



## 2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001 or [www.sae.org](http://www.sae.org).

AMS 2472	Anodic Treatment of Aluminum Alloys, Sulfuric Acid Process, Dyed Coating
AMS 2473	Chemical Treatment for Aluminum Alloys, General Purpose Coating
AMS 4037	Aluminum Alloy, Sheet and Plate, 4.4Cu - 1.5Mg - 0.60Mn, (2024; -73 Flat Sheet, -T351 Plate), Solution Heat Treated

## 2.2 ASTM Publications:

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959 or [www.astm.org](http://www.astm.org).

ASTM B 117	Operating Salt Spray (Fog) Testing Apparatus
ASTM B 137	Measurement of Mass of Coating on Anodically Coated Aluminum

## 3. TECHNICAL REQUIREMENTS:

### 3.1 Solutions:

3.1.1 Electrolyte: Shall be an aqueous solution of sulfuric acid of suitable concentration maintained within  $\pm 2$  °F ( $\pm 1$  °C) of the temperature approved in 4.4.2.

3.1.1.1 The nominal concentration of the electrolyte should be 15 to 20% by weight. The temperature should be selected from within the range 64 to 75 °F (18 to 24 °C).

3.1.2 Sealer: Unless otherwise permitted, the sealer shall be an aqueous solution of sodium dichromate or potassium dichromate (See 8.2.9).

### 3.2 Procedure:

3.2.1 Cleaning and Deoxidation: Parts shall have clean surfaces, free from water break, prior to immersion in the anodizing bath. Etching to achieve metal removal is required for cast surfaces.

3.2.1.1 Cleaning materials or products used for surface preparation containing iron, such as steel wool, iron oxide rouge, or steel wire, which may become embedded in the metal and accelerate subsequent corrosion, are prohibited.

3.2.2 Tight electrical contact shall be maintained during the anodic treatment to prevent contact arcing (burning) of parts, but small irregularities of coating at points of electrical contact are acceptable.

3.2.3 Coating: The cleaned parts shall be made the anode(s) in the electrolyte contained in a chemical-resistant tank which may also serve as the cathode. The processing shall be adjusted to obtain the required weight and quality of the coatings. The anodizing current shall be maintained within  $\pm 2$  amperes per square foot ( $\pm 21.5 \text{ A/m}^2$ ) of the nominal value. Alternatively, the anodizing current shall be ramped up over a five minute or other preselected period to the desired final voltage and maintained until the anodic coating reaches the desired thickness. After anodizing, parts shall be rinsed in clean water at ambient temperature.

3.2.4 Sealing: Parts shall be immersed in the sealant solution for a suitable time (See 8.2.9), then rinsed. The rinse shall be thorough, but slight staining resulting from the sealant solution is acceptable. Rinsing is not required if deionized water is used for sealing.

3.2.5 Masking: Areas where anodizing is prohibited shall be masked.

### 3.3 Properties:

Coated parts shall conform to the following requirements:

3.3.1 Coating Weight: The sealed coating weight (See 4.3.2.1), determined in accordance with ASTM B 137, shall be not less than 600 mg/square foot ( $6.5 \text{ g/m}^2$ ).

3.3.1.1 If small parts, such as rivets or machine screws, are anodized in bulk in a container, the specified coating weight shall apply to not less than 75% of the parts treated together, determined by random sampling, but in no case shall any part show uncoated areas.

3.3.2 Corrosion Resistance: Panels (See 4.3.2.2) shall meet the following requirements, determined after exposure for not less than 336 hours to salt spray corrosion test in accordance with ASTM B 117, except that significant surface shall be inclined six degrees from vertical. Areas within 1/16 inch (1.6 mm) of identification markings or of an edge, or at electrode contact marks, shall not be included.

Fifteen scattered spots or pits, none larger than 1/32 inch (0.8 mm) diameter, on a total of 150 square inches ( $968 \text{ cm}^2$ ) of test area from five or more test pieces.

Five scattered spots or pits, none larger than 1/32 inch (0.8 mm) diameter, on any 30 square inches ( $194 \text{ cm}^2$ ) of test area from one or more test pieces.

### 3.4 Touch Up:

Parts on which the anodic coating has been scratched or damaged superficially may be coated using AMS 2473 or another method acceptable to the cognizant engineering organization. Touch-up, unless otherwise specified, shall not exceed 0.5 inch (13 mm) in its longest dimension, except that scratches that are essentially one dimensional (less than 0.03 inches (0.8 mm) wide) may be reworked. The total reworked area shall not exceed 5% of the total surface area.

### 3.5 Quality:

Anodic coating, as received by purchaser, shall be continuous, smooth, adherent, and uniform in appearance, and shall be free from powdery areas, loose films, discontinuities such as breaks or scratches (except at contact points), or other damage or imperfections detrimental to usage of the coating.

## 4. QUALITY ASSURANCE PROVISIONS:

### 4.1 Responsibility for Inspection:

The coating processor shall supply all samples for processor's tests and shall be responsible for the performance of all required tests. Parts, if required for tests, shall be supplied by purchaser. Processor may utilize his own or any other inspection facilities or services acceptable to purchaser. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that processing conforms to specified requirements.

