



AEROSPACE STANDARD

AS6450™**REV. B**

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Superseding AS6450A

Lubricant Application, Solid Film, Heat Cured, Potable Water,
Hydraulic, and Other Fluid Systems

RATIONALE

This document has been determined to contain basic and stable technology which is not dynamic in nature.

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1. SCOPE

This SAE Aerospace Standard (AS) establishes the surface pretreatment, temperature, and baking time required to cure AS6449 Type I and Type II solid film lubricant (SFL) when it is applied over the surfaces of manufactured parts of various metals. Application method may be dipping or spraying.

2. REFERENCES

The following publications form a part of this document to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order. In the event of conflict between the text of this document and references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

2.1 SAE Publications

Available from SAE International, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or 724-776-4970 (outside USA), www.sae.org.

AMS2486	Conversion Coating of Titanium Alloys Fluoride-Phosphate Type
AMS2488	Anodic Treatment - Titanium and Titanium Alloys Solution pH 13 or Higher
AMS2700	Passivation of Corrosion Resistant Steels
AMS-QQ-P-416	Plating, Cadmium (Electrodeposited)
AS6449	Solid Film Lubricant for Fluid Fittings in Oxygen, Potable Water, Hydraulic, and Other Systems

2.2 ASTM Publications

Available from ASTM International, 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19428-2959, Tel: 610-832-9585, www.astm.org.

ASTM D1125 Standard Test Methods for Electrical Conductivity and Resistivity of Water

ASTM D2510 Standard Test Method for Adhesion of Solid Film Lubricants

ASTM D6123 Standard Specification for Pressure-Sensitive Tape for Light-Duty Packaging and General Purpose Masking

ASTM F22 Standard Test Method for Hydrophobic Surface Films by the Water-Break Test

2.3 PRI Publications

Available from Performance Review Institute, 161 Thorn Hill Road, Warrendale, PA 15086-7527, Tel: 724-772-1616, www.pri-network.org.

PD2101 Aerospace Quality Assurance , Product Standards Qualification Requirements - Fluid Distribution System

AC7108/1 Nadcap Audit Criteria for Painting and Dry Film Coating

AC7112/2 Nadcap Audit Criteria for Fittings and Other Machined Components

AC7112/4 Nadcap Audit Criteria for Hose Assemblies

2.4 U.S. Government Publications

Available from the Document Automation and Production Service (DAPS), Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094, Tel: 215-697-9495, <https://assist.daps.dla.mil/quicksearch/>.

MIL-A-8625 Anodic Coatings, for Aluminum and Aluminum Alloys

3. REQUIREMENTS

3.1 Manufacturer Qualification

A manufacturer coating product in accordance with this specification shall be controlled to requirements of PD2101 and AC7112/2 or AC7112/4 as applicable. Accreditation shall implement AC7108/1 requirements as applicable.

NOTE: Applicators must be certified to Company Specifications. The applicators must be proficient and have a good knowledge of materials, tools, methods, and processes. The applicator must know the critical areas to be coated and the acceptable final appearance of the coated parts. See Appendix.

3.2 General Pretreatment and Application Instructions

Do not touch the surfaces to be coated with bare hands at any time. Stir the lubricant until thoroughly mixed, using a low shear mixing blade. A mechanical paint shaker may be used, but is not recommended for waterborne coatings as excessive foaming may occur.

Pretreatment, application, and cure requirements shall be as follows, unless otherwise specified on the drawing: