

BAC5019

REVISION
Y
6/8/2022

CHROMIC ACID ANODIZING



THIS SPECIFICATION ESTABLISHES THE REQUIREMENTS FOR CHROMIC ACID ANODIZING OF ALL ALUMINUM AND ALUMINUM ALLOYS

BAC 5019 DEPARTURES	EFF DATE	AFFECTED SUBCONTRACTOR(S)	AFFECTED PROGRAM(S)	AFFECTED BOEING SITES	REASON
6-135	4/20/1995	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.
6-145	3/24/1997	HAWKER-DEHAVILLAND, SIDNEY AND GOVERNMENT AIRCRAFT FACTORIES, MELBOURNE	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE	(1) TO PERMIT USE OF EXISTING SEALING FACILITIES. (2) TO ASSURE SATISFACTORY PAINT ADHESION TO ANODIZED SURFACES.
1-5	6/8/2022	ISRAEL AIRCRAFT INDUSTRIES LTD	ALL BCA	NONE	TO ALLOW HIGHER FREE CHROMIC ACID AND TOTAL HEXAVALENT CHROMATE IN ANODIZING SOLUTION
1-6	6/8/2022	VOUGHT AIRCRAFT INDUSTRIES, INC.	ALL BCA	NONE	TO ALLOW EXTENSION OF FLOW TIME FROM CLASS 5 ANODIZING TO FIRST PRIME COAT OR FUEL TANK COATING FROM 16 TO 48 HOURS.
1-7	6/8/2022	HYTEK FINISHES CO	ALL BCA	NONE	TO ALLOW AN ALTERNATIVE TEMPERATURE RANGE FOR DILUTE CHROMATE SEALING OF PARTS ANODIZED AT 105 F
1-8	6/8/2022	FUJI HEAVY INDUSTRIES; KAJI KINZOKU KOGYU CO LTD	ALL BCA	NONE	TO ASSURE ADHESION OF PAINT ON PARTS ENAMELLED IN DETAIL. TO ENABLE SUBCONTRACTORS TO USE EXISTING FACILITIES
DCNPSO-01991_01	6/8/2022	N/A	N/A	N/A	SODIUM CHROMATE IS DISSOLVED IN WATER (ALONG WITH CHROMIC ACID) TO 45 TO 100 PPM DEGREES. SOLUTION IS ANALYZED FOR CR+6 CONTENT, THEREFORE THE DEGREE OF HYDRATION OF THE ORIGINAL SODIUM CHROMATE DOES NOT AFFECTE THE SOLUTION CONTROL. DUE TO ITS HIGHLY HYGROSCOPIC NATURE, AHYDROUS SODIUM CHROMATE IS EXTREMEMLY DIFFICULT AND COSTLY TO PRODUCE AND STORE.