



INCREMENTAL CHANGE

Release Notification Date: 08/09/2023

SPM 70-23-15 STRIPPING ANODIZED COATING FROM ALUMINUM

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HIGHLIGHTS

HIGHLIGHT REFERENCE DESCRIPTION OF CHANGE

sk70-23-15-110-301 Technical Change: Changed procedure for stripping anodized coating from aluminum. Also, added the applicable materials.

tk70-23-15-110-030 Technical Change: Changed CAUTION statement from General section.

TASK 70-23-15-110-030

1. General.

CAUTION: COMPLETE REMOVAL OF PROTECTIVE ANODIZED COATING WILL RESULT IN MATERIAL LOSS OF APPROXIMATELY 0.001 inch (0.03 mm) EACH TIME A PART IS STRIPPED. CAUTION MUST BE EXERCISED WHEN STRIPPING PRECISION PARTS.

The following procedure is useful for stripping anodized coating from aluminum parts.

2. Materials.

Subtask 70-23-15-110-301

Description	No.	Operating Temp °F (°C)
Phosphoric Acid-Chromic Acid Mixture	S0012	75-180 (24-82)
Phosphoric Acid-Sodium Molybdate Acid Mixture	S1223	131-140 (55-60)
Nitric Acid Solution	S0001	Ambient

3. Procedure.

Subtask 70-23-15-110-302

A. Using the materials specified, strip the parts as directed in the following steps.

WARNING: HYDROCARBON SOLVENTS ARE FLAMMABLE AND TOXIC. AVOID PROLONGED CONTACT WITH THE SKIN, AND OBSERVE PRECAUTIONS AGAINST FIRE.

- (1) Clean parts per TASK 70-21-01-110-001, Cleaning Method No. 1 - Solvent Degreasing, TASK 70-21-03-160-001, Cleaning Method No. 3 - Steam Cleaning, or as directed by specific Shop Manual Repair.

- (2) Mask areas not to be stripped, per specific Shop Manual procedure.
- (3) Alternative procedure available. Use S0012, mix solution as per TASK 70-00-99-800-012, Solution S0012.
 - (a) Immerse part(s) into solution until anodized protective coating is removed.
 - (b) Thoroughly rinse part(s) with running tap water.
 - (c) Do an inspection of the part(s) for removal of anodize. Re-cycle, if necessary.
- (3) Alternative Procedure. Use S1223, mix solution as per TASK 70-00-99-801-822, Solution A. S1223.
 - (a) Immerse part(s) into solution until anodized protective coating is removed. Do a check every 10 minutes of intervals until anodized protective coating is removed. Do not exceed 40 minutes of immersion in stripping solution.
 - (b) Thoroughly rinse part(s) with running tap water.
 - (c) Use Solution S0001 to clean and de-smut the part as per TASK 70-00-99-800-001 for 30 seconds to 1 minute.
 - (d) Thoroughly rinse part(s) with running tap water.
- (4) Remove masking if applicable.
- (5) Re-rinse with running tap water, if necessary.
- (6) Deleted.
- (7) Deleted.
- (8) Deleted.

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