

BAC5861

REVISION
E
11/4/2011

APPLICATION OF PHOSPHATE-
FLUORIDE COATING TO TITANIUM
ALLOYS



THIS SPECIFICATION ESTABLISHES THE REQUIREMENTS FOR THE APPLICATION OF A PHOSPHATE-FLUORIDE CONVERSION
COATING TO TITANIUM AND TITANIUM ALLOYS.

| <u>BAC 5861 DEPARTURES</u> | <u>EFF DATE</u> | <u>SUBCONTRACTOR(S) AFFECTED</u> | <u>AFFECTED PROGRAMS</u> | <u>AFFECTED BOEING SITES</u> | <u>REASON</u> |
|----------------------------|-----------------|---|--|---|---|
| <u>1/5/22</u> | 2/9/2022 | ALL | ALL BOEING PHILADELPHIA | PHILADELPHIA, PA | REVISE PROCESS CONTROL TESTING FOR BONDED PARTS. ADD INFO TO ACCOUNT FOR THE USE OF BR6747-1 PRIMER. ADD REFERENCE TO D210-13467-1 FOR QUALIFICATION REQUIREMENTS. ALSO UPDATE TO LATEST VERSION OF BAC5861 |
| 6-13 | 1/1/2015 | ALL | ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF | BCAG AND SUPPORTING | TO PROVIDE A PROCEDURE FOR REWORKING DAMAGED PAINT FINISHES ON TITANIUM PARTS |
| 6-18 | 9/11/2014 | ALL | ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF | BCAG AND SUPPORTING | TO ALLOW REFERENCE TO BAC5753 METHOD IIA FOR IMMERSION APPLICATION. |
| 9-8 | 11/29/1994 | ALL | ALL BOEING DEFENSE AND SPACE GROUP | BOEING DEFENSE AND SPACE GROUP AND SUPPORTING | TO UPDATE PSD L-4 TO APPLY TO ALL BOEING DEFENSE AND SPACE GROUP |
| 9-16 | 10/28/1997 | ALL EXCEPT LAWRENCE RIPA K | 494 (F-22) | BOEING DEFENSE AND SPACE GROUP | TO CLARIFY RINSING REQUIREMENTS AFTER HOT SOAK. |
| 9-19 | 10/28/1997 | LAWRENCE RIPA K | 494 (F-22) | NONE | TO CLARIFY RINSING REQUIREMENTS AFTER HOT SOAK. |
| 9-24 | 3/25/1999 | ALL | ALL BOEING DEFENSE AND SPACE GROUP | BOEING DEFENSE AND SPACE GROUP AND SUPPORTING | TO REMOVE CONCENTRATION REQUIREMENT ON HYDROFLUORIC ACID. |
| 9-25 | 7/13/2000 | AIR CAPITOL PLATING HYTECH FINISHES CO. | 494 (F-22) | BOEING DEFENSE AND SPACE GROUP | TO ALLOW OPTIONAL PRETREATMENT BY GLASS BEAD BLASTING FOR IMPROVED ADHESION. |
| 9-34 | 6/26/2003 | NOT AVAILABLE | | | |
| 9-36 | 10/13/2005 | ALL | FL 1 ALL IDS-PS/W/H | INTEGRATED DEFENSE SYSTEMS AND SUPPORTING | TO ADD ALODINE 5200 |
| 9-37 | 11/3/2008 | ALL | 494 | INTEGRATED DEFENSE SYSTEMS | ADD OPTION TO USE SOL-GEL IN LIEU OF PHOSPHATE FLUORIDE CONVERSION COAT, CLARIFICATION. |