



AEROSPACE STANDARD	AS7109™/2	REV. B
	Issued 1995-03 Revised 2005-09 Cancelled 2017-06 Superseded by PRI AC7109/2	
Nadcap Requirements for Vapor Deposited Coatings		

RATIONALE

AS7109/2B is being cancelled and superseded by PRI AC7109/2.

CANCELLATION NOTICE

This document has been declared "CANCELLED" as of June 2017 and has been superseded by PRI AC7109/2. By this action, this document will remain listed in the Numerical Section of the Aerospace Standards Index noting that it is superseded by PRI AC7109/2. Cancelled specifications are available from SAE.

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1. SCOPE:

This SAE Aerospace Standard (AS) is to be used as a supplement to AS7109. In addition to the requirements contained in AS7109, the requirements contained herein shall apply to suppliers seeking Nadcap Coatings accreditation who are engaged in vapor deposit processes, except diffusion coatings.

1.1 Class Qualification shall include one of the following:

1.1.1 Class A Physical Vapor Deposit (PVD)

- a. Sputter
- b. Electron Beam

1.1.2 Class B Chemical Vapor Deposit (CVD)

2. APPLICABLE DOCUMENTS:

The following publications form a part of this standard 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.

2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Telephone: (724) 776-4841, Web address: <http://www.sae.org>.

AS7102	Nadcap - Requirements for Heat Treating
AS7108	Nadcap - Requirements for Chemical Processing
AS7109	Nadcap - Requirements for Coatings
AS7109/4	Nadcap - Requirements for Stripping
AS7109/6	Nadcap - Requirements for Plating of Coated Parts
AS7109/7	Nadcap - Requirements for Heat Treating for Suppliers of Coatings

3. OPERATOR TRAINING AND CERTIFICATION:

- 3.1 All of the designated PVD/CVD operators shall be currently certified (when required by the customer) or otherwise approved in accordance with supplier procedures.

4. PROCESS PLANNING:

- 4.1 Coating trials shall be conducted prior to initial production to insure the coating will meet material/process specifications as applicable.
- 4.2 The supplier shall have approved technical plans for hardware as required by customer.

5. MANUFACTURING:

- 5.1 The supplier shall have detailed work instructions describing each step in the PVD/CVD coating process:
- Preparation of coating materials before coating parts
 - Methods of cleaning and preparing parts before coating
 - Fixturing and masking techniques
 - Coating application procedure including all process parameters and their limits including deposition rate on part or mounted sample tab.
 - Details of post coating chemical and thermal treatments