

PS13209

REVISION
AL
8/15/2011

COATING, MULTICOLORED CHEMICAL
CONVERSION OF ALUMINUM ALLOYS BY
THE IMMERSION PROCESS



ORION

THIS SPECIFICATION INCLUDES PROCEDURES AND REQUIREMENTS FOR MULTICOLORED CHEMICAL CONVERSION COATING IMMERSION APPLICATION. THE COATING PROVIDES INCREASED CORROSION PROTECTION AND PAINT ADHESION FOR ALUMINUM ALLOYS. THIS SPECIFICATION MEETS (OR EXCEEDS) THE REQUIREMENTS OF MIL-C-5541E CLASS 1A AND 3 CONVERSION COATINGS. BRUSH APPLICATION PER P.S. 13204 MAY BE USED IN LIEU OF THIS PROCESS ON UP TO 5% OF THE SURFACE AREA TO BE TREATED. THIS SPECIFICATION IS EQUIVALENT TO DPS 9.45 AND IS APPLICABLE AT BOEING-ST. LOUIS AND ITS SUBCONTRACTORS WHEN DPS 9.45, MULTICOLORED CONVERSION COATING IS SPECIFIED ON THE ENGINEERING DRAWING/MODEL. THIS SPECIFICATION IS APPLICABLE WHEN CALLED OUT BY ENGINEERING DOCUMENTS, BY OTHER PROCESS SPECIFICATIONS, OR WHEN LISTED IN A SPECIFICATION CONVERSION INDEX. SUBCONTRACTORS AND OTHER BOEING BUSINESS UNITS MAY USE ALTERNATE SOLUTIONS AND PROCEDURES, HOWEVER THE CLASS OF ALTERNATE SOLUTIONS SHALL MATCH THE APPLICATION, I.E., CLASS 1A FOR CORROSION PROTECTION AND CLASS 3 FOR LOW ELECTRICAL RESISTANCE. THE CONVERSION COATINGS SHALL MEET REQUIREMENTS OF SECTION 5 AND QUALITY ASSURANCE REQUIREMENTS OF SECTION 7 OF THIS SPECIFICATION. SUBCONTRACTORS AND OTHER BOEING BUSINESS UNITS SHALL USE ONLY THOSE ALTERNATE SOLUTIONS THAT ARE APPROVED IN ACCORDANCE WITH MIL-DTL-81706, METHOD C (IMMERSION).

<u>PS13209 DEPARTURES</u>	<u>EFF DATE</u>	<u>SUBCONTRACTOR(S) AFFECTED</u>	<u>ON MODELS</u>	<u>MFG DEPTS OF DIV BELOW AFFECTED</u>	<u>REASON</u>
NO DEPARTURES					