



AEROSPACE STANDARD

AS7109™/6**REV. B**

Issued	1995-03
Revised	2005-09
Cancelled	2017-06

Superseded by PRI AC7109/6

Nadcap Requirements for Plating of Coated Parts

RATIONALE

AS7109/6B is being cancelled and superseded by PRI AC7109/6.

CANCELLATION NOTICE

This document has been declared "CANCELLED" as of June 2017 and has been superseded by PRI AC7109/6. By this action, this document will remain listed in the Numerical Section of the Aerospace Standards Index noting that it is superseded by PRI AC7109/6. Cancelled specifications are available from SAE.

SAE Technical Standards Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user."

SAE reviews each technical report at least every five years at which time it may be revised, reaffirmed, stabilized, or cancelled. SAE invites your written comments and suggestions.

Copyright © 2017 SAE International

All rights reserved. No part of this publication may be reproduced, stored in a retrieval system or transmitted, in any form or by any means, electronic, mechanical, photocopying, recording, or otherwise, without the prior written permission of SAE.

TO PLACE A DOCUMENT ORDER: Tel: 877-606-7323 (inside USA and Canada)
Tel: +1 724-776-4970 (outside USA)
Fax: 724-776-0790
Email: CustomerService@sae.org
<http://www.sae.org>

SAE WEB ADDRESS:

Full document details: SAE AS7109_6B

SAE values your input. To provide feedback on this Technical Report, please visit <http://standards.sae.org/AS7109/6B>

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 plating of coated parts. Demonstrated compliance (as described in AS7003) to AS7108 satisfies the requirements contained herein.

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>.

AS7003	Nadcap - Program Operations
AS7108	Nadcap - Requirements for Chemical Processes
AS7109	Nadcap - Requirements for Coatings

2.2 ASTM Publications:

Available from ASTM, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA, 19428-2959, Telephone: (610) 832-9585, Web address: <http://www.astm.org>.

ASTM B 244	Standard Test Method for Measurement of Thickness of Anodic Coatings on Aluminum and of Other Nonconductive Coatings on Nonmagnetic Basis Metals with Eddy-Current Instruments
ASTM B 487	Standard Test Method for Measurement of Metal and Oxide Coating Thickness by Microscopical Examination of a Cross Section
ASTM B 499	Standard Test Method for Measurement of Coating Thicknesses by the Magnetic Method: Nonmagnetic Coatings on Magnetic Basis Metals
ASTM B 504	Standard Test Method for Measurement of Thickness of Metallic Coatings by the Coulometric Method
ASTM B 530	Standard Test Method for Measurement of Coating Thicknesses by the Magnetic Method Electrodeposited Nickel Coatings on Magnetic and Nonmagnetic Substrates
ASTM B 567	Standard Test Method for Measurement of Coating Thickness by Beta Backscatter Measurements
ASTM B 568	Standard Test Method for Measurement of Coating Thickness by X-Ray Spectrometry

3. EQUIPMENT AND FACILITIES:

- 3.1 Tanks shall be free of evidence of leaking.
- 3.2 Tanks and work surfaces shall be maintained sufficiently free of corrosion and chemical spillage.
- 3.3 Spray and rinse tanks shall be clean, clear, free-running or monitored for contamination levels, and situated in a sequence to prevent cross contamination of process tanks to assure adequate neutralization and/or removal of process chemicals.
- 3.4 Process and rinse tanks shall be situated such that hardware can be maintained wet, from final cleaning and activation through the process to the final rinse, without interruption.
- 3.5 Tanks with temperature range requirements shall be equipped with controls and over- and under-temperature alarms.