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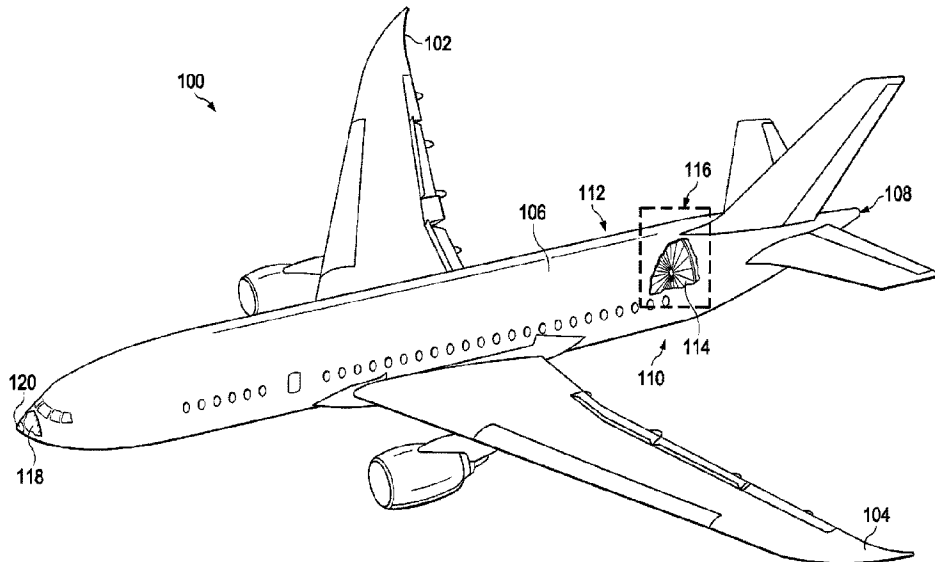
(72) Inventeurs/Inventors:
PETERSON, KRISTOFER L., US;
MILLER, EILEEN E., US;
ULVIN, MARK ALLEN, US;
MCGHEE, RONALD LEROY, US;
LILIENTHAL, DAVID A., US

(73) Propriétaire/Owner:
THE BOEING COMPANY, US

(74) Agent: MARKS & CLERK

(54) Titre : PROCÉDE POUR LE CO-DURCISSEMENT DE RAIDISSEURS PERPENDICULAIRES

(54) Title: METHOD FOR CO-CURING PERPENDICULAR STIFFENERS



(57) Abrégé/Abstract:

A method for fabricating a composite structure is provided. A first number of layers of composite material is laid up to form a first set of stiffeners. A second number of layers of composite material is laid up to form a panel. The first set of stiffeners is associated with a first side of the panel. A precured composite strip is positioned on a second side of the panel, opposite the first side. A third number of layers of composite material is laid up on the second side of the panel to form a second set of stiffeners running perpendicular to the first set of stiffeners. The pre-cured composite lies at an intersection between one of the first set of stiffeners and one of the second set of stiffeners. All the layers of composite material are co-cured to form the composite structure.

ABSTRACT

A method for fabricating a composite structure is provided. A first number of layers of composite material is laid up to
5 form a first set of stiffeners. A second number of layers of composite material is laid up to form a panel. The first set of stiffeners is associated with a first side of the panel. A pre-cured composite strip is positioned on a second side of the panel, opposite the first side. A third number of layers of
10 composite material is laid up on the second side of the panel to form a second set of stiffeners running perpendicular to the first set of stiffeners. The pre-cured composite lies at an intersection between one of the first set of stiffeners and one of the second set of stiffeners. All the layers of composite
15 material are co-cured to form the composite structure.

METHOD FOR CO-CURING PERPENDICULAR STIFFENERS

BACKGROUND INFORMATION

5 1. Field:

[0001] The present disclosure relates generally to manufacturing processes for composite structures. More specifically, the present disclosure relates to a method for co-curing perpendicular stiffeners used in aircraft applications.

10

2. Background:

[0002] Manufacturing an aircraft requires many complex processes. With the increasing use of composite structures for aircraft applications, manufacturers continue to look for ways to decrease the cost and time necessary to manufacture these composite parts.

[0003] Some aircraft parts are made up of multiple composite structures. For example, a bulkhead may be made up of a composite panel and a set of stiffeners on one or both sides. The stiffeners provide structural support for the panel. The number of composite structures used to form the aircraft part, as well as the orientation and thickness of the composite material, may present unique challenges for a manufacturer.

[0004] To form an aircraft part made of multiple composite structures, each component may be individually cured and then fastened together. Other processes co-cure two of the structures and then fasten them to a third part. In still other instances, parts are co-bonded with other parts to form the completed structure. As a result, the part and its components may undergo multiple cure cycles before it is ready to be installed in the aircraft. This process may take more time or be more expensive than desired.

[0005] Therefore, it would be desirable to have a method and apparatus that takes into account at least some of the issues discussed above, as well as other possible issues.

SUMMARY

[0006] An illustrative embodiment of the present disclosure provides a method for fabricating a composite structure. A first number of layers of composite material are laid up to form a first set of stiffeners. A second number of layers of composite material are laid up to form a panel. The first set of stiffeners is associated with a first side of the panel. A third number of layers of composite material are laid up on a second side of the panel, opposite the first side, to form a second set of stiffeners. The second set of stiffeners runs perpendicular to the first set of stiffeners. The first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material are co-cured to form the composite structure.

[0007] Another illustrative embodiment of the present disclosure provides a composite structure for an aircraft comprising a panel, a first set of stiffeners, a second set of stiffeners, and a number of pre-cured composite strips. The panel has a first side and a second side opposite the first side. The first set of stiffeners is associated with the first side of the panel. The second set of stiffeners is associated with the second side of the panel. The second set of stiffeners runs perpendicular to the first set of stiffeners. Each of the number of pre-cured composite strips is positioned at an intersection between one of the first set of stiffeners and one of the second set of stiffeners. The panel, the first set of stiffeners, and the second set of stiffeners are co-cured to form the composite structure.

[0008] Yet another illustrative embodiment of the present disclosure provides a method for fabricating a composite structure for an aircraft. A first number of layers of composite material is laid up to form a first stiffener. A second number of layers of composite material is laid up to form

a panel. The first stiffener is associated with a first side of the panel. A first pre-cured composite strip is positioned on a second side of the panel, opposite the first side. A third number of layers of composite material is laid up on the second side of the panel opposite the first side to form a second stiffener. The second stiffener runs perpendicular to the first stiffener. The first pre-cured composite strip is positioned between the second side of the panel and the second stiffener at an intersection between the first stiffener and the second stiffener. The first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material are co-cured to form the composite structure.

[0008a] Yet another illustrative embodiment of the present disclosure provides a method for fabricating a composite structure, the method comprising: laying up a first number of layers of composite material to form a first set of stiffeners; laying up a second number of layers of composite material to form a panel, wherein the first set of stiffeners is associated with a first side of the panel; laying up a third number of layers of composite material on a second side of the panel opposite the first side to form a second set of stiffeners, wherein the second set of stiffeners runs perpendicular to the first set of stiffeners; positioning a first pre-cured composite strip between a first stiffener in the second set of stiffeners and the second side of the panel; positioning a second pre-cured composite strip between a second stiffener in the first set of stiffeners and the first side of the panel, such that the first pre-cured composite strip and the second pre-cured composite strip have a shape configured to overlap at an intersection between perpendicular stiffeners; and co-curing the first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material to form the composite structure.

[0008b] Yet another illustrative embodiment of the present disclosure provides a composite structure for an aircraft comprising: a panel having a first side and a second side opposite the first side; a first set of stiffeners associated with the first side of the panel; a second set of stiffeners associated with the second side of the panel, wherein the second set of stiffeners runs perpendicular to the first set of stiffeners; and a number of pre-cured composite strips positioned on the panel at an intersection between a first stiffener in the second set of stiffeners and a second stiffener in the first set of stiffeners, wherein the number of pre-cured composite strips comprises a first pre-cured composite strip positioned between the first stiffener in the second set of stiffeners and the second side of the panel and a second pre-cured composite strip positioned between a second stiffener in the first set of stiffeners and the first side of the panel, wherein first pre-cured composite strip and second pre-cured composite strips have a shape configured to overlap at the intersection, and wherein the panel, the first set of stiffeners, and the second set of stiffeners are co-cured to form the composite structure.

[0008c] Yet another illustrative embodiment of the present disclosure provides a method for fabricating a composite structure for an aircraft, the method comprising: laying up a first number of layers of composite material to form a first stiffener; laying up a second number of layers of composite material to form a panel, wherein the first stiffener is associated with a first side of the panel; positioning a first pre-cured composite strip on a second side of the panel, wherein the second side is opposite the first side; laying up a third number of layers of composite material on the second side of the panel to form a second stiffener running perpendicular to the first stiffener, wherein the first pre-cured composite strip is positioned between the second stiffener and the second side of

the panel at an intersection of the first stiffener and the second stiffener; positioning a second pre-cured composite strip between the first stiffener and the first side of the panel, wherein the second pre-cured composite strip is positioned
5 between the first stiffener and the first side of the panel at the intersection of the first stiffener and the second stiffener; and co-curing the first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material to form the
10 composite structure.

[0008d] Yet another illustrative embodiment of the present disclosure provides a method for fabricating a composite structure, the method comprising: laying up a first number of layers of composite material to form a first set of stiffeners;
15 laying up a second number of layers of composite material to form a panel, wherein the first set of stiffeners is associated with a first side of the panel; laying up a third number of layers of composite material on a second side of the panel opposite the first side to form a second set of stiffeners,
20 wherein the second set of stiffeners runs perpendicular to the first set of stiffeners; positioning a first pre-cured composite strip between a first stiffener in the second set of stiffeners and the second side of the panel only at an intersection of the first stiffener in the second set of stiffeners and a second
25 stiffener in the first set of stiffeners; and co-curing the first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material to form the composite structure, wherein the first pre-cured composite strip prevents buckling of the
30 composite structure at the intersection, and wherein the intersection is the geometrical overlap of the first stiffener and the second stiffener with the panel sandwiched in between.

[0008e] Yet another illustrative embodiment of the present disclosure provides a method for fabricating a composite structure for an aircraft, the method comprising: laying up a first number of layers of composite material to form a first stiffener; laying up a second number of layers of composite material to form a panel, wherein the first stiffener is associated with a first side of the panel; positioning a first pre-cured composite strip on a second side of the panel, wherein the second side is opposite the first side; laying up a third number of layers of composite material on the second side of the panel to form a second stiffener running perpendicular to the first stiffener, wherein the first pre-cured composite strip is positioned between the second stiffener and the second side of the panel only at an intersection of the first stiffener and the second stiffener; and co-curing the first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material to form the composite structure, wherein the first pre-cured composite strip prevents buckling of the composite structure at the intersection, and wherein the intersection is the geometrical overlap of the first stiffener and the second stiffener with the panel sandwiched in between.

