INCREMENTAL CHANGE Release Notification Date: 12/27/2022

SPM 70-00-99 S1220 - CONSUMABLE MATERIALS - SULFURIC ACID ANODIZING AND THIN FILM SULFURIC 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-

HIGHLIGHTS

HIGHLIGHT REFERENCE	DESCRIPTION OF CHANGE
tk70-00-99-801-819	Technical Change: Changed procedure title.
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.