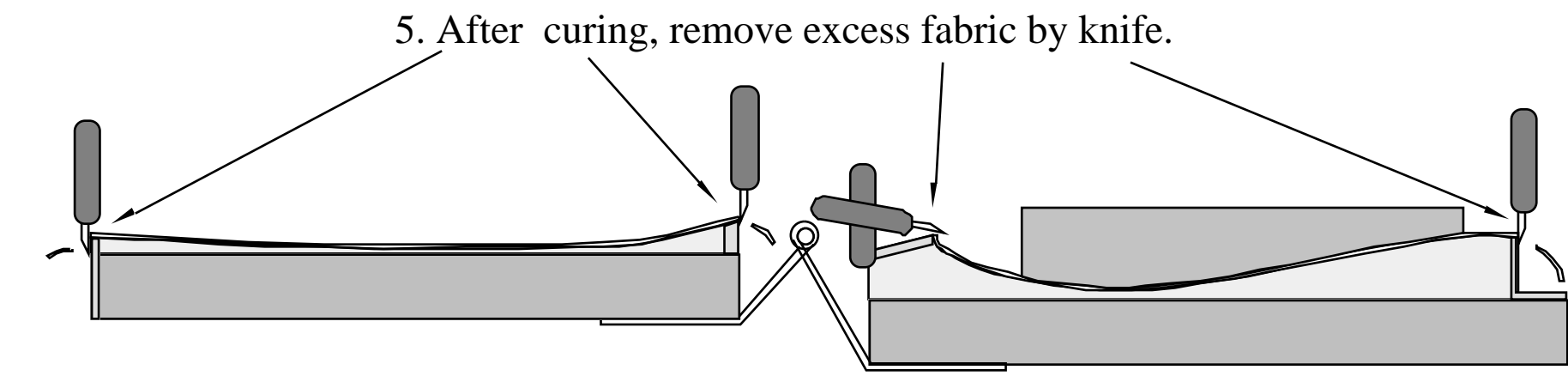


SANDING FIXTURE.



2. Sand or cut the foam core to shape in a jig in three one meter pieces

3. Layup epoxy+glass fabric on both mold halves.
NOTE! See also point 10b.

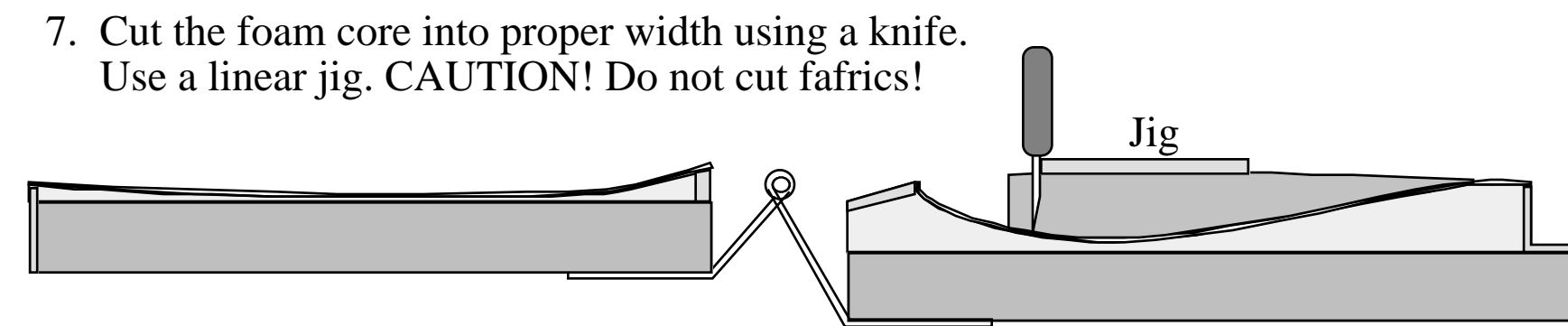


5. After curing, remove excess fabric by knife.

4. Press the foam on the wet fabric for bonding

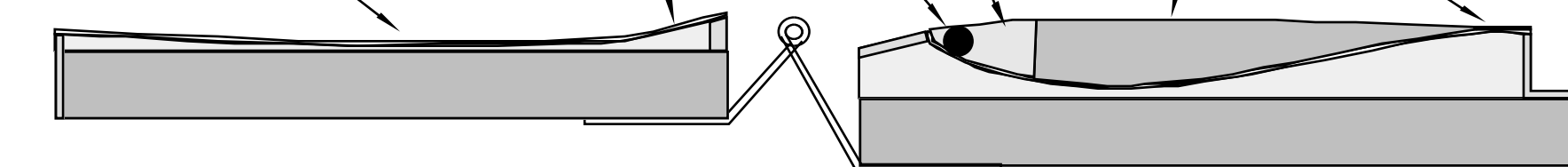
8. Layup the unidirectional rowing onto the leading and trailing edges of the blade.
9. Add the lead weights into the still wet epoxy/unidirectional laminate.
10. Add a layer of epoxy+micro balloons onto all surfaces.

