



**INCREMENTAL CHANGE**

Release Notification Date: 05/09/2024

**SPM 70-00-99 S1173 - CHROMATED CONVERSION COATING - (C03-006)**

**DISCLAIMER**

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HIGHLIGHTS

HIGHLIGHT  
REFERENCE

DESCRIPTION OF CHANGE

tk70-00-99-801-173 [Technical Change: Changed description for consumable C03-006. Also, deleted consumable C03-083 from the procedure.](#)

TASK 70-00-99-801-173

1. Composition.

Description	Consumable No.	Concentration (Initial Mix)
Bonderite M-CR 1200S Aero	C03-006	1.0 oz/US gal (7.5 g/l)

NOTE: The recommended concentration will produce suitable coatings on most alloys. If the desired coating is not obtained, add product in 0.25 oz/gal (1.9 g/l) increments until the desired coating is obtained. Do not exceed 3.0 oz/gal (22.5 g/l).

2. Preparation.

Subtask 70-00-99-809-336

**WARNING: ACID SOLUTIONS ARE VERY ACTIVE AND CAUSE SERIOUS BURNS. AVOID CONTACT WITH SKIN, EYES, AND CLOTHING. IF CONTACT OCCURS, WASH IMMEDIATELY WITH ABUNDANT QUANTITY OF WATER. AVOID BREATHING VAPORS.**

**WARNING: OPERATOR SHOULD WEAR FACE SHIELD, GLOVES, PROTECTIVE CLOTHING, AND PROTECTIVE SHOES.**

- A. Fill the tank 3/4 full with water.
- B. Add the chromate conversion coating Bonderite M-CR 1200S Aero C03-006 slowly and carefully while stirring the solution to mix.
- C. Fill the tank with water to the working level.

D. Stir the solution again to mix and heat to the operating temperature.

3. Composition.

Subtask 70-00-99-809-337

A. Determine the concentration of the chromate conversion coating Bonderite M-CR 1200S Aero C03-006 .

Description	Limits	Recommended Interval
Bonderite M-CR 1200S Aero	0.85-1.15 oz gal (6.5-8.5 g/l)	Weekly
pH of solution	1.3-2.0	Weekly

NOTE: When the concentration is adjusted to produce suitable coatings on a particular alloy or alloys, maintain the concentration within  $\pm 0.15$  oz/gal (1.0 g/l) of the established concentration. Do not exceed 3.0 oz/gal (22.5 g/l).

B. Follow the manufacturer's control procedures to maintain the solution.

4. Regeneration.

Subtask 70-00-99-809-338

- A. Add the correct products/chemicals to keep the solution in the check limits per the manufacturer's instructions.
- B. Losses due to evaporation must be replaced by filling the tank with water to the working level.
- C. Remove the sludge and clean the tank when accumulated solids interfere with processing.
- D. Replace the solution if it loses its effectiveness.

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