[0009] The features and functions can be achieved independently in various embodiments of the present disclosure or may be combined in yet other embodiments in which further details can be seen with reference to the following description and drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

[00010] The novel features believed characteristic of the illustrative embodiments are set forth in the appended claims.

5 The illustrative embodiments, however, as well as a preferred mode of use, further objectives and features thereof, will best be understood by reference to the following detailed description of an illustrative embodiment of the present disclosure when read in conjunction with the accompanying drawings, wherein:

10 [00011] **Figure 1** is an illustration of a perspective view of an aircraft in accordance with an illustrative embodiment;

[00012] **Figure 2** is an illustration of a block diagram of a manufacturing environment in accordance with an illustrative embodiment;

15 [00013] **Figure 3** is an illustration of a perspective view of an assembly used to form a composite structure in accordance with an illustrative embodiment;

[00014] **Figure 4A** is an illustration of a cross-sectional view of an assembly used to form a composite structure in accordance with an illustrative embodiment;

20 [00015] **Figure 4B** is an illustration of a cross-sectional view of a formed composite structure in accordance with an illustrative embodiment;

[00016] **Figure 5** is an illustration of an overhead view of a composite structure in accordance with an illustrative embodiment;

25 [00017] **Figure 6** is an illustration of a cross-sectional view of a composite structure in accordance with an illustrative embodiment;

30 [00018] **Figure 7** is an illustration of a flowchart of a process for fabricating a composite structure in accordance with an illustrative embodiment;

[00019] **Figure 8** is an illustration of a flowchart of a process for fabricating a composite structure in accordance with an illustrative embodiment;

5 [00020] **Figure 9** an illustration of a flowchart of a process for installing arrestment fasteners for a composite structure in accordance with an illustrative embodiment;

[00021] **Figure 10** is an illustration of a block diagram of an aircraft manufacturing and service method in accordance with an illustrative embodiment; and

10 [00022] **Figure 11** is an illustration of a block diagram of an aircraft in which an illustrative embodiment may be implemented.

DETAILED DESCRIPTION

[00023] The illustrative embodiments recognize and take into account one or more different considerations. For example, the
5 illustrative embodiments recognize and take into account that the manufacturing process for an aircraft includes fabricating composite structures for use in that aircraft. Some of these composite structures may be complex. For instance, a bulkhead may be comprised of a composite panel and one set of stiffeners
10 on each side. Stiffeners on one side run perpendicularly to stiffeners on the other. In such a case, some currently used techniques require each part to be laid up and cured individually and then fastened together. This process uses multiple autoclave cycles, countless fasteners, and may take
15 more time and resources than desired.

[00024] The illustrative embodiments also recognize and take into account that some currently employed solutions result in a composite part that may not be formed as desired. As an example, when a panel and stiffeners are co-cured, evidence of
20 bowing, delamination, and other undesired effects may be present at the area of overlap. Heavy stiffeners may sink at the intersection. In other words, the stiffeners may not form smoothly, evenly, and in a planar (flat) manner across one side of the panel. The lack of structure, as well as tooling
25 constraints, may limit a manufacturers ability to co-cure composite parts with perpendicular stiffeners.

[00025] The illustrative embodiments further recognize and take into account that inspection of composite parts is desired before placing that composite part in an aircraft. For example,
30 non-destructive inspection may be used to find surface and sub-surface defects within a composite part. In areas where overlap of other structures exists, non-destructive inspection may be difficult or unworkable.

[00026] Thus, the disclosed embodiments relate to method for co-curing perpendicular stiffeners to a common web. A first number of layers of composite material is laid up on a tool to form a panel. A first pre-cured composite strip is positioned
5 on a first side of the panel. A second number of layers of composite material is laid up on the first side of the panel to form a first stiffener. The pre-cured strip sits between the panel and the first stiffener. A third number of layers of composite material is laid up on a second side of the panel,
10 opposite the first side, to form a second stiffener running perpendicular to the first stiffener.

[00027] A number of different tools may be used to maintain the shape of stiffeners on either side of the panel. The first number of layers of composite material, the second number of
15 layers of composite material, and the third number of layers of composite material are co-cured to form the composite structure. The pre-cured strip is co-bonded with the layers of composite material and provides additional structural support while curing. After cure, trim, and inspection, arrestment fasteners
20 are installed at each stiffener intersections, an area that is difficult to inspect (i.e., the no-inspect zone). The disclosed method minimizes the number of cure cycles required to manufacture complex composite panels.

[00028] With reference now to the figures and, in particular,
25 with reference to **Figure 1**, an illustration of an aircraft is depicted in accordance with an illustrative embodiment. In this illustrative example, aircraft **100** has wing **102** and wing **104** attached to fuselage **106**.

[00029] Fuselage **106** has section **108** and section **110**. Skin
30 **112** of fuselage **106** is comprised of a composite material. Aft bulkhead **114** separates section **108** from section **110** in portion **116** of fuselage **106**. Forward pressure bulkhead **118** is located in nose **120** of aircraft **100**.

[00030] Both aft bulkhead **114** and forward pressure bulkhead **118** may be made of composite material. Further, these structures may comprise a panel with stiffeners on each side of the panel, such stiffeners running perpendicular to one another.

5 Aft bulkhead **114** and forward pressure bulkhead **118** may be formed using the process described herein.

[00031] Turning now to **Figure 2**, an illustration of a block diagram of a manufacturing environment is depicted in accordance with an illustrative embodiment. In this illustrative example,
10 manufacturing environment **200** is an example of an environment where composite structure **202** may be manufactured for use in aircraft **204**. Composite structure **202** may then be installed in aircraft **204**.

[00032] As depicted, composite structure **202** may take a number
15 of different forms. For example, without limitation, composite structure **202** may be a bulkhead, a panel, a compartment, a stabilizer, a wheel well, a divider, a skin, or some other suitable structure for use in aircraft **204**. When composite structure **202** is a bulkhead, composite structure **202** may take
20 the form of an aft wheel well bulkhead, an aft nose wheel well bulkhead, a pivot bulkhead, an aft section bulkhead, a forward pressure bulkhead, or some other type of bulkhead.

[00033] Prior to curing, composite structure **202** takes the form of assembly **206**. Assembly **206** is a stackup of layers of
25 composite material laid up on various tools and support structures. Assembly **206** comprises first number of layers of composite material **208**, second number of layers of composite material **210**, and third number of layers of composite material **212**. Each layer of composite material may be the same or a
30 different type of composite material, depending on the particular implementation.

[00034] As used herein, "a number of," when used with reference to items, means one or more items. Thus, a number of

layers of composite material includes one or more layers of composite material.

[00035] Assembly 206 is supported by tool 214 and plurality of rubber mandrels 216. Plurality of rubber mandrels 216 are placed in each channel of each stiffener. Plurality of rubber mandrels 216 is used to maintain the shape of the stiffeners in assembly 206. After stackup, assembly 206 is bagged, placed under vacuum, and positioned within autoclave 218 for curing.

[00036] In this illustrative example, cured composite structure 202 is comprised of panel 220, first set of stiffeners 222, second set of stiffeners 224, number of pre-cured strips 226, and fasteners 228. First number of layers of composite material 208, second number of layers of composite material 210, and third number of layers of composite material 212 were laid up to form first set of stiffeners 222, panel 220, and second set of stiffeners 224, respectively.

[00037] Panel 220 provides the web of composite structure 202. Panel 220 may be substantially planar in these illustrative examples.

[00038] First set of stiffeners 222 and second set of stiffeners 224 are structures configured to provide structural support for panel 220. First set of stiffeners 222 is associated with first side 230 of panel 220. First side 230 of panel 220 may correspond with the tool side of assembly 206 pre-cure.

[00039] Second set of stiffeners 224 is associated with second side 232 of panel 220. Second side 232 of panel 220 may correspond with the bag side of assembly 206 pre-cure. Second set of stiffeners 224 runs perpendicular to first set of stiffeners 222.

[00040] Each stiffener in first set of stiffeners 222 and second set of stiffeners 224 may have the same or different shape. For example, without limitation, any one of the stiffeners may take the form of a hat stiffener, a blade

stiffener, a round stiffener, a j-stiffener, a trapezoidal stiffener, a half-round stiffener, a rectangular stiffener, a round stiffener, and any other suitable type of stiffener. In this illustrative example first set of stiffeners **222** have a similar shape as second set of stiffeners **224**.

[00041] As depicted, first stiffener **234** is one of first set of stiffeners **222**. First stiffener **234** has first flange **236** and second flange **238**, which each run along the length of first stiffener **234**, in parallel and opposite one another. Second stiffener **240** is one of second set of stiffeners **224**. Second stiffener **240** has first flange **242** and second flange **244**, which run along the length of second stiffener **240**, in parallel and opposite one another.

[00042] In this illustrative example, number of pre-cured strips **226** are composite structures previously cured and trimmed. The composite material selected for number of pre-cured strips **226** may be selected from any type of composite material suitable for use in assembly **206**. The type and thickness of number of pre-cured strips **226** may vary depending on the particular implementation.

[00043] Number of pre-cured strips **226** are configured for placement in assembly **206** to provide a desired level of stiffness at certain areas of composite structure **202**. Number of pre-cured strips **226** promote flatness of the different layers of the part during curing.

[00044] As depicted, number of pre-cured strips **226** lay between second set of stiffeners **224** and second side **232** of panel **220**. Number of pre-cured strips **226** may also lay between first set of stiffeners **222** and first side **230** of panel **220**. In other words, number of pre-cured composite strips are sandwiched between two uncured parts in assembly **206** and are co-bonded with those parts during the autoclave cycle.

[00045] Number of pre-cured strips **226** may not be needed on both sides of panel **220** to maintain the desired shape and

stiffness for panel **220** and stiffeners (**222**, **224**) during cure. However, number of pre-cured strips **226** are needed on at least one side of panel **220**.

[00046] As illustrated, first pre-cured composite strip **246**
5 lays between second stiffener **240** and second side **232** of panel **220**. Second pre-cured composite strip **248** lays between first stiffener **234** and first side **230** of panel **220**. First pre-cured composite strip **246** and second pre-cured composite strip **248** provide stiffness for assembly **206** during curing and prevent
10 buckling of assembly **206** at intersection **249** of first stiffener **234** and second stiffener **240**. Intersection **249** is the geometrical overlap of first stiffener **234** and second stiffener **240** with panel **220** sandwiched in between.

[00047] In this illustrative example, first pre-cured
15 composite strip **246** and second pre-cured composite strip **248** may have a shape configured to cover the overlap between perpendicular stiffeners. First pre-cured composite strip **246** and second pre-cured composite strip **248** may run the entire length of second stiffener **240** and first stiffener **234**,
20 respectively. In this manner, first pre-cured composite strip **246** provides support at each intersection between second stiffener **240** and every perpendicular stiffener in first set of stiffeners **222** on the other side of panel **220** that geometrically overlaps with second stiffener **240**.