6. Sand the foam core into proper shape using a sanding tool.

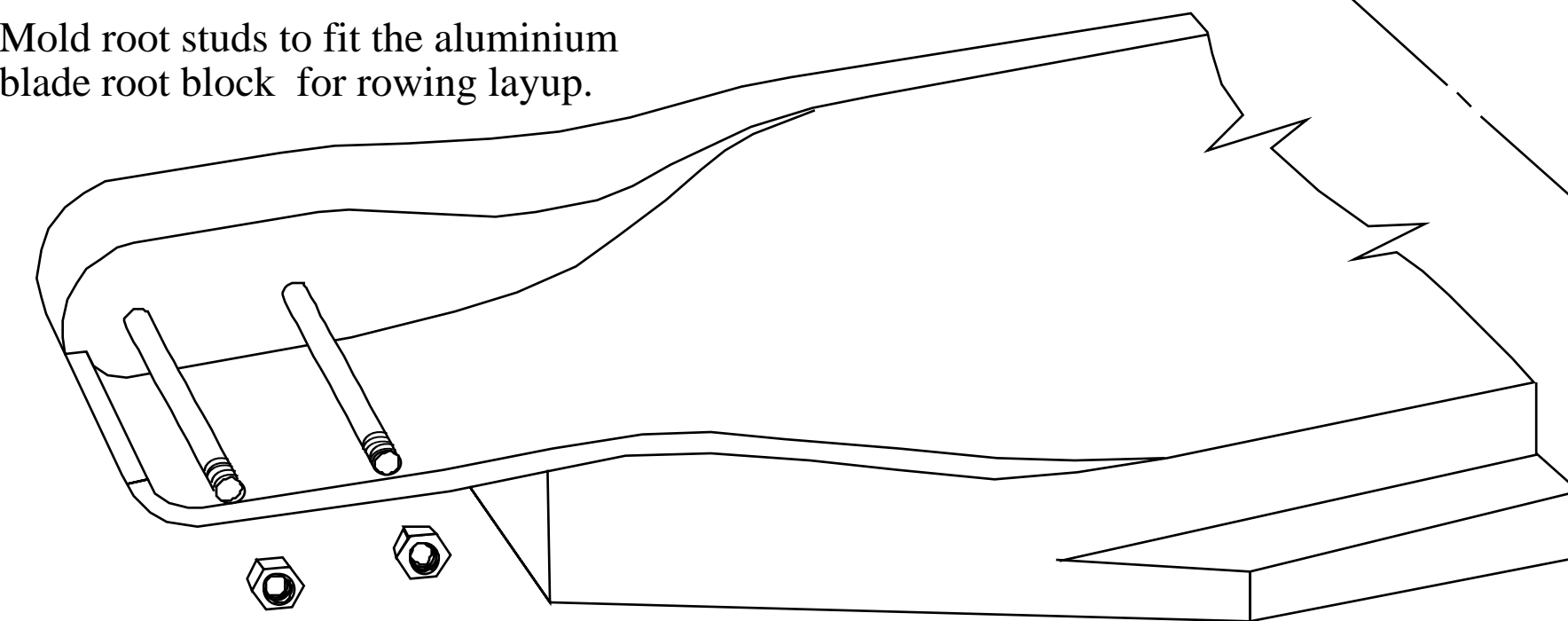


7. Cut the foam core into proper width using a knife. Use a linear jig. CAUTION! Do not cut fabrics!

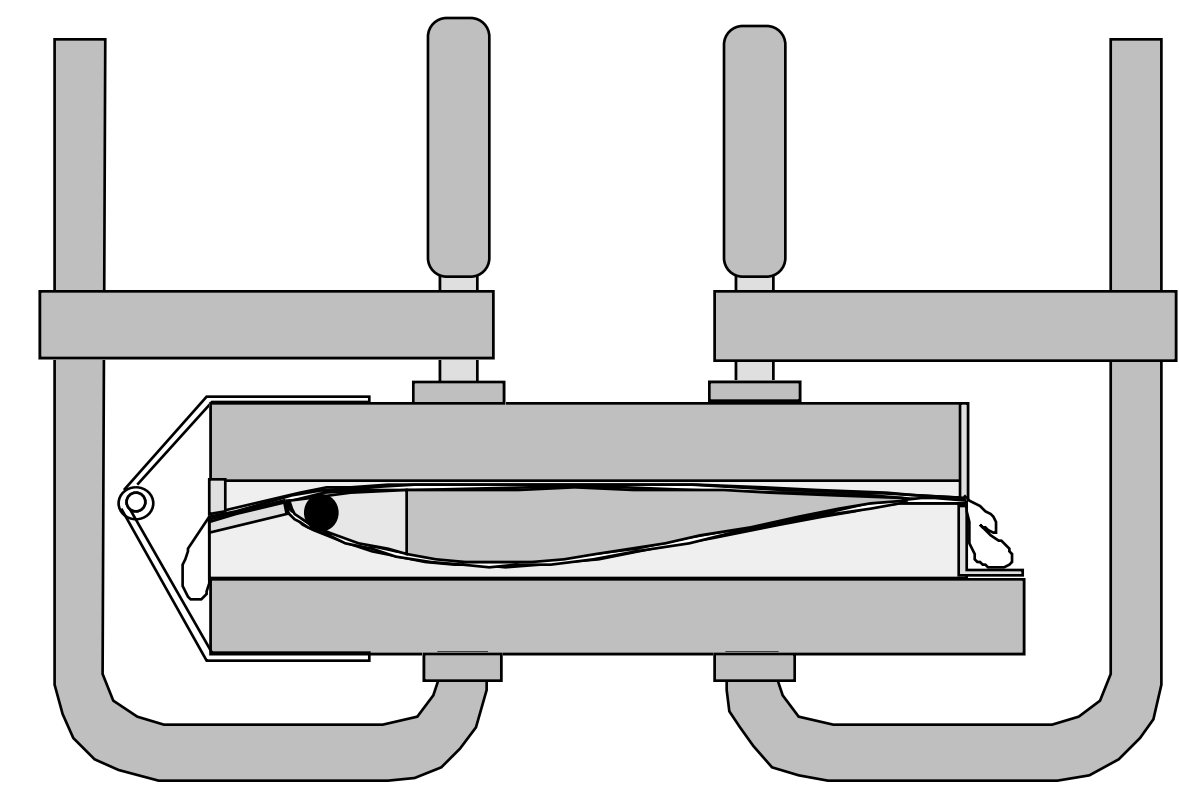
10b. Optional! You can layup the epoxy/fabric on this side at this point instead of point 3. It will result in a better bond. \



Mold root studs to fit the aluminium blade root block for rowing layup.



11. Close and press the mold halves together. The excess epoxy will flow out.



12. After curing remove the blade from the mold. Cut excess fabric and flash by knife and smooth the leading and trailing edges by wet sanding.

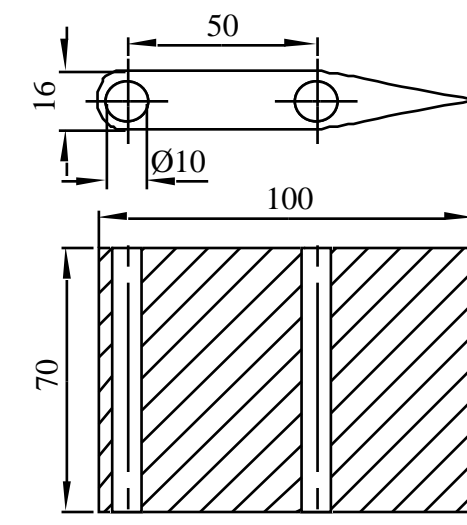
13. Postcure the finished rotor blade in a sturdy jig at an even temperature of 70 degrees Celcius (maximum).



