BAC5632

REVISION
D
8/3/2004

BORIC ACID – SULFURIC ACID ANODIZING

ORION aerospace

THIS SPECIFICATION ESTABLISHES THE REQUIREMENTS FOR BORIC ACID–SULFURIC ACID ANODIZING OF ALL ALUMINUM AND ALUMINUM ALLOYS.

BAC 5632 DEPARTURES	*EFF DATE*	SUBCONTRACTOR(S) AFFECTED	ON MODELS	MFG DEPTS OF DIV BELOW AFFECTED	REASON
6-31	9/15/1997	NONE	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	SHOP 8–3194 ONLY	TO REVISE REQUIREMENTS FOR UNSEALED ANODIZE PRETREATMENT SUCH THAT A LONGER PERIOD OF TIME IS ALLOWED BETWEEN ANODIZING AND PRIMING OR FIRST FUEL TANK COATING APPLICATION.
6-39	3/15/1999	NONE	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	SHOPS A–W315, A–W325 AND A–3900 ONLY	TO ALLOW A LONGER PERIOD OF TIME BETWEEN ANODIZING AND PRIMING OR FIRST FUEL TANK COATING APPLICATION
6-43	5/12/2000	NONE	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	SHOP A–W325 ONLY	TO ALLOW A LONGER PERIOD OF TIME BETWEEN CLASS 5 ANODIZING AND PRIMING OR FIRST FUEL TANK COATING APPLICATION.
6-50	5/2/2001	HYTEK FINISHES CO.	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	TO ALLOW EXTENSION OF FLOW TIME FROM CLASS 5 ANODIZING TO FIRST PRIME COAT OR FUEL TANK COATING FROM 16 TO 48 HOURS.
6-55	7/3/2002	NONE	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	SHOP A–3900	TO REVISE REQUIREMENT FOR UNSEALED ANODIZE TO ALLOW A LONGER PERIOD OF TIME BETWEEN ANODIZING AND APPLICATION OF BAC5710, TYPE 60 ADHESIVE PRIMER.
6-60	12/21/2005	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCAG AND SUPPORTING	CHANGE SECTION 6C. CONTINUOUS TEMPERATURE MONITORING REQUIREMENT TO AGREE WITH SECTION 8H. WHICH ALLOWS REGULAR INTERVAL MONITORING DETERMINED THROUGH EXPERIENCE
6-62	1/10/2007	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	BCA AND SUPPORTING	REVISE SECTION 8.F. TO PERMIT THE USE OF CLEAN, LINT FREE, POWDER FREE, NON–SILICON GLOVES FOR HANDLING WET AND DRY ANODIZED PARTS.
6-63	11/15/2006	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	BCA AND SUPPORTING	TO ALLOW THE USE OF ALUMINUM CATHODES.
6-64	3/27/2007	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	BCA AND SUPPORTING	REVISE INCOMING SOLUTION AND RINSE WATER PH AND FINAL IMMERSION PH AFTER ANODIZING. CHANGE SECTION 9.3 OVERLY RESTRICTIVE RINSE WATER CHLORIDE CONCENTRATION FROM 25 PPM MAXIMUM TO 50 PPM MAXIMUM.
6-67	7/10/2007	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	BCA AND SUPPORTING	ALLOW NONDESTRUCTIVE AND NONCHEMICAL ALTERNATIVE FOR ANODIZE COATING WEIGHT MEASUREMENT ON BORIC-SULFURIC ACID ANODIZE.
6-68	10/31/2008	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCA AND SUPPORTING	TO ADD SODIUM CHROMATE TETRAHYDRATE FOR USE IN DILUTE CHROMATE SEAL SOLUTION AND UPDATE OBSOLETE MATERIAL SPECIFICATION REFERENCES IN MATERIALS CONTROL.