25 **[00048]** In other illustrative examples, first pre-cured composite strip **246** and second pre-cured composite strip **248** may not run the length of second stiffener **240** and first stiffener **234**, respectively. Instead, the pre-cured strips may provide stiffness at the intersection points on either side of the panel
30 where first stiffener **234** and second stiffener **240** overlap, only. In other words, a pre-cured strip may be segmented. These segments may have gaps between them or may be positioned adjacent to one another where no space is present.

[00049] Any one of number of pre-cured strips **226** may have a square shape, a rectangular shape, and irregular shape, a circular shape, or some other suitable type of shape. Since number of pre-cured strips **226** comprise composite material and
5 are laid up at the same time as the other layers of composite material, the addition of number of pre-cured strips **226** does not substantially increase the weight, complexity, or processing time of composite structure **202**.

[00050] Layers of adhesive **250** adhere number of pre-cured
10 strips **226** to surrounding structures in assembly **206**. In this depicted example, second stiffener **240** and first pre-cured composite strip **246** have first layer of adhesive **252** between the two. First pre-cured composite strip **246** and second side **232** of panel **220** have second layer of adhesive **254** between the two. In
15 a similar fashion, first side **230** of panel **220** and second pre-cured composite strip **248** have third layer of adhesive **256** between the two. Second pre-cured composite strip **248** and first stiffener **234** have fourth layer of adhesive **258** between the two.

[00051] Once assembly **206** is cured in autoclave **218** to form
20 cured composite structure **202**, composite structure **202** is trimmed and inspected. Inspection system **259** is configured to inspect composite structure **202** for defects. For example, without limitation, inspection system **259** may be a non-destructive inspection system. Inspection of panel **220** at
25 intersection **249** of first stiffener **234** and second stiffener **240** may be unworkable. As a result, fasteners **228** are installed such that structural stability of panel **220** in that area is within selected tolerances. Fasteners **228** may be called arrestment fasteners in this illustrative example.

[00052] As depicted, fasteners **228** transect composite
30 structure **202** at various points in the overlap between first stiffener **234** and second stiffener **240**. More specifically, first fastener **260** is installed through first flange **242** of second stiffener **240**, first layer of adhesive **252**, first pre-

cured composite strip **246**, second layer of adhesive **254**, second side **232** of panel **220**, first side **230** of panel **220**, third layer of adhesive **256**, second pre-cured composite strip **248**, fourth layer of adhesive **258** and finally first flange **236** of first stiffener **234**.

[00053] In a similar fashion, second fastener **262** is installed through first flange **242** of second stiffener **240**, through the rest of the structure, and to second flange **238** of first stiffener **234**. Third fastener **264** transects second flange **244** of second stiffener **240**, through the structure, and through first flange **236** of first stiffener **234**. Fourth fastener **266** transects second flange **244** of second stiffener **240**, then through the structure, and finally through second flange **238** of first stiffener **234**.

[00054] Collectively, fasteners **228** secure first stiffener **234**, panel **220**, and second stiffener **240** at intersection **249** such that positive margins are maintained while no non-destructive inspection is performed on the panel where intersecting stringers preclude full coverage. Of course, in other illustrative examples, more or fewer fasteners **228** may be installed at intersection **249**. Fasteners **228** are installed at each intersection between a stiffener in first set of stiffeners **222** and its perpendicular counterparts in second set of stiffeners **224**.

[00055] With the use of an illustrative embodiment, panel **220**, first set of stiffeners **222**, and second set of stiffeners **224** may be cured in a single autoclave cycle. The use of number of pre-cured strips **226** prevents undesired defects, such as bowing, to occur at the intersection of the stiffeners and panel **220**. Panel **220** will remain substantially flat during curing. The use of arrestment fasteners **228** eliminate the need for inspection in the area of overlap.

[00056] The illustrative embodiments described herein reduce manufacturing time and decrease cost to form composite structure

202. Since panel **220**, first set of stiffeners **222**, and second set of stiffeners **224** are all formed at once, the need for drilling and fastening the parts together is substantially reduced. Rework also may be reduced or eliminated.

5 **[00057]** With reference next to **Figure 3**, an illustration of a perspective view of a manufacturing environment is depicted in accordance with an illustrative embodiment. Manufacturing environment **300** is an example of a physical implementation for manufacturing environment **200** shown in block form in **Figure 2**.

10 Components used to form aft bulkhead **114** in portion **116** of aircraft **100** from **Figure 1** are shown.

[00058] As depicted, assembly **302** includes layers of composite material laid up to form panel **304**, first set of stiffeners **306**, and second set of stiffeners **308**. In this illustrative example,
15 second set of stiffeners **308** run perpendicular to first set of stiffeners **306**. Panel **304** has first side **312** and second side **314**.

[00059] Second set of stiffeners **306** includes stiffener **315**, stiffener **316** and stiffener **317**. Stiffener **315** is formed from
20 layers of composite material **318** laid up on mandrel **319**. Stiffener **316** is formed from layers of composite material **320** laid up on mandrel **321**. Stiffener **317** is formed from layers of composite material **322** laid up on mandrel **324**. In this
illustrative example, first stiffener **316** has flange **326** and
25 flange **328**.

[00060] First set of stiffeners **308** include stiffener **330**, stiffener **332**, and stiffener **334**, each formed from layers of composite material. Stiffener **330** has flange **336** and flange **338**.

30 **[00061]** Stiffener **316** on second side **314** of panel **304** intersects with stiffener **330** on first side **312** of panel **304** at section **340**. A pre-cured strip (not shown in this view) is positioned between stiffener **316** and second side **314** of panel **304** prior to curing. In a similar fashion, stiffener **317** and

stiffener **330** also overlap. A pre-cured strip is also placed at that intersection, as well as any additional areas in which a stiffener on one side overlaps a stiffener on the other.

[00062] Turning now to **Figure 4A**, an illustration of a cross-sectional view of an assembly used to form a composite structure is depicted in accordance with an illustrative embodiment. A cross-sectional view of assembly **302** is shown along lines 4-4 in **Figure 3**.

[00063] Pre-cured composite strip **400** has been positioned between layers of composite material **320** and second side **314** of panel **304** at section **340**. Layer of adhesive **402** bonds pre-cured composite strip **400** to layers of composite material **320**. In this illustrative example, adhesive **402** the entire surface of pre-cured composite strip **400**. In other illustrative examples, adhesive **402** may only cover a portion of pre-cured composite strip **400** at the stiffener flanges. Layer of adhesive **404** bonds pre-cured composite strip **400** to panel **304**.

[00064] As illustrated, pre-cured composite strip **406** has been positioned between layers of composite material **408** and first side **312** of panel **304** at section **340**. Layer of adhesive **410** bonds pre-cured composite strip **406** to layers of composite material **408**. Layer of adhesive **412** bonds pre-cured composite strip **406** to panel **304**.

[00065] Both pre-cured composite strip **400** and pre-cured composite strip **406** are examples of physical implementations for one of number of pre-cured strips **226** shown in block form in **Figure 2**.

[00066] **Figure 4B** shows a cross-sectional view of a formed composite structure in accordance with an illustrative embodiment, along lines 4-4 in **Figure 3**. Assembly **302** has been cured and mandrel **321** removed. As shown in this view, panel **304** remains substantially planar and the tooling (mandrels) associated with stiffener **330**, does not cause sagging at section **340**.

[00067] Turning now to **Figure 5**, an illustration of an overhead view of a composite structure is depicted in accordance with an illustrative embodiment. **Figure 5** depicts an overhead view of composite structure **500**. Composite structure **500** represents first set of stiffeners **306**, second set of stiffeners **308**, and panel **304** after curing.

[00068] In this illustrative example, section **340** may contain a no-inspection or "no-scan" zone. Fasteners **502** have been placed in section **340** of composite structure **500**. Specifically, fastener **504**, fastener **506**, fastener **508**, and fastener **510** have been placed in locations **310** where a flange of stiffener **316** overlaps with a flange of stiffener **330**. The installation of arrestment fasteners in these areas provides the desired level of performance notwithstanding the capabilities to inspect.

[00069] Although pre-cured strip **406** is shown running the entire length of stiffener **316** in this illustrative example, in other illustrative example, pre-cured strip **406** may be segmented and localized only to the intersections between stiffener **316** and a perpendicular stiffener on the other side of panel **304**.

[00070] Turning now to **Figure 6**, an illustration of a cross-sectional view of a composite structure is depicted in accordance with an illustrative embodiment. Composite structure **600** is an example of a physical implementation for composite structure **202** shown in block form in **Figure 2**. **Figure 6** shows a different configuration for the bag side stiffener.

[00071] As illustrated, composite structure **600** includes stiffener **602** and stiffener **604**. Stiffener **602** is a blade stiffener in this illustrative example. Stiffener **602** is oriented perpendicularly to stiffener **604**. Composite structure **600** is formed similarly to composite structure **500** shown in **Figure 5**.

[00072] In this illustrative example, only one pre-cured composite strip is used in composite structure **600**. Pre-cured composite strip **606** is positioned between stiffener **602** and

first side **608** of panel **610**. Pre-cured composite strip **606** is surrounded on either side by layer of adhesive **611** and layer of adhesive **612**, respectively. Stiffener **604** is co-cured and attached directly to second side **613** of panel **610**, instead of
5 having a pre-cured strip between the two structures. Fastener **614** and fastener **616** penetrate the flanges of stiffener **602** to stiffener **604**.

[00073] Aircraft **100** in **Figure 1** is only one physical implementation of a platform incorporating composite structure
10 **202** in **Figure 2** having number of pre-cured strips **226**. Although the examples for an illustrative embodiment are described with respect to an aircraft, an illustrative embodiment may be applied to other types of platforms. Composite structure **202** in **Figure 2** may be used in any platform where a bulkhead or other
15 panel with perpendicular stiffeners is desired. The platform may be, for example, a mobile platform, a stationary platform, a land-based structure, an aquatic-based structure, or a space-based structure. More specifically, the platform, may be a surface ship, a tank, a personnel carrier, a train, a
20 spacecraft, a space station, a satellite, a submarine, an automobile, a power plant, a bridge, a dam, a house, a manufacturing facility, a building, or another suitable platform.

[00074] The different components shown in **Figure 1** and **Figures**
25 **3-6** may be combined with components in **Figure 2**, used with components in **Figure 2**, or a combination of the two. Additionally, some of the components in **Figure 1** and **Figures 3-6** may be illustrative examples of how components shown in block form in **Figure 2** may be implemented as physical structures.

30 [00075] Other configurations of assembly **302** may be implemented other than those shown in **Figures 3-5**. For example, pre-cured composite strip **406** and associated layers of adhesive may be absent. In other illustrative examples, additional pre-

cured strips may be used at section **340** on one or both sides of panel **304**.