Fiberglass skin layers of bidirectional glass fabric (240 gr/sqm):

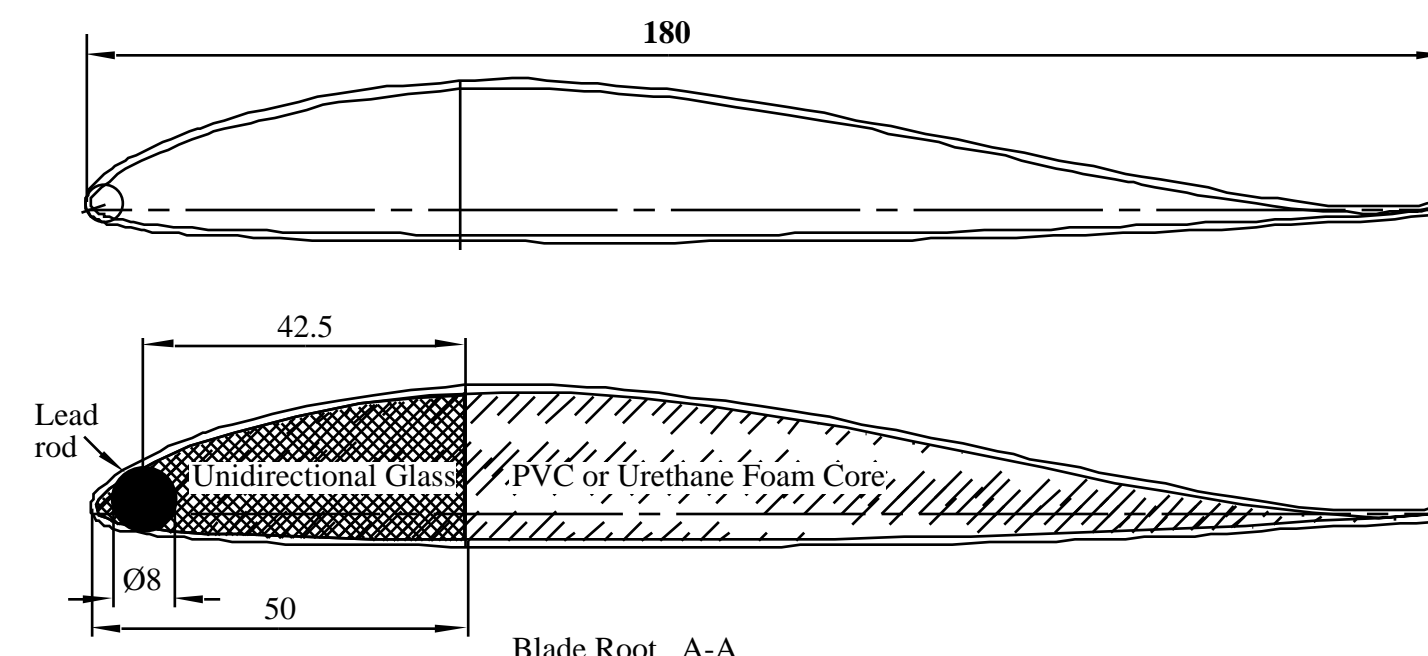
- 1) One full length layer in 0°/90° degree orientation
- 2) One full length layer in 45° degree orientation
- 3) One layer 75 percent length in 45 degree orientation
- 4) One layer 50 percent length in 45 degree orientation
- 5) One layer 25 percent length in 45 degree orientation

Upper Surface (percent)		Lower Surface (percent)	
x	y	x	y
.147	1.229	.853	-.819
.358	1.520	1.142	-.946
.804	2.006	1.696	-1.128
1.980	2.941	3.020	-1.415
4.424	4.312	5.576	-1.736
6.914	5.380	8.086	-1.920
9.427	6.263	10.573	-2.059
14.497	7.626	15.503	-2.242
19.607	8.605	20.393	-2.351
24.754	9.243	25.246	-2.417
29.969	9.533	30.031	-2.455
35.174	9.432	34.826	-2.490
40.292	9.030	39.708	-2.494
45.360	8.420	44.640	-2.476
50.390	7.666	49.610	-2.436
55.387	6.795	54.613	-2.377
60.358	5.846	59.642	-2.290
65.311	4.850	64.689	-2.178
70.250	3.838	69.750	-2.034
75.184	2.838	74.816	-1.860
80.118	1.895	79.882	-1.645
85.060	1.046	84.940	-1.384
90.016	.343	89.984	-1.051
94.995	-.119	95.005	-.629
100.00	0	100.00	0

