

SPM 70-00-99 S1220 - CONSUMABLE MATERIALS - SULPHURIC ACID ANODIZING HEXAVALENT CHROMIUM FREE SEALING SOLUTION

DISCLAIMER

The Incremental Changes published by GE Aviation are considered Instructions for Continued Airworthiness. These Incremental Changes, along with the current Manual revision and published Temporary Revisions, constitute the latest Instructions for Continued Airworthiness.

GE Designated: -CONFIDENTIAL-

The information contained in this document is GE proprietary information and is disclosed in confidence. It is the property of GE and shall not be used, disclosed to others or reproduced without the express written consent of GE, including, but without limitation, it is not to be used in the creation, manufacture, development, or derivation of any repairs, modifications, spare parts, designs, or configuration changes or to obtain FAA or any other government or regulatory approval to do so. If consent is given for reproduction in whole or in part, this notice and the notice set forth on each page of this document shall appear in any such reproduction in whole or part.

This technical data is considered subject to the Export Administration Regulations (EAR) pursuant to 15 CFR Parts 730-774. Transfer of this data by any means to a Non-U.S. Person, whether in the United States or abroad, without the proper U.S. Government authorization (e.g., License, exemption, NLR, etc.), is strictly prohibited.

Copyright (2022) General Electric Company, U.S.A.

HIGHLIGHTS

HIGHLIGHT REFERENCE DESCRIPTION OF CHANGE

tk70-00-99-801-819 Technical Change: Added Solution Sheet 1220 for a sulphuric acid anodizing hexavalent chromium free sealing solution.

TASK 70-00-99-801-819

1. Commercial Products.

- A. Socosurf PACS is an alternative solution to hexavalent chromium containing sealant applied after anodizing.

2. Composition.

Subtask 70-00-99-350-017

| Consumable Product | No. | Concentration (Initial Mix) |
|---|---------|-----------------------------|
| Socosurf PACS | C03-125 | 8-12% (v/v) |
| Hydrogen Peroxide (35% Technical Grade) | C04-309 | 5-7% (v/v) |

NOTE: Other concentration raw materials can be used if the concentration given in table is obtained.

3. Preparation.

Subtask 70-00-99-350-018

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 CONSUMABLE PRODUCTS.

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 PACS C03-125 and hydrogen peroxide C04-309, top with demineralized water up to the optimal fill level and stir.
- C. Prepared solution pH should be between 4.2 and 5.3.
- D. If the pH is less than 4.2, use ammonia diluted to 5% to increase the pH, and if the pH is more than 5.3, use nitric acid diluted to 5% to decrease the pH.

4. Check.

Subtask 70-00-99-350-019

A. Determine the concentration of bath parameters as follows:

| Checks | Limits | Recommended Intervals |
|---|------------|-----------------------|
| Socosurf PACS | 8-12 % v/v | Weekly |
| Hydrogen Peroxide (35% Technical Grade) | 5-7% (v/v) | Twice a week |
| pH | 4.2-5.3 | Weekly |

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

5. Regeneration.

Subtask 70-00-99-350-020

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

GE Designated: - CONFIDENTIAL Subject to the restrictions on the media