[00076] Turning next to **Figure 7**, an illustration of a flowchart of a process for fabricating a composite structure is depicted in accordance with an illustrative embodiment. The process described in **Figure 7** may be used to form composite structure **202** for aircraft **204** shown in block form in **Figure 2**.

[00077] The process begins by laying up a first number of layers of composite material on a tool to form a first stiffener (operation **700**). Then, a second number of layers of composite material are laid up to form a panel (operation **702**). The first stiffener is associated with a first side of the panel. Next, a first pre-cured composite strip is positioned on a second side of the panel opposite the first side (operation **704**).

[00078] The process then lays up a third number of layers of composite material on the second side of the panel to form a second stiffener running perpendicular to the first stiffener (operation **706**). The first pre-cured composite strip has been positioned between the second stiffener and the second side of the panel at an intersection between the first stiffener and the second stiffener.

[00079] Thereafter, the process co-cures the first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material to form the composite structure (operation **708**)

[00080] Next, the cured composite structure is trimmed and inspected (operation **710**). The process then installs fasteners at an intersection of the first stiffener and the second stiffener (operation **712**) with the process terminating thereafter.

[00081] In some illustrative examples, the operations described in **Figure 7** may occur in a different order than described herein. Depending on the particular implementation,

an operation may be modified or eliminated to allow flexibility and critical off path work.

[00082] Turning now to **Figure 8**, an illustration of a flowchart of process for fabricating a composite structure is depicted in accordance with an illustrative embodiment. The process depicted in **Figure 8** may be used to position the first pre-cured composite strip in the assembly, as described in operation **704** in **Figure 7**.

[00083] The process begins by selecting a shape and location to position the first pre-cured composite strip (operation **800**). The process then applies a first layer of adhesive at an interface of the first pre-cured composite strip and the second side of the panel (operation **802**). Next, the first pre-cured composite strip is placed on top of the first layer of adhesive (operation **804**).

[00084] The process then applies a second layer of adhesive at an interface of the first pre-cured composite strip and the second stiffener (operation **806**). Operation **804** and operation **806** may occur in reverse order in some applications.

[00085] The process next co-bonds the first pre-cured composite strip with the first stiffener, the second stiffener, and the panel (operation **808**) with the process terminating thereafter. This process may be repeated for each stiffener to ensure even curing and reduce deformations at the overlap between a stiffener on one side of the panel and the corresponding stiffener running parallel on the opposite side of the panel. Additional layers of adhesive may be used. A second pre-cured composite strip may be positioned on the second side of the panel at the intersection of the first stiffener and the second stiffener. The process for positioning and co-bonding remains the same.

[00086] Turning now to **Figure 9**, an illustration of a flowchart of a process for installing arrestment fasteners for a composite structure is depicted in accordance with an

illustrative embodiment. The process depicted in **Figure 9** may be used during operation **712** shown in **Figure 7**. The addition of arrestment fasteners ensures a desired degree of structural stability in hard to inspect areas of the assembly.

5 **[00087]** The process begins by installing a first fastener at an intersection of a first flange of the first stiffener and a first flange of the second stiffener (operation **900**). Next, a second fastener is installed at an intersection of the first flange of the first stiffener and a second flange of the second
10 stiffener (operation **902**).

[00088] The process then installs a third fastener at an intersection of a second flange of the first stiffener and the first flange of the second stiffener (operation **904**). Then, a fourth fastener is installed at an intersection of the second
15 flange of the first stiffener and the second flange of the second stiffener (**906**) with the process terminating thereafter.

[00089] This process may be repeated for each stiffener to ensure structural stability at the overlap between a stiffener on one side of the panel and the corresponding stiffener running
20 perpendicular on the opposite side of the panel.

[00090] The flowcharts and block diagrams in the different depicted illustrative embodiments illustrate the architecture, functionality, and operation of some possible implementations of apparatuses and methods in an illustrative embodiment. In this
25 regard, each block in the flowcharts or block diagrams may represent a module, a segment, a function, and/or a portion of an operation or step.

[00091] Illustrative embodiments of the disclosure may be described in the context of aircraft manufacturing and service
30 method **1000** as shown in **Figure 10** and aircraft **1100** as shown in **Figure 11**. Turning first to **Figure 10**, an illustration of a block diagram of an aircraft manufacturing and service method is depicted in accordance with an illustrative embodiment. During pre-production, aircraft manufacturing and service method **1000**

may include specification and design **1002** of aircraft **1100** in **Figure 11** and material procurement **1004**.

[00092] During production, component and subassembly manufacturing **1006** and system integration **1008** of aircraft **1100**
5 in **Figure 11** takes place. Thereafter, aircraft **1100** in **Figure 11** may go through certification and delivery **1010** to be placed in service **1012**. While in service **1012** by a customer, aircraft **1100** in **Figure 11** is scheduled for routine maintenance and service **1014**, which may include modification, reconfiguration,
10 refurbishment, and other maintenance or service.

[00093] Composite structure **202** from **Figure 2** and the components within composite structure **202** may be made during component and subassembly manufacturing **1006**. In addition, composite structure **202** may be used in parts made for routine
15 maintenance and service **1014** as part of a modification, reconfiguration, or refurbishment of aircraft **1100** in **Figure 11**.

[00094] Each of the processes of aircraft manufacturing and service method **1000** may be performed or carried out by a system integrator, a third party, an operator, or some combination
20 thereof. In these examples, the operator may be a customer. For the purposes of this description, a system integrator may include, without limitation, any number of aircraft manufacturers and major-system subcontractors; a third party may include, without limitation, any number of vendors,
25 subcontractors, and suppliers; and an operator may be an airline, a leasing company, a military entity, a service organization, and so on.

[00095] With reference now to **Figure 11**, an illustration of a block diagram of an aircraft is depicted in which an
30 illustrative embodiment may be implemented. In this example, aircraft **1100** is produced by aircraft manufacturing and service method **1000** in **Figure 10** and may include airframe **1102** with plurality of systems **1104** and interior **1106**. Examples of systems **1104** include one or more of propulsion system **1108**,

electrical system **1110**, hydraulic system **1112**, and environmental system **1114**. Any number of other systems may be included. Although an aerospace example is shown, different illustrative embodiments may be applied to other industries, such as the automotive industry.

[00096] Apparatuses and methods embodied herein may be employed during at least one of the stages of aircraft manufacturing and service method **1000** in **Figure 10**.

[00097] In one illustrative example, components or subassemblies produced in component and subassembly manufacturing **1006** in **Figure 10** may be fabricated or manufactured in a manner similar to components or subassemblies produced while aircraft **1100** is in service **1012** in **Figure 10**. As yet another example, one or more apparatus embodiments, method embodiments, or a combination thereof may be utilized during production stages, such as component and subassembly manufacturing **1006** and system integration **1008** in **Figure 10**. One or more apparatus embodiments, method embodiments, or a combination thereof may be utilized while aircraft **1100** is in service **1012**, during maintenance and service **1014** in **Figure 10**, or both. The use of a number of the different illustrative embodiments may substantially expedite the assembly of aircraft **1100**, reduce the cost of aircraft **1100**, or both expedite the assembly of aircraft **1100** and reduce the cost of aircraft **1100**.

[00098] The illustrative embodiments provide a method for co-curing perpendicular stiffeners and a panel to form a composite structure for use in aircraft. With the use of pre-cured strips at the overlap between a stiffener on one side of the panel and a stiffener on the other, manufacturers can attain the desired level of stability, ensure structural integrity at the overlap, and decrease manufacturing time of complex composite parts. Stiffeners no longer need to be fastened to the web of the composite structure. As a result, the use of some manufacturing

process may be reduced or eliminated, saving both time and money for the manufacturer while more quickly producing a composite part that meets standards for use in aircraft.

5 **[00099]** In some alternative implementations of an illustrative embodiment, the function or functions noted in the blocks may occur out of the order noted in the figures. For example, in some cases, two blocks shown in succession may be executed substantially concurrently, or the blocks may sometimes be performed in the reverse order, depending upon the functionality
10 involved. Also, other blocks may be added, in addition to the illustrated blocks, in a flowchart or block diagram.

15 **[000100]** The description of the different illustrative embodiments has been presented for purposes of illustration and description and is not intended to be exhaustive or limited to the embodiments in the form disclosed. Many modifications and variations will be apparent to those of ordinary skill in the art. Further, different illustrative embodiments may provide different features as compared to other desirable embodiments. The embodiment or embodiments selected are chosen and described
20 in order to best explain the principles of the embodiments, the practical application, and to enable others of ordinary skill in the art to understand the disclosure for various embodiments with various modifications as are suited to the particular use contemplated.

25

What is claimed is:

1. A method for fabricating a composite structure, the method comprising:

laying up a first number of layers of composite material to form a first set of stiffeners;

laying up a second number of layers of composite material to form a panel, wherein the first set of stiffeners is associated with a first side of the panel;

laying up a third number of layers of composite material on a second side of the panel opposite the first side to form a second set of stiffeners, wherein the second set of stiffeners runs perpendicular to the first set of stiffeners;

positioning a first pre-cured composite strip between a first stiffener in the second set of stiffeners and the second side of the panel;

positioning a second pre-cured composite strip between a second stiffener in the first set of stiffeners and the first side of the panel, such that the first pre-cured composite strip and the second pre-cured composite strip have a shape configured to overlap at an intersection between perpendicular stiffeners; and

co-curing the first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material to form the composite structure.

2. The method of claim 1 further comprising:

co-bonding the first pre-cured composite strip with the first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material.

3. The method of claim 2, further comprising:
applying a first layer of adhesive between the first pre-cured composite strip and the second side of the panel prior to co-bonding.
4. The method of claim 3, further comprising:
applying a second layer of adhesive between the first pre-cured composite strip and the second stiffener prior to co-bonding.
5. The method of any one of claims 2 to 4, further comprising:
installing fasteners at an intersection of the first stiffener and the second stiffener after co-curing, wherein the fasteners provide structural support at the intersection.
6. The method of claim 5, wherein installing the fasteners comprises:
installing a first fastener at an intersection of a first flange of the first stiffener and a first flange of the second stiffener;
installing a second fastener at an intersection of the first flange of the first stiffener and a second flange of the second stiffener;
installing a third fastener at an intersection of a second flange of the first stiffener and the first flange of the second stiffener; and
installing a fourth fastener at an intersection of the second flange of the first stiffener and the second flange of the second stiffener.
7. The method of claim 6, further comprising:
inspecting a cured composite structure.

8. The method of any one of claims 2 to 7 further comprising:

co-bonding the second pre-cured composite strip with the first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material.

9. The method of claim 8, further comprising:

applying a third layer of adhesive between the second pre-cured composite strip and the first side of the panel prior to co-bonding; and

applying a fourth layer of adhesive between the second pre-cured composite strip and the first stiffener prior to co-bonding.

