



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

CHROMATE FINISH FOR ZINC DIE CASTING

SJ-M10P9000-AA
SJ-M10P9001-AA

1. SCOPE

The materials defined by this specification are chromate finishes for unplated zinc die castings where a corrosion resistant surface is needed.

2. APPLICATION

These specifications were released originally for material used either in locations where they are invisible or where their appearance is adequate.

3. REQUIREMENTS

3.1 STATISTICAL PROCESS

Suppliers must conform to the requirements of Ford Quality System Standard Q-101. A mutually acceptable Control Plan as described therein is required for material/source approval. Appropriate statistical tools must be used to analyze process/product data so that variation in the final product is continuously reduced.

3.2 FINISH

3.2.1 SJ-M10P9000-AA

An uninterrupted and uniform chromate coating of any colour, unless otherwise specified in the drawing, is required.

3.2.2 SJ-M10P9001-AA (silver finish)

An uninterrupted and uniform bright chromate coating with silver gloss, the appearance of which is at least as good as that of the uncoated die casting, is required.

3.3 METHOD

The chromate finish may be produced by any procedure which ensures coatings in accordance with the requirements of this specification possessing good adhesion properties.

Date	Release No.	Release/Revision
1992 03 31	C10176266	Revised & Retyped.
1989 07 31	B/031526TC	Retyped. Minor changes. Was 3 sheets.
1971 09 02	2G/PG0884/JP	Released

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3.4 SALT SPRAY RESISTANCE, min (ASTM B-117)

SJ-M10P9000-AA
SJ-M10P9001-AA96 h
48 h

Parts shall be considered as failed, if more than 6 corrosion spots per 1000 cm² or any corrosion spots larger than 1.5 mm in diameter appear on significant surfaces.

3.5 SUPPLIER'S RESPONSIBILITY

All materials supplied to this specification must be equivalent in all characteristics to the material upon which approval was originally granted.

Prior to making any changes in the properties, composition, construction, colour, processing or labelling of the material originally approved under this specification, whether or not such changes affect the materials' ability to meet the specification requirements, the supplier shall notify Purchasing, Toxicology and the affected Materials Engineering activity of the proposed changes and obtain the written approval of the Materials Engineering activity. Test data, test samples and a new code identification are to be submitted with the request.

Substance restrictions imposed by law, regulations or Ford apply to the materials addressed by this document. The restrictions are defined in Engineering Material Specification WSS-M99P9999-A1, unless a different suffix (e.g., A2 or A3) is specified on the engineering document for the application.

4. APPROVAL OF MATERIALS

Materials defined by this specification must have prior approval by the responsible Materials Engineering activity. Suppliers desiring approval of their materials shall first obtain an expression of interest from the affected Purchasing, Design and Materials Engineering activity. Upon request, the Supplier shall submit to the affected Materials Engineering activity a completed copy of their laboratory test reports, signed by a qualified and authorised representative of the test facility, demonstrating full compliance with all the requirements of this specification (test results, not nominal values), the material designation and code number, and test specimens for Ford evaluation. Ford's engineering approval of a material will be based on its performance to this specification and on an assessment of suitability for intended processes and/or applications. Upon approval, the material will be added to the Engineering Material Approved Source List.