

 INCREMENTAL CHANGE

Release Notification Date: 12/27/2022

**SPM 70-00-99 S1219 - CONSUMABLE MATERIALS - SULFURIC ACID ANODIZING AND THIN FILM
 SULFURIC ACID ANODIZING HEXAVALENT CHROMIUM FREE SEALING SOLUTION**

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HIGHLIGHTS

HIGHLIGHT REFERENCE DESCRIPTION OF CHANGE

- tk70-00-99-801-818 Technical Change: Changed procedure title.
- tk70-00-99-801-818 Technical Change: Added Solution Sheet 1219 for a sulphuric acid anodizing hexavalent chromium free sealing solution.

TASK 70-00-99-801-818

1. Commercial Products.

- A. Socosurf TCS is an alternative solution to hexavalent chromium containing sealants applied after anodizing.

2. Composition.

Subtask 70-00-99-350-009

Consumable Product	No.	Concentration (Initial Mix)
Socosurf TCS	C03-124	31 - 41% V/V

3. Preparation

Subtask 70-00-99-350-010

WARNING: REFER TO THE PRODUCT LABEL AND THE MANUFACTURER'S (MATERIAL) SAFETY DATA SHEET (SDS) FOR INSTRUCTIONS ON THE HAZARDS, STORAGE, SAFE HANDLING AND PROPER USE OF THIS PRODUCT.

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

- A. Fill the bottom of the tank with demineralized water.
- B. Add the required quantity of Socosurf TCS C03-124, top with demineralized water up to the optimal fill level and stir.
- C. Prepared solution pH should be between 3.8 and 4 and as follows:
 - (1) Measure the pH when the bath is at operating temperature (35-45°C (95-113°F)).
- D. If the pH is less than 3.8, use ammonia diluted to 5% to increase the pH, and if the pH is more than 4, use sulfuric acid diluted to 5% to decrease the pH.

4. Check.

Subtask 70-00-99-350-011

A. Determine the concentration of bath parameters as follows:

Checks	Limits	Recommended Intervals
Socosurf TCS	31-41% v/v	Weekly
pH	3.8-4.0	Weekly

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

5. Regeneration.

Subtask 70-00-99-350-012

A. If required, follow the manufacturer's regeneration procedures to maintain the solution.

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