

BAC5555

REVISION
T
2/16/2011

PHOSPHORIC ACID ANODIZING OF
ALUMINUM FOR STRUCTURAL
BONDING



<u>BAC 5555 DEPARTURES</u>	<u>EFF DATE</u>	<u>SUBCONTRACTOR(S) AFFECTED</u>	<u>ON MODELS</u>	<u>MFG DEPTS OF DIV BELOW AFFECTED</u>
6-98	12/8/2000	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	BCAG AND SUPPORTING
6-111	3/16/2006	NIPPI CORPORATION	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE
6-112	4/20/2006	TRIUMPH AIRBORNE STRUCTURES INC.	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE
6-113	12/11/2006	TRIUMPH AIRBORNE STRUCTURES INC.	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE
6-114	5/29/2007	TRIUMPH FABRICATIONS - FT. WORTH	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE
6-115	7/13/2007	SPIRIT AEROSYSTEMS, INC WICHITA, DIVISION	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE
6-116	7/13/2007	YOKOHAMA RUBBER CO., LTD	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE
6-117	7/30/2007	FLEET CANADA INC.	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE
6-118	5/27/2011	SPIRIT AEROSYSTEMS	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE
6-119	10/28/2011	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCA AND SUPPORTING
6-120	5/2/2012	MITSUBISHI HEAVY INDUSTRIES, LTD (MHI)	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE
6-122	7/2/2014	KAMAN AEROSPACE CORPORATION BLOOMFIELD, CT	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE
6-123	8/9/2016	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCA AND SUPPORTING
8-1	8/12/2010	ALL	CH-47	NONE
8-2	11/1/2012	BRENNER AEROSTRUCTURES	ALL BOEING PHILADELPHIA	NONE

8-3	10/29/2014	GKN	ALL BOEING PHILADELPHIA	ALL BOEING PHILADELPHIA AND SUPPORTING
9-1	6/16/2011	SPIRIT AEROSYSTEMS	ALL BDS-PS/W/H	NONE
9-2	7/25/2012	ALL	ALL BDS	BDS AND SUPPORTING

THIS SPECIFICATION ESTABLISHES THE ENGINEERING REQUIREMENTS FOR PHOSPHORIC ACID ANODIZING OF ALUMINUM FOR STRUCTURAL ADHESIVE BONDING AND SUBSEQUENT FINAL FINISHING.

REASON

TO ALLOW SHORTENED DEOXIDATION AND ANODIZE TIMES WHEN PROCESSING BMS8-336 ALUMINUM MESH

TO ALLOW USE OF JAPANESE INDUSTRY STANDARDS FOR CHEMICAL USED IN JAPAN.

TO ALLOW TRIUMPH AIRBORNE STRUCTURES INC. THE USE OF ALKALINE, DEOXIDIZER AND ASSOCIATED RINSE TANKS FOR NON-BONDED DETAILS.

TO ALLOW TRIUMPH AIRBORNE STRUCTURES TO PROCESS WITH DIFFERENT INCOMING WATER REQUIREMENTS, WITH WEEKLY VERIFICATION TESTING.

TO ALLOW TRIUMPH FABRICATIONS - FT. WORTH THE USE OF ALKALINE, DEOXIDIZER, AND ASSOCIATED RINSE TANKS FOR PRE-PENETRANT CLEANING.

TO ALLOW SPIRIT TO PERFORM THE WATERBREAK FREE INSPECTION ON OUTER SURFACES OF LOADS AT A FREQUENCY OF ONCE PER SHIFT. ADDITIONAL REQUIREMENTS ARE RETAINED.

TO ALLOW ALTERNATE VAPOR DEGREASING SOLVENT, AND ALTERNATE DEGREASING PROCESS.

TO PERMIT PROCESSING OF BAC5555 BOND PARTS AND DEHAVILLAND PPS 36.10 BOND PARTS IN THE SAME MANUFACTURING LINE.

TO ALLOW SPIRIT TO PROCESS WITH DIFFERENT RECTIFIER REQUIREMENTS

TO ADD NEW SOLVENT FORMULATION FOR AC-828 MASKANT.

TO ALLOW ALTERNATE VAPOR DEGREASING SOLVENT AND ALTERNATE DEGREASING PROCESS

TO REINSTATE ALLOWANCE FOR USE OF EXISTING DEOXIDIZER

ADD NEW FUNGICIDE USAGE TO SECTION 5 AND 9. ALLOW ALL SUBCONTRACTORS TO USE.

TO ALLOW THE WEEKLY WEDGE TEST TO BE OMITTED IF NO PART PROCESSING IS CONDUCTED FOR A GIVEN WEEK.

TO ADD NEW FUNGICIDE USAGE TO SECTION 5 AND 9.

TO ALLOW GKN TO PROCESS METAL BOND DETAILS PER DPS11.08

TO ALLOW SPIRIT TO PROCESS WITH DIFFERENT RECTIFIER REQUIREMENTS

ALLOW BDS AND SUPPLIERS TO PROCESS WITH PERMANENT MASKANT.