10. The method of any one of claims 2 to 9, further comprising:

positioning a plurality of rubber mandrels in each channel of the second set of stiffeners to maintain a desired shape during curing.

11. A composite structure for an aircraft comprising:

a panel having a first side and a second side opposite the first side;

a first set of stiffeners associated with the first side of the panel;

a second set of stiffeners associated with the second side of the panel, wherein the second set of stiffeners runs perpendicular to the first set of stiffeners; and

a number of pre-cured composite strips positioned on the panel at an intersection between a first stiffener in the second set of stiffeners and a second stiffener in the first set of stiffeners,

wherein the number of pre-cured composite strips comprises a first pre-cured composite strip positioned between the first stiffener in the second set of stiffeners and the second side of the panel and a second pre-cured composite strip positioned between a second stiffener in the first set of stiffeners and the first side of the panel,

wherein first pre-cured composite strip and second pre-cured composite strips have a shape configured to overlap at the intersection, and

wherein the panel, the first set of stiffeners, and the second set of stiffeners are co-cured to form the composite structure.

12. The composite structure of claim 11, further comprising:

a first layer of adhesive at between the first pre-cured composite strip and the second stiffener; and

a second layer of adhesive between the first pre-cured composite strip and the second side of the panel.

13. The composite structure of claim 12, further comprising:

fasteners at the intersection between the first stiffener and the second stiffener.

14. The composite structure of claim 13, wherein the fasteners comprise:

a first fastener through a first flange of the first stiffener and a first flange of the second stiffener;

a second fastener through the first flange of the first stiffener and a second flange of the second stiffener;

a third fastener through a second flange of the first stiffener and the first flange of the second stiffener; and

a fourth fastener through of the second flange of the first stiffener and the second flange of the second stiffener.

15. A method for fabricating a composite structure for an aircraft, the method comprising:

laying up a first number of layers of composite material to form a first stiffener;

laying up a second number of layers of composite material to form a panel, wherein the first stiffener is associated with a first side of the panel;

positioning a first pre-cured composite strip on a second side of the panel, wherein the second side is opposite the first side;

laying up a third number of layers of composite material on the second side of the panel to form a second stiffener running perpendicular to the first stiffener, wherein the first pre-cured composite strip is positioned between the second stiffener and the second side of the panel at an intersection of the first stiffener and the second stiffener;

positioning a second pre-cured composite strip between the first stiffener and the first side of the panel, wherein the second pre-cured composite strip is positioned between the first stiffener and the first side of the panel at the intersection of the first stiffener and the second stiffener; and

co-curing the first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material to form the composite structure.

16. The method of claim 15 further comprising:

applying a first layer of adhesive between the first pre-cured composite strip and the second side of the panel;

applying a second layer of adhesive between the first pre-cured composite strip and the second stiffener; and

co-bonding the first pre-cured composite strip with the first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material.

17. The method of claim 16 further comprising:

applying a third layer of adhesive at an interface of the second pre-cured composite strip and the first side of the panel;

applying a fourth layer of adhesive at the interface of the second pre-cured composite strip and the first stiffener; and

co-bonding the second pre-cured composite strip with the first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material.

18. The method of any one of claims 15 to 17 further comprising:

installing fasteners at the intersection of the first stiffener and the second stiffener after co-curing.

19. A method for fabricating a composite structure, the method comprising:

laying up a first number of layers of composite material to form a first set of stiffeners;

laying up a second number of layers of composite material to form a panel, wherein the first set of stiffeners is associated with a first side of the panel;

laying up a third number of layers of composite material on a second side of the panel opposite the first side to form a second set of stiffeners, wherein the second set of stiffeners runs perpendicular to the first set of stiffeners;

positioning a first pre-cured composite strip between a first stiffener in the second set of stiffeners and the second side of the panel only at an intersection of the first stiffener in the second set of stiffeners and a second stiffener in the first set of stiffeners; and

co-curing the first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material to form the composite structure, wherein the first pre-cured composite strip prevents buckling of the composite structure at the intersection, and wherein the intersection is the geometrical overlap of the first stiffener and the second stiffener with the panel sandwiched in between.

20. The method of claim 19, further comprising:

co-bonding the first pre-cured composite strip with the first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material.

21. The method of claim 20, further comprising:

applying a first layer of adhesive between the first pre-cured composite strip and the second side of the panel prior to co-bonding.

22. The method of claim 21, further comprising:

applying a second layer of adhesive between the first pre-cured composite strip and the first stiffener prior to co-bonding.

23. The method of any one of claims 20 to 22, further comprising:

positioning a second pre-cured composite strip between the second stiffener and the first side of the panel; and

co-bonding the second pre-cured composite strip with the first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material.

24. The method of claim 23, further comprising:

applying a third layer of adhesive between the second pre-cured composite strip and the first side of the panel prior to co-bonding; and

applying a fourth layer of adhesive between the second pre-cured composite strip and the second stiffener prior to co-bonding.

25. The method of any one of claims 20 to 24, further comprising:

installing fasteners at the intersection of the first stiffener and the second stiffener after co-curing, wherein the fasteners provide structural support at the intersection.

26. The method of claim 25, wherein installing the fasteners comprises:

installing a first fastener at an intersection of a first flange of the first stiffener and a first flange of the second stiffener;

installing a second fastener at an intersection of the first flange of the first stiffener and a second flange of the second stiffener;

installing a third fastener at an intersection of a second flange of the first stiffener and the first flange of the second stiffener; and

installing a fourth fastener at an intersection of the second flange of the first stiffener and the second flange of the second stiffener.

27. The method of claim 26, further comprising:
inspecting a cured composite structure.

28. The method of any one of claims 20 to 27, further comprising:

positioning a plurality of rubber mandrels in a channel of each stiffener of the second set of stiffeners to maintain a desired shape during curing.

29. A method for fabricating a composite structure for an aircraft, the method comprising:

laying up a first number of layers of composite material to form a first stiffener;

laying up a second number of layers of composite material to form a panel, wherein the first stiffener is associated with a first side of the panel;

positioning a first pre-cured composite strip on a second side of the panel, wherein the second side is opposite the first side;

laying up a third number of layers of composite material on the second side of the panel to form a second stiffener running perpendicular to the first stiffener, wherein the first pre-cured composite strip is positioned between the second stiffener and the second side of the panel only at an intersection of the first stiffener and the second stiffener;
and

co-curing the first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material to form the composite structure, wherein the first pre-cured composite strip

prevents buckling of the composite structure at the intersection, and wherein the intersection is the geometrical overlap of the first stiffener and the second stiffener with the panel sandwiched in between.

30. The method of claim 29, further comprising:
applying a first layer of adhesive between the first pre-cured composite strip and the second side of the panel;
applying a second layer of adhesive between the first pre-cured composite strip and the second stiffener; and
co-bonding the first pre-cured composite strip with the first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material.

31. The method of claim 30, further comprising:
positioning a second pre-cured composite strip between the first stiffener and the first side of the panel;
applying a third layer of adhesive at an interface of the second pre-cured composite strip and the first side of the panel;
applying a fourth layer of adhesive at the interface of the second pre-cured composite strip and the first stiffener; and
co-bonding the second pre-cured composite strip with the first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material.

32. The method of any one of claims 29 to 31, further comprising:
installing fasteners at the intersection of the first stiffener and the second stiffener after co-curing.

33. The method of claim 32, wherein installing fasteners comprises:

installing a first fastener at an intersection of a first flange of the first stiffener and a first flange of the second stiffener;

installing a second fastener at an intersection of the first flange of the first stiffener and a second flange of the second stiffener;

installing a third fastener at an intersection of a second flange of the first stiffener and the first flange of the second stiffener; and

installing a fourth fastener at an intersection of the second flange of the first stiffener and the second flange of the second stiffener.

34. The method of claim 33, further comprising:
inspecting a cured composite structure.

35. The method of claim 29, further comprising:
co-bonding the first pre-cured composite strip with the first number of layers of composite material, the second number of layers of composite material, and the third number of layers of composite material.

36. The method of claim 35, further comprising:
applying a first layer of adhesive between the first pre-cured composite strip and the second side of the panel prior to co-bonding.

37. The method of claim 36, further comprising:
applying a second layer of adhesive between the first pre-cured composite strip and the second stiffener prior to co-bonding.

38. The method of any one of claims 35 to 37, further comprising:

positioning a plurality of rubber mandrels in a channel of the second stiffener to maintain a desired shape during curing.

