

BAC5719

REVISION
AA
7/17/2014

CHEMICAL CONVERSION COATINGS FOR
ALUMINUM AND ALUMINUM ALLOYS



<u>BAC 5719 DEPARTURES</u>	<u>EFF DATE</u>	<u>SUBCONTRACTOR(S) AFFECTED</u>	<u>ON MODELS</u>	<u>MFG DEPTS OF DIV BELOW AFFECTED</u>
6-111	11/25/1998	NORTHROP GRUMMAN	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE
6-131	5/7/2002	NONE	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCAG
6-136	10/31/2003	NONE	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	SHOPS T-4920 AND A-8700
6-137	10/31/2003	NONE	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	SHOPS T-4900 AND A-8700
6-138	7/2/2004	NONE	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	BCAG AUBURN, SALT LAKE CITY AND WICHITA ONLY
6-142	11/24/2004	KOREAN AIRLINES (AEROSPACE DIVISION)	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE
6-143	9/14/2006	NONE	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	SHOP A-7340 Only
6-144	5/10/2006	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCAG AND SUPPORTING
6-145	3/20/2007	BLUE STREAK FINISHERS	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE
6-147	4/18/2007	NONE	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	SHOPS A-8700 and A-7300
6-148	1/8/2009	TC SYSTEMS	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE
6-149	8/28/2009	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCA AND SUPPORTING
6-150	1/5/2010	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCA AND SUPPORTING
6-152	6/15/2010	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCA AND SUPPORTING
6-153	6/23/2011	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	RENTON: R-3480, EVERETT: TD30P, T-B353, T-B356, U-B310
6-154	5/29/2012	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCA AND SUPPORTING

6-155	10/23/2013	ARNPRIOR AEROSPACE, INC. (CANADA AND MEXICO SITES)	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE
6-156	12/10/2015	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCA AND SUPPORTING
6-82	2/6/1992	NONE	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	BCAG WICHITA ONLY
6-96	11/1/1996	NONE	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	A-8910 AND A-3943
8-1	8/22/2011	ALL	ICH-47F	ALL BOEING PHILADELPHIA AND SUPPORTING
9-4	8/28/1997	NONE	581/583 (B-2)	BOEING NORTH AMERICAN, NORTH AMERICAN AVIATION DIV.,
9-6	8/5/1999	NONE	204 (E-3A) 667 (767 AWACS)	BOEING DEFENSE AND SPACE GROUP (EL PASO ONLY)
9-8	10/13/2000	ALL	581-583 (B-2)	BOEING DEFENSE AND SPACE GROUP AND SUPPORTING
9-12	8/11/2015	ALL	ALL BDS EXCEPT 581 (B-2) AND 809 (P-8)	BDS AND SUPPORTING (EXCEPT EL PASO OPERATIONS)
9-13	9/3/2015	ALL	737 MMA, P8 (809)	BDS AND SUPPORTING (EXCEPT EL PASO OPERATIONS)

THIS SPECIFICATION ESTABLISHES THE REQUIREMENTS FOR APPLYING A CHEMICAL CONVERSION COATING ON ALUMINUM AND ALUMINUM ALLOYS TO INCREASE CORROSION RESISTANCE, ACT AS A PAINT BASE, AND PROVIDE AN ELECTRICALLY CONDUCTIVE FINISH.

REASON

TO ALLOW GRUMMAN THE USE OF EXISTING ALODINE 600 SOLUTION
THIS WILL SUPPORT THE USE OF SMALL TANKS
TO ALLOW SALT SPRAY TESTING ON 6061-T6 ALLOY WHICH IS MORE REPRESENTATIVE OF ACTUAL SHOP PRODUCTION. THIS IS AN RE-ISSUE OF PSD6-106
TO ALLOW A PROCESS FOR ACID CLEANING OF TUBING WITH MILL CODE MARKINGS AS AN OPTION TO ALKALINE CLEANING.
TO ALLOW THE USE OF READY-TO-USE CHEMICAL CONVERSION COATING SOLUTIONS IN 55 GALLON PROCESSING TANKS WITHOUT CHEMICAL ADDITIONS
TO ALLOW KAL (AEROSPACE DIVISION) TO USE SALT SPRAY CORROSION TEST SPECIMENS. 0.032 TO 0.063 INCH THICK BY 3 INCHES WIDE BY 5 INCHES LONG WHEN PROCESSING IN SMALL TANKS (LESSS THAN 55 GALLONS EACH).
ALLOW SHOP A-7340 TO IMMERSION RINSE IN 140 f MAXIMUM FOR 2 TO 5 MINUTES, FOLLOWING CHEMICAL CONVERSION COATING.
CHANGE TABLE II AND FL 10 ALODINE 1600/1660 MAKE-UP AND CONTROL REQUIREMENTS.
TO ALLOW MULTIPLE IMMERSION METHOD AS AN OPTION FOR PUMPED ALUMINUX 100 ALKALINE ETCHANT AND DEOXIDIZE SOLUTIONS FOR TUBING.
TO ALLOW MULTIPLE IMMERSION METHOD AS AN OPTION FOR PUMPED TEA ALKALINE ETCHANT AND DEOXIDIZE SOLUTIONS FOR TUBING
TO ALLOW SMALL DIAMETER 6061 ALUMINUM TUBING TO BE PROCESSED USING MULTIPLE IMMERSION METHOD.
TO ALLOW SOLVENT CLEANING AS A PREPERATION FOR TYPE II APPLICATION OF CONVERSION COATING OF FULL SIZED HOLES
TO ALLOW PH ADJUSTMENT WITH NITRIC ACID FOR TYPE I ALODINE 1500 SOLUTIONS
TO ADD A DEFINITION FOR TUBE AND TO REVISE PROCESSING OF SMALL DIAMETER TUBING.
ALLOW THE USE OF CHEMICAL CLEANING ON SKIN QUALITY ALUMINUM PRIOR TO ALODINING. ADD THREE ADDITIONAL EVERETT SEAL, TEST, AND PAINT ORGINIZATIONS. ADD ANDROX 1250.
TO CLARIFY THE USE OF ALKALINE ETCH CLEANING AS A SURFACE PREPERATION PRIOR TO CHEMICAL CONVERSION TREATMENT.

TO ALLOW PROCESSOR TO USE LOCALLY AVAILABLE NITRIC ACID.

TO ALLOW THE USE OF ALTERNATIVE APPLICATION MATERIALS FOR MANUAL CONVERSION COATING TREATMENT.

ALL ELEVATED TEMPERATURE RINSE FOLLOWING APPLICATION OF ALODINE 1200

TO PROVIDE SHOPS A-8910 AND A-3943 OPTION FOR CLEANING WELDED ASSEMBLIES WITH OPEN FAYING SURFACES.

TO ALLOW MANUFACTURE'S RECOMMENDED CONCENTRATION FOR ALODINE 1200S.

TO ALLOW USE OF LOCALLY AVAILABLE PROCESSING CONDITIONS.

REVISE REQUIREMENTS FOR EL PASO REQUIREMENTS

REVISE REQUIREMENTS TO ALLOW MIL-P-85582 PRIMER. REF RDR'S R-107, R-119, S-2723

TO PROVIDE INSTRUCTION FOR COLORED CONVERSION COATINGS. REVISE MFG BLOCK TO EXCLUDE EL PASO OPERATIONS.

TO PROVIDE INSTRUCTION FOR COLORED CONVERSION COATINGS.