### 4.2 Classification of Tests:

4.2.1 Acceptance Tests: Quality (3.5) is an acceptance test and shall be performed on each lot.

4.2.2 Periodic Tests: Coating weight (3.3.1), corrosion resistance (3.3.2), and tests of cleaning and processing solutions (See 8.3) to ensure that the anodic coating will conform to specified requirements are periodic tests and shall be performed at a frequency selected by the processor unless frequency of testing is specified by purchaser.

4.2.3 Preproduction Tests: All technical requirements are preproduction tests and shall be performed prior to or on the initial shipment of processed parts to a purchaser, when a change in material and/ or processing requires approval by the cognizant engineering organization (See 4.4.2), and when purchaser deems confirmatory testing to be required.

### 4.3 Sampling and Testing:

Shall be not less than the following; a lot shall be all parts of the same part number, processed in a continuous series of operations (3.2.4 to 3.2.5, inclusive), in not longer than 24 consecutive hours, and presented for processor's inspection at one time.

4.3.1 For Acceptance Tests: Shall be as shown in Table 1.

TABLE 1 - Sampling for Acceptance Testing

Number of Parts in Lot			Quality
Up	to	7	All
8	to	15	7
16	to	40	10
41	to	110	15
111	to	300	25
301	to	500	35
Over		500	50

4.3.2 For Periodic Tests: Sample quantity and frequency shall be selected at the discretion of the processor, unless otherwise specified, except for corrosion testing, which shall be carried out at a frequency not less than monthly.

4.3.2.1 Coating Weight: Shall be determined on representative parts when size and shape permit accurate determination of surface area. If parts are of such size and shape that surface area cannot be determined readily, coating weight determinations shall be made on separate test panels 0.025 to 0.063 inch (0.64 to 1.60 mm) thick and not less than 3 inches (76 mm) square fabricated from AMS 4037 aluminum alloy.

4.3.2.1.1 Separate test panels, if used, shall be processed with the work they represent.

4.3.2.2 Corrosion Resistance: Shall be determined on separate test panels 0.025 to 0.63 inch (0.64 to 1.60 mm) thick and not less than 3 x 10 inches (76 x 254 mm) in width and length fabricated from AMS 4037 aluminum alloy.

4.4 Approval:

4.4.1 Processes, control factors, or preproduction sample part or test panel, or any combination thereof specified, shall be approved by the cognizant engineering organization before production parts are supplied.

4.4.2 Processor shall make no significant change to materials, processes, or control factors from those on which the approval was based, unless the change is approved by the cognizant engineering organization. A significant change is one which, in the judgment of the cognizant engineering organization, could affect the properties or performance of the parts.

4.4.3 Control factors for anodizing shall include, but not be limited to, the following:

Cleaning procedure, including the compositions and temperatures of the baths used

Deoxidation process

Anodizing bath composition (including impurity limits), temperature, and agitation method

Rate of voltage rise, anodizing voltage, and time of anodizing

Sealing solution composition (including impurity limits), temperature, and pH

Purity of water used for sealing and rinsing

Periodic test plan.

#### 4.5 Reports:

The processor of coated parts shall furnish with each shipment a report stating that the parts have been processed and tested in accordance with specified requirements and that they conform to the acceptance test requirements. This report shall include the purchase order number, lot number, AMS 2471F, part number, and quantity.

#### 4.6 Resampling and Retesting:

4.6.1 If any lot acceptance test fails to meet specified requirements, parts in that lot may be stripped by a method acceptable to purchaser which does not roughen, pit or embrittle the basis metal or adversely affect part dimensions, pretreated, coated, post-treated as defined herein and tested. Alternatively, all parts in the lot may be inspected for the nonconforming attribute, and the nonconforming parts may be stripped by a method acceptable to purchaser that does not pit, roughen, embrittle the basis metal, or adversely affect part dimensions, pretreated, recoated, post-treated as defined herein, and tested. After any stripping and recoating, parts shall meet the dimensional requirements of the drawing.

4.6.2 If results of any periodic test fail to meet specified test requirements, the process is nonconforming. No additional parts shall be plated until the process is corrected and new specimens are coated and tested. Results of all tests shall be recorded and, when requested, reported. Purchaser shall be notified of all parts coated since the last acceptable test.

#### 5. PREPARATION FOR DELIVERY:

5.1 Coated parts shall be handled and packaged to ensure that the required physical characteristics and properties of the coating are preserved.

5.2 Packages of coated parts shall be prepared for shipment in accordance with commercial practice and in compliance with applicable rules and regulations pertaining to the handling, packaging, and transportation of the coated parts to ensure carrier acceptance and safe delivery.

#### 6. ACKNOWLEDGMENT:

A processor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.

#### 7. REJECTIONS:

Parts on which the coating does not conform to this specification, or to modifications authorized by purchaser, will be subject to rejection.