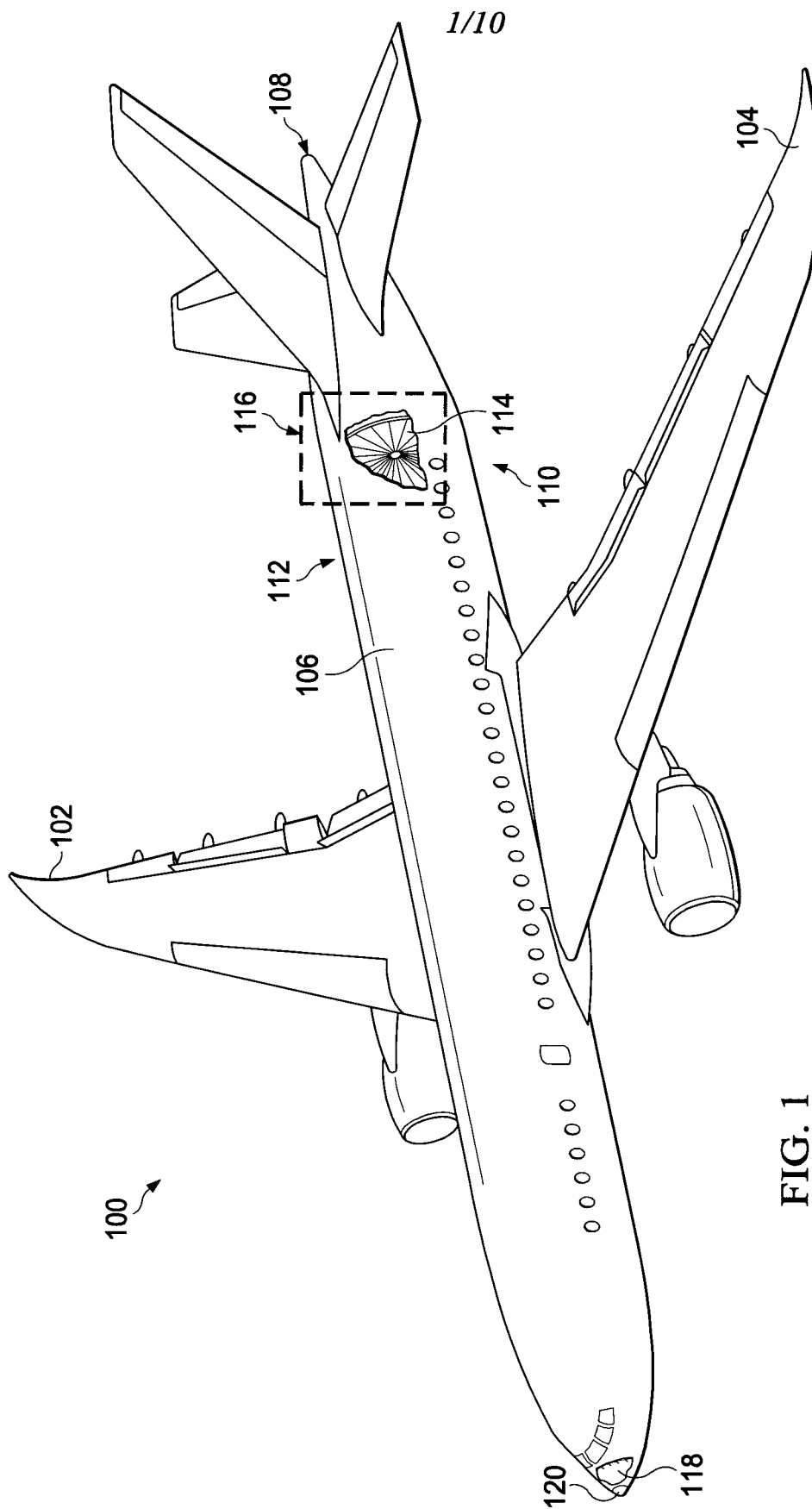


FIG. 1

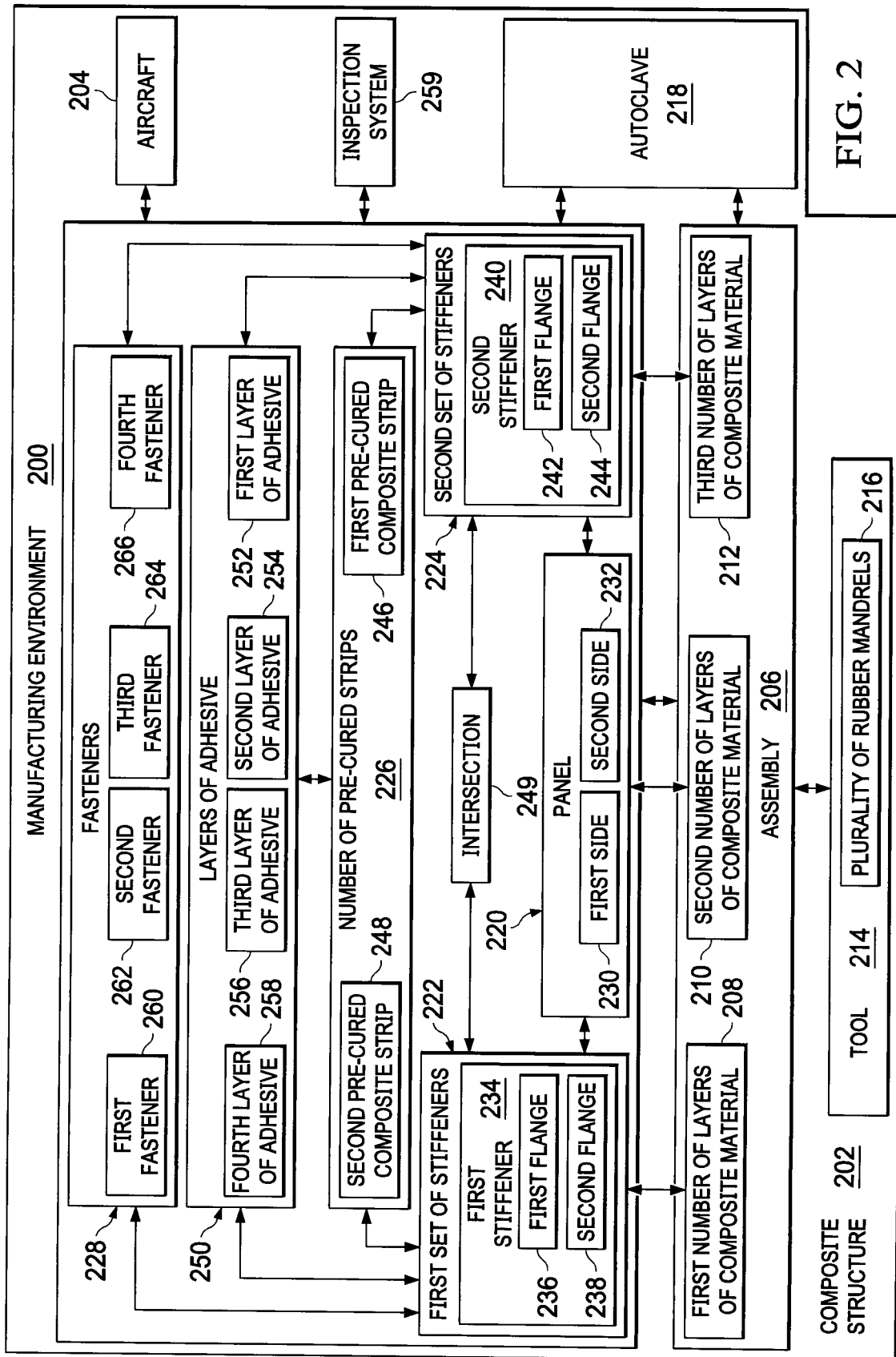


FIG. 2

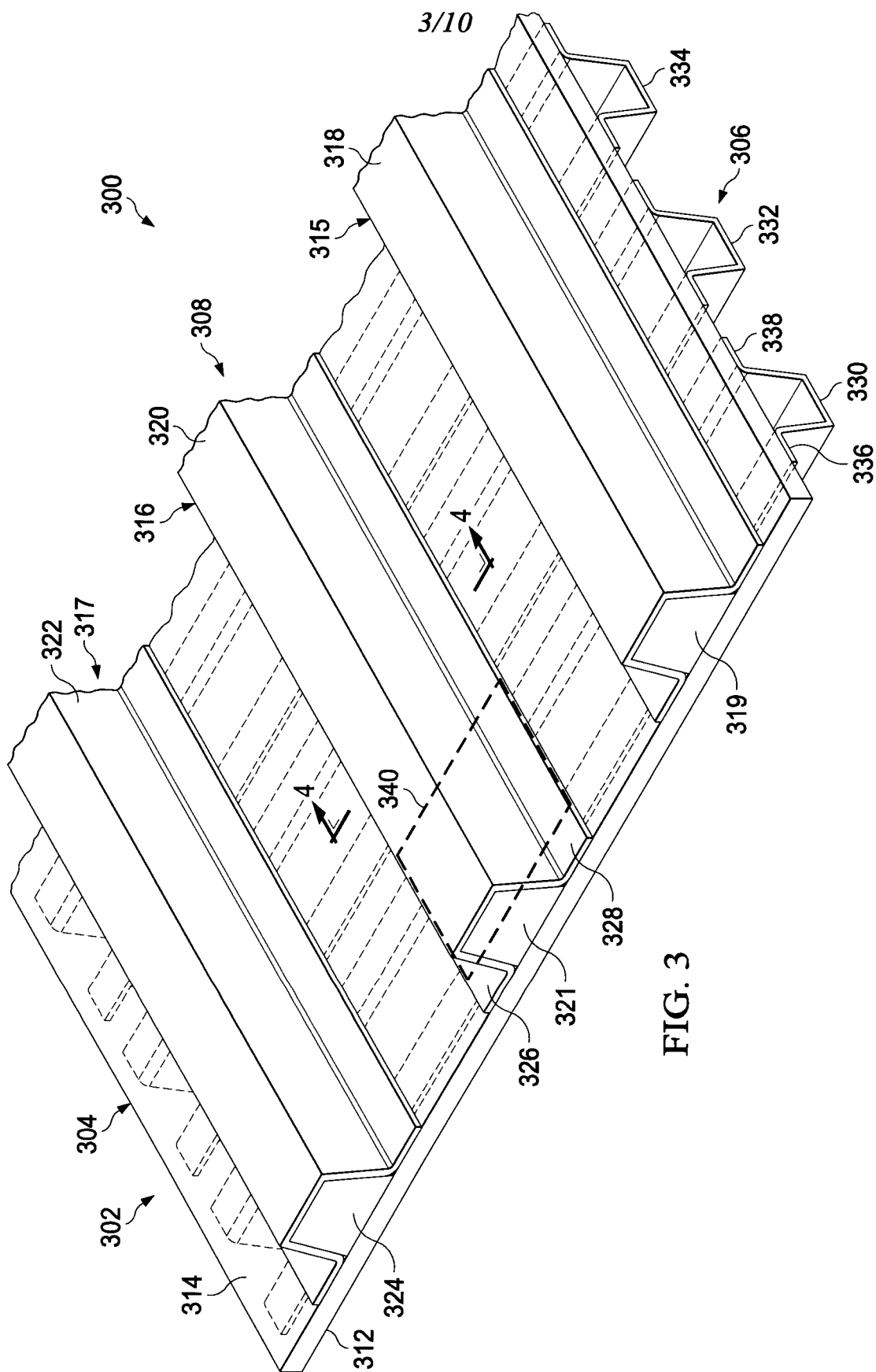