6-69	12/17/2008	ARNPRIOR AEROSPACE	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	TO REVISE REQUIREMENTS FOR UNSEALED ANODIZED PRETREATMENT TO ALLOW A LONGER PERIOD OF TIME BETWEEN ANODIZING AND PRIMER OR FUEL TANK COATING APPLICATION
6-71	4/26/2010	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCA AND SUPPORTING	TO INCREASE THE ALLOWABLE THICKNESS RANGE FOR CORROSION RESISTANCE PANELS
6-72	6/15/2010	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCA AND SUPPORTING	TO REMOVE PAINT ADHESION TESTING REQUIREMENTS FROM SECTION 11 FOR CLASS 5 COATINGS.
6-73	1/24/2011	SKILLS INC, AUBURN WA	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	TO ALLOW EXTENSION OF FLOW TIME FROM CLASS 5 ANODIZING TO FIRST PRIME COAT OR FUEL TANK COATING FROM 16 TO 48 HOURS.
6-74	7/13/2011	SPIRIT AEROSYSTEMS, WICHITA DIVISION, MPF SHOPS 3171, 3172 AND 3173 ONLY	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	UPDATE SUBCONTRACTOR AND MFG DEPT LISTINGS TO ALLOW A LONGER PERIOD OF TIME BETWEEN CLASS 5 ANODIZING AND PRIMING OR FIRST FUEL TANK COATING APPLICATION.
6-75	10/4/2011	MAGNETIC AND PENETRANT SERVICES COMPANY (MAPSCO)	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	TO ALLOW EXTENSION OF FLOW TIME FROM CLASS 5 ANODIZING TO FIRST PRIME COAT OR FUEL TANK COATING FROM 16 TO 48 HOURS.
6-76	2/17/2012	NONE	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	SHOP A-7300 ONLY	TO INCREASE THE PERIOD OF TIME BETWEEN ANODIZING AND APPLICATION OF VARIOUS COATING SYSTEMS TO 80 HOURS. TO ADD BAC5710 TYPE 51 TO THE LIST OF APPLICABLE COATINGS
6-77	5/29/2012	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCA AND SUPPORTING	TO ALLOW NONDESTRUCTIVE AND NONCHEMICAL ALTERNATIVE FOR ANODIZE COATING WEIGHT MEASUREMENT ON BORIC-SULFURIC ACID ANODIZE.
6-78	11/13/2012	MECAPROTEC INDUSTRIES	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	TO ALLOW EXTENSION OF FLOW TIME FROM CLASS 5 ANODIZING TO FIRST PRIME COAT OR FUEL TANK COATING FROM 16 TO 48 HOURS.
6-79	5/17/2013	NONE	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	A-3250	TO ALLOW A LONGER PERIOD OF TIME BETWEEN CLASS 5 ANODIZING AND PRIMING, OR FUEL TANK COATING OR BAC5710, TYPE 60 ADHESIVE PRIMER. ADD BMS10-83 TYPE VI AND TYPE VII
6-80	12/10/2015	3 P PROCESSING WICHITA, KANSAS	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	TO ALLOW EXTENSION OF FLOW TIME FROM CLASS 5 ANODIZING TO FIRST PRIME COAT OR FUEL TANK COATING FROM 16 TO 48 HOURS.
6-81	9/1/2016	MHI Hiroshima Plant	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	TO ALLOW EXTENSION OF FLOW TIME FROM CLASS 5 ANODIZING TO FIRST PRIME COAT OR FUEL TANK COATING FROM 16 TO 48 HOURS.
6-82	1/5/2017	ORION INDUSTRIES, AUBURN, WA	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	TO ALLOW EXTENSION OF FLOW TIME FROM CLASS 5 ANODIZING TO FIRST PRIME COAT OR FUEL TANK COATING FROM 16 TO 48 HOURS.
9-8	1/27/2005	NOT AVAILABLE			
9-10	7/26/2015	ALL	ALL BDS EXCEPT 494 (F-22) AND 809 (P-8)	ALL BDS AND SUPPORTING	DIRECT USERS TO BAC5884.