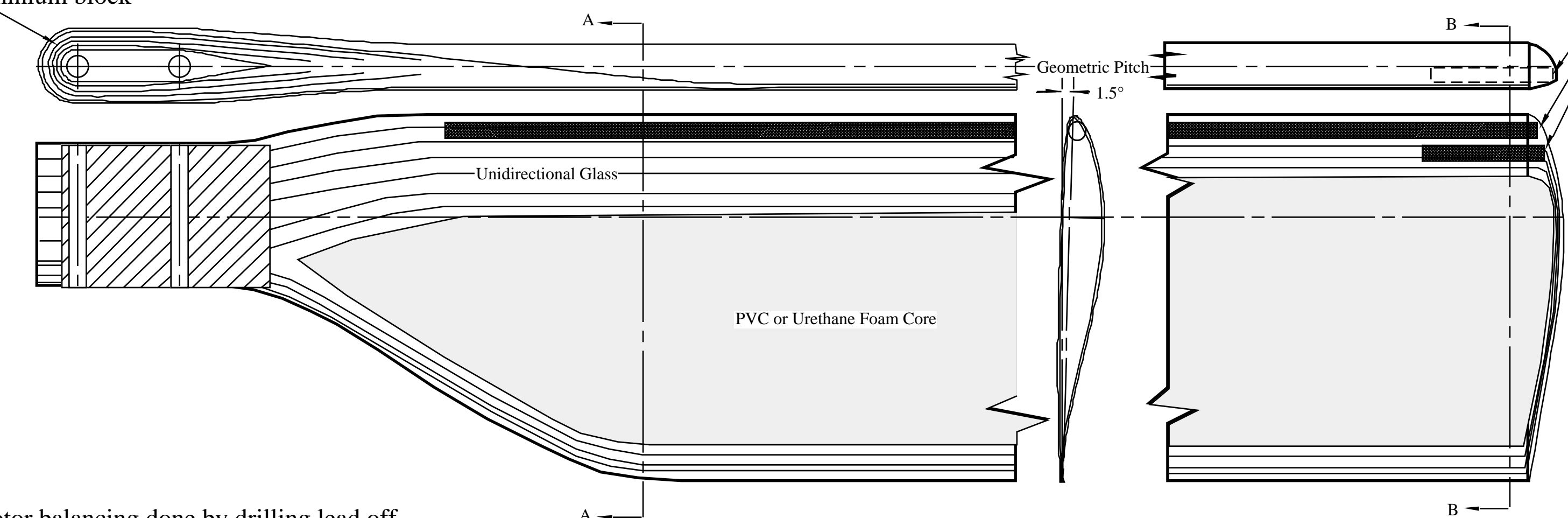
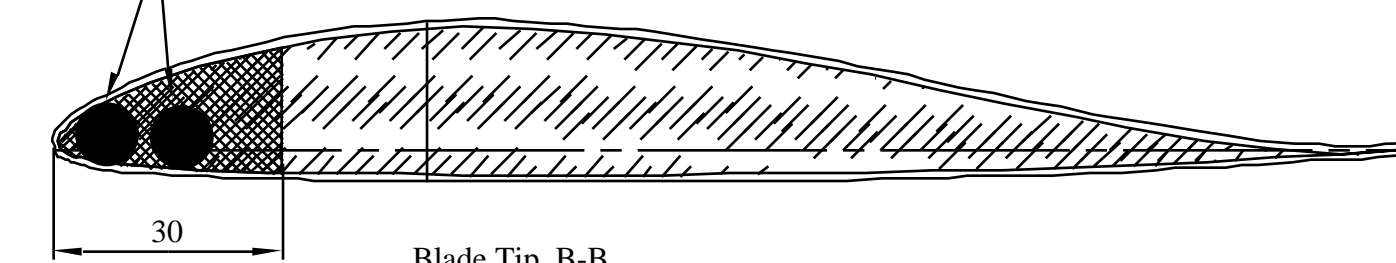


Unidirectional rowing is wound around the blade root aluminium block


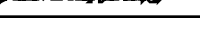
NACA 8-H-12



Rotor balancing done by drilling lead off from the two lead rods at the blade tip.



Rotor balancing done by drilling lead off from the two lead rods at the blade tip.

<p>Tervämäki Engineering</p> <p>Jukka Tervämäki</p> <p>Harmapaadentie 12A</p> <p>00930 Helsinki, Finland</p>		Signature	Date	Version
		<i>Jukka Tervämäki</i>	Feb.10,99	02
<p>AUTOGYRO JT-5B</p> <p>Rotor Blades</p>	<p>Scale</p> <p>1:1 (1:2)</p> <p>(1:5)</p>	Projection	Drawing	
			<p>No:09</p>	