FIG. 3

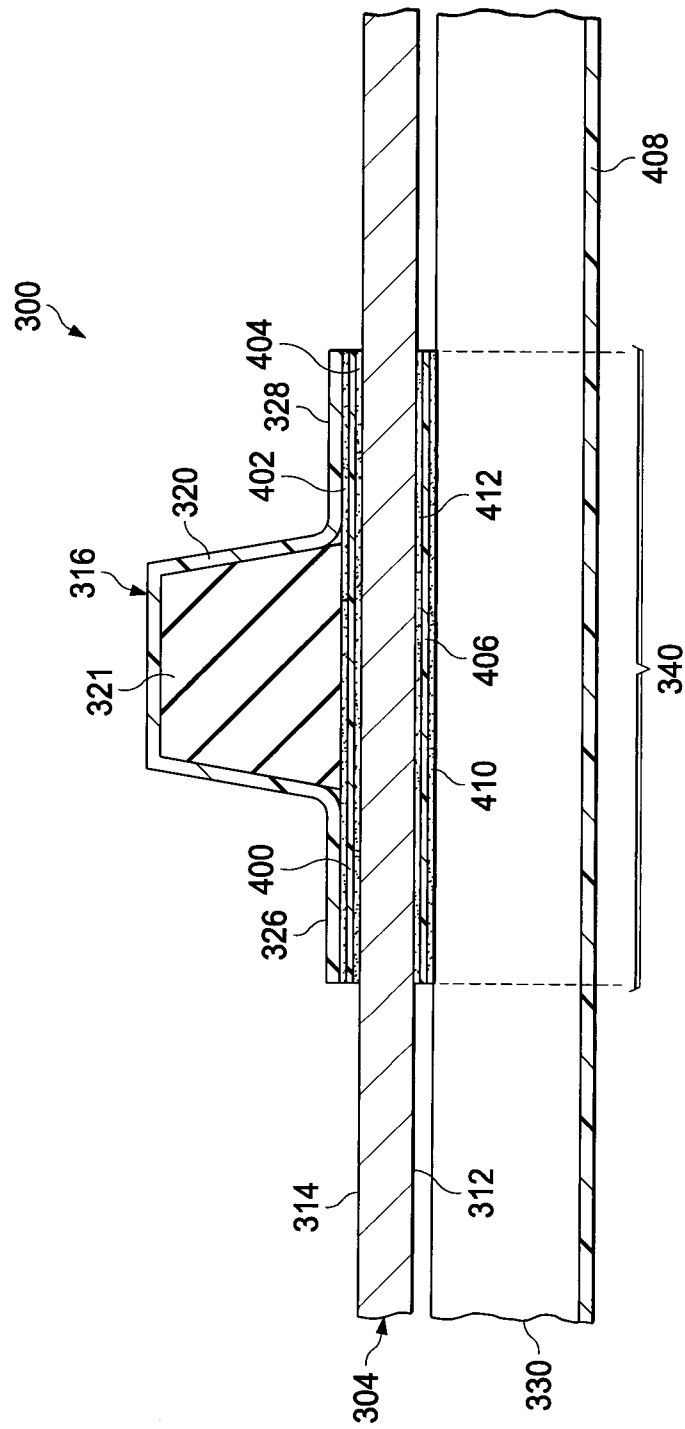


FIG. 4A

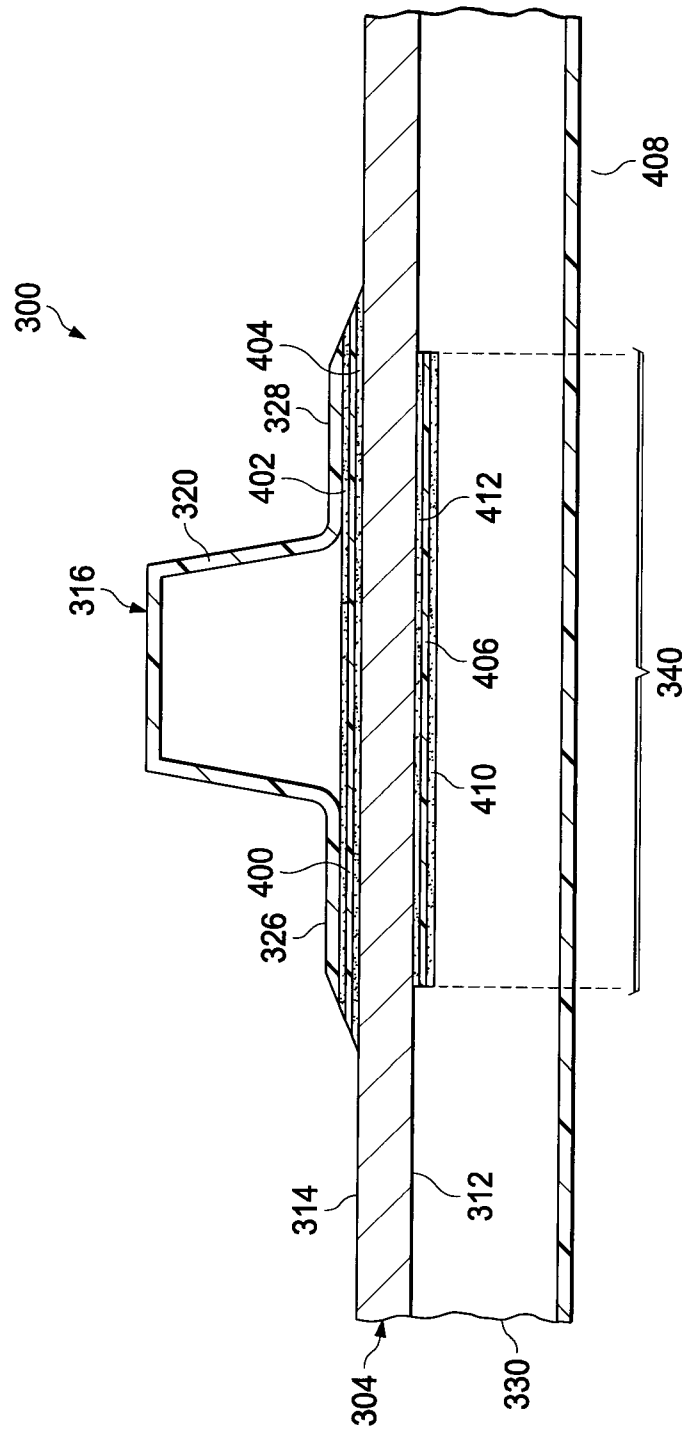
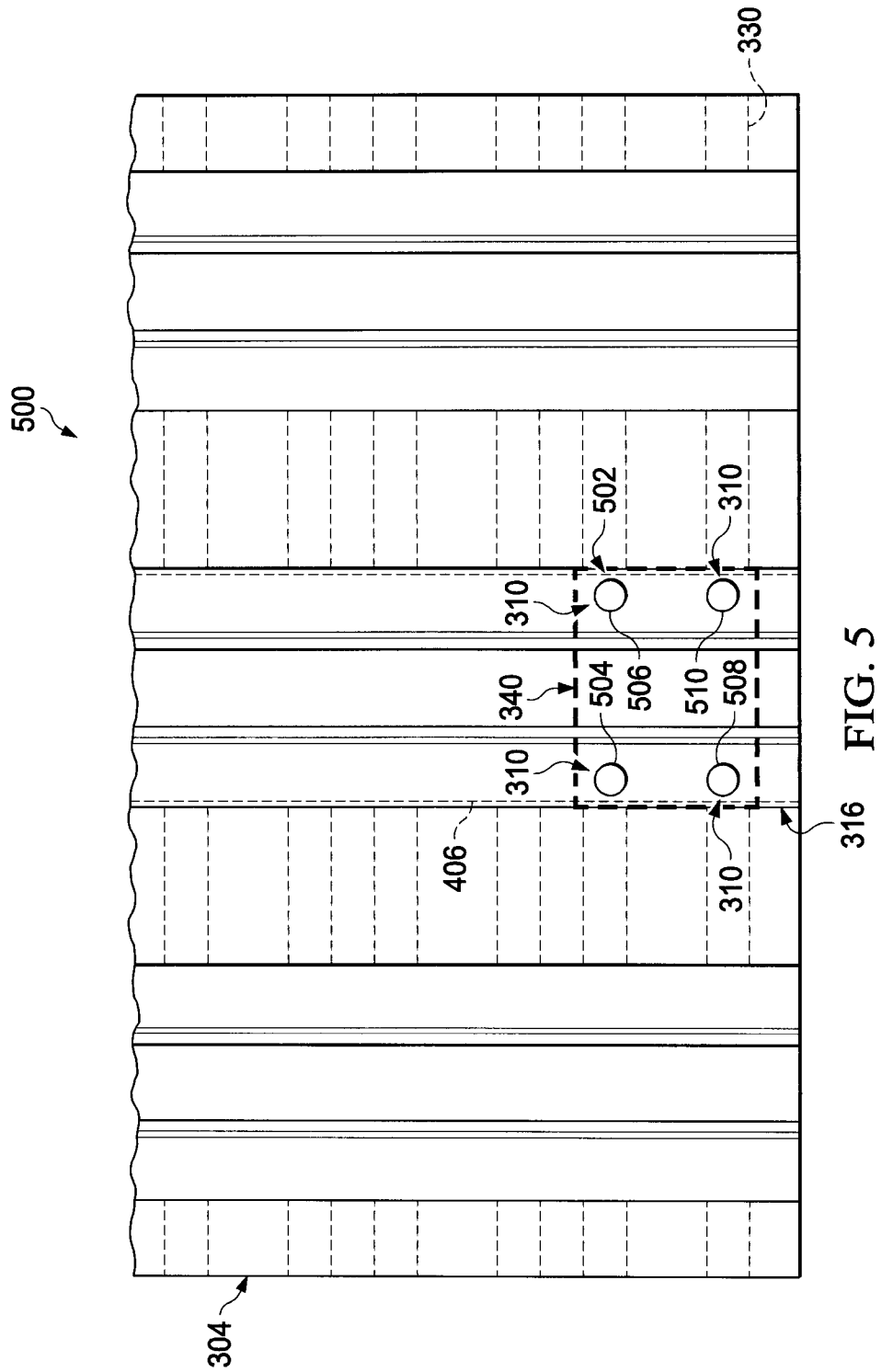


FIG. 4B



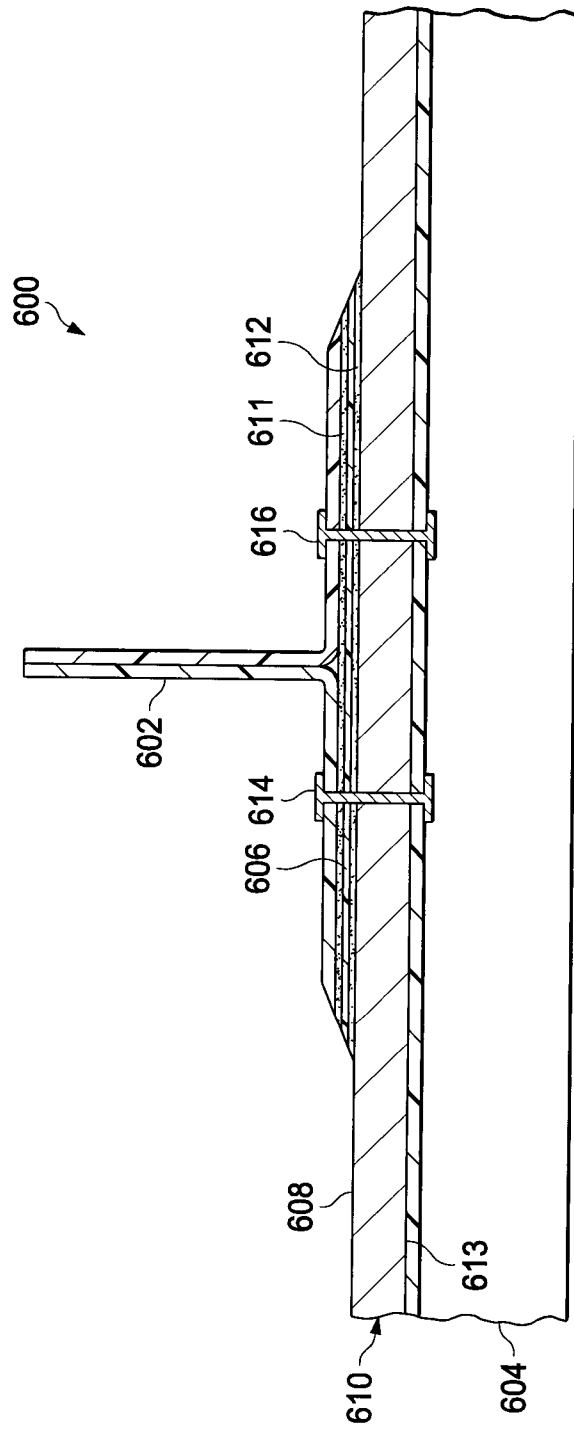


FIG. 6

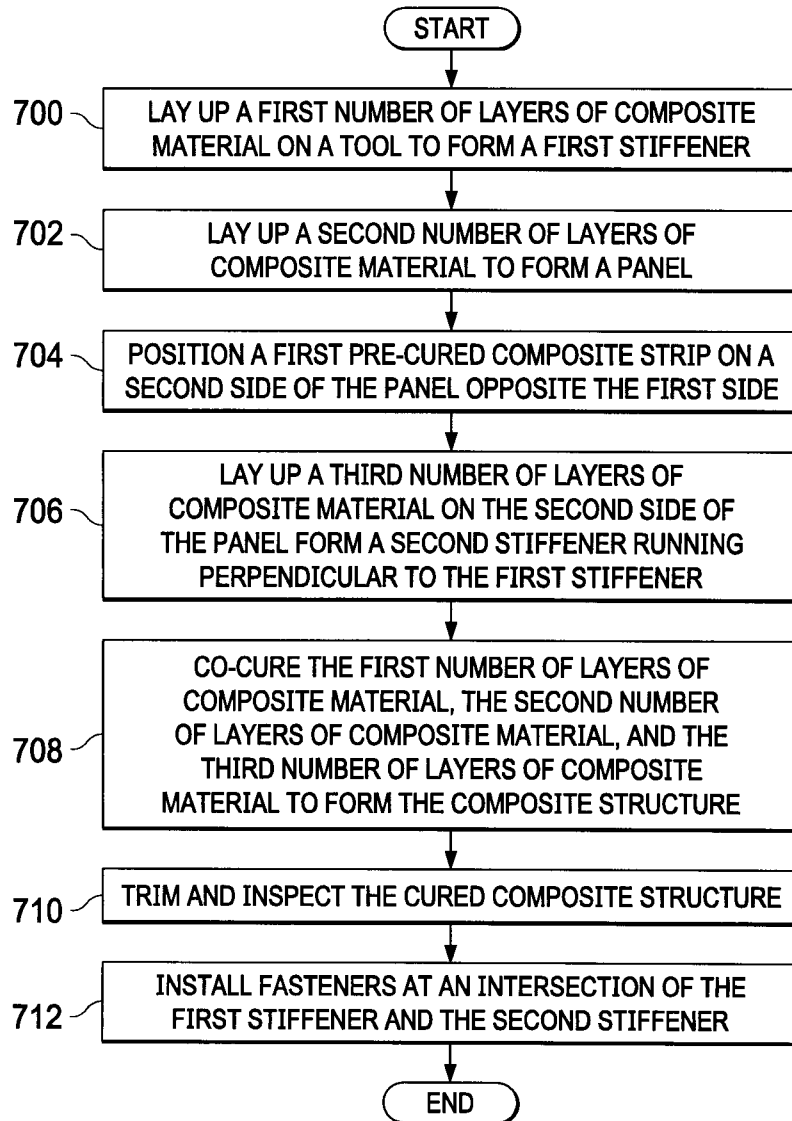


FIG. 7

9/10

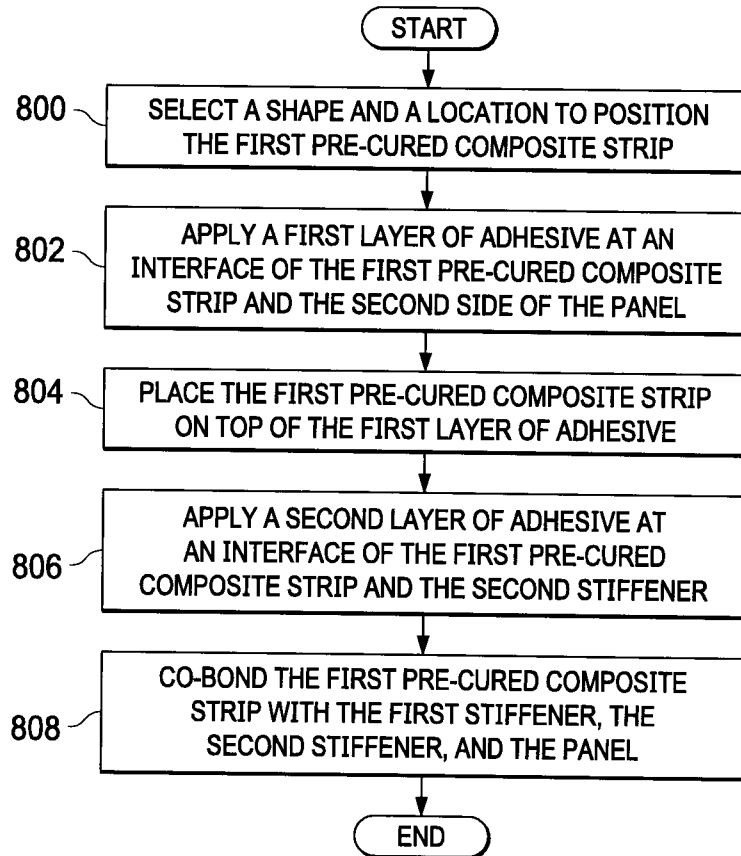


FIG. 8

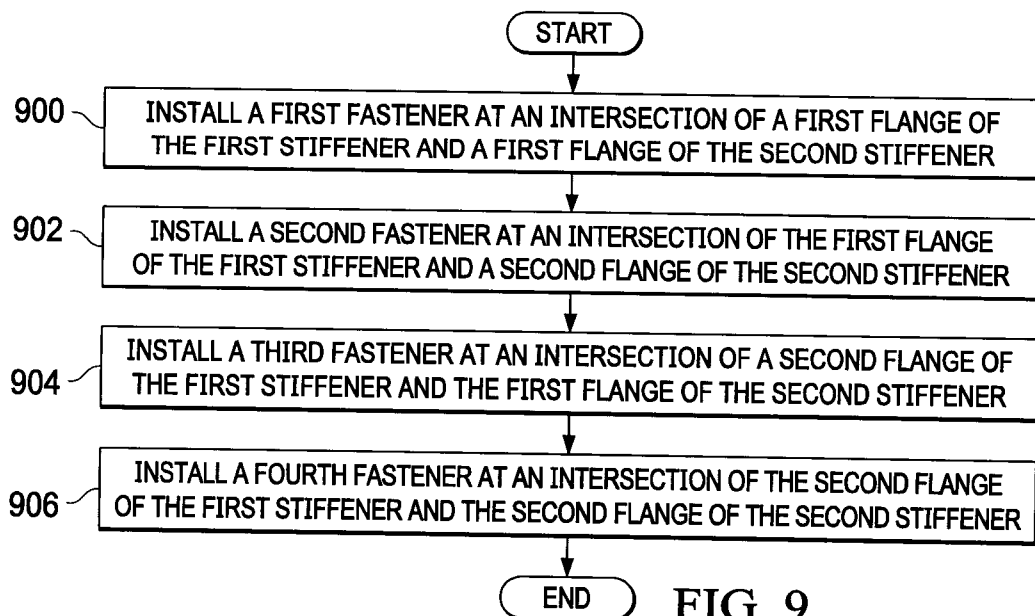


FIG. 9

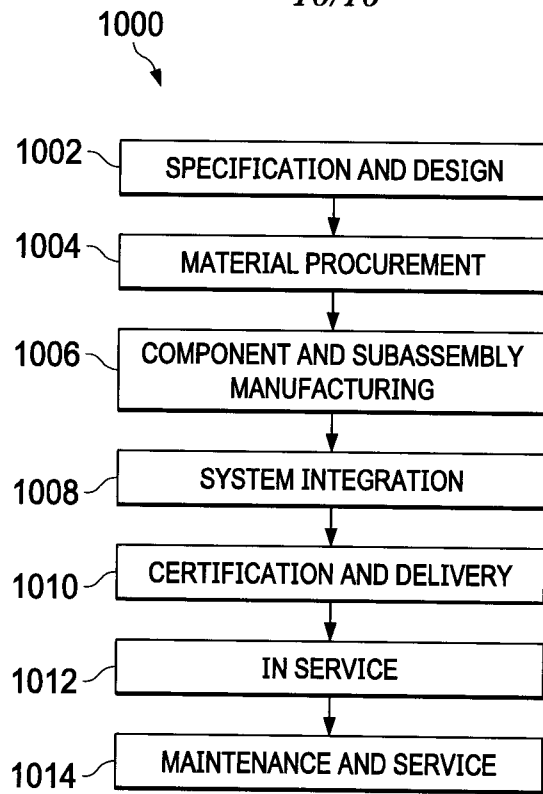


FIG. 10

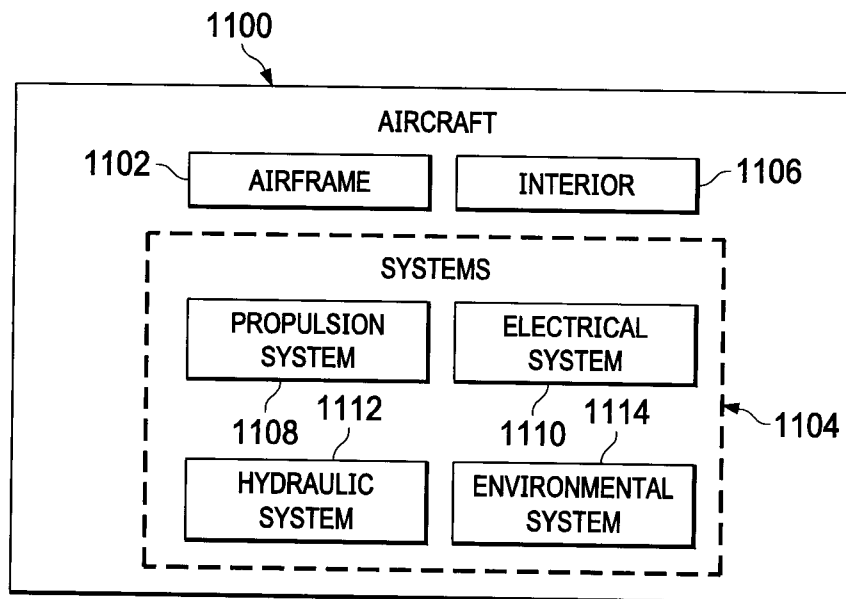


FIG. 11

