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Rework/Repair Handbook to Address the Implications of Lead-Free Electronics and Mixed Assemblies in Aerospace and High Performance Electronic Systems

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Rework/Repair Handbook to Address the Implications of Lead-Free Electronics and Mixed Assemblies in Aerospace and High Performance Electronic Systems

GEIA-HB-0005-3

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**Rework/Repair Handbook to Address the Implications of Lead-Free
Electronics and Mixed Assemblies in Aerospace and High
Performance Electronic Systems**

GEIA-HB-0005-3

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Contents

Foreword	iii
Introduction	iii
1.0 Scope	1
2.0 References	1
3.0 Terms and Definitions	2
4.0 Symbols and Abbreviated Terms	6
5.0 Pb-Free Concerns	8
5.1 Reliability	8
5.1.1 Mixed Metallurgy Reliability	8
5.1.1.1 Pb-free Terminations in SnPb Joints	9
5.1.1.2 SnPb Terminations in Pb-free Joints	9
5.1.1.3 Bismuth (Bi)	9
5.1.1.3.1 SnPb Finish in SnBi Solder Alloy	9
5.1.1.3.2 SnBi Finish in SnPb Solder Alloy	9
5.2 Configuration Management	9
5.3 Risk Management	10
5.4 Tin Whiskers	10
5.5 Copper Dissolution (Erosion)	10
6.0 Materials	11
6.1 Solder	11
6.1.1 Solder Alloys	11
6.1.2 Solder Forms	11
6.1.2.1 Solder Wire	11
6.1.2.2 Solder Paste	12
6.1.2.3 Solder Preforms	12
6.2 Fluxes	12
6.3 Piece Parts	12
6.3.1 Termination Finishes	12
6.3.2 Area Arrays (BGA, CSP, etc.)	13
6.4 Printed Circuit Boards	13
6.4.1 Laminate Material	13
6.4.2 Surface Finish	13
6.5 Conformal Coatings	14
7.0 Soldering Equipment	14
7.1 Hand Soldering Equipment	14
7.1.1 General Hand Soldering Equipment Considerations	14
7.1.2 Tip Selection	15
7.1.3 Soldering Iron Tip Life	15
7.2 Fountain Soldering	16
7.3 Convective Soldering Equipment	18
7.3.1 Thermal Profile Issues	18
8.0 General Rework/Repair Considerations	19
8.1 Rework/Repair Procedure Order of Precedence	19
8.2 Technician Training	20
8.3 Pb-Free Rework/Repair Considerations	20
8.3.1 General Process Considerations	20
8.3.2 Solder Processing Considerations	21
8.3.3 Flux Considerations	21
9.0 Pre-Rework/Repair Processes	22
9.1 Alloy Identification	22
9.1.1 IPC/JEDEC J-STD-609	22
9.1.2 X-Ray Fluorescence (XRF)	24

9.1.3 Pb Swabs	24
9.2 Piece Part and CCA Preparation.....	24
9.2.1 Piece Part Preparation.....	25
9.2.1.1 Dry Bake of Moisture Sensitive Piece Parts	25
9.2.1.2 Hot Solder Dip for Tin Whisker Mitigation	25
9.2.2 CCA Preparation.....	25
9.2.2.1 Conformal Coating Removal.....	25
9.2.2.2 Preheating of CCAs Prior to Rework/Repair.....	25
10.0 Rework/Repair Processes	26
10.1 Conductive Hand Soldering.....	26
10.2 Convective Soldering Process	27
10.2.1 Solder Paste Handling	27
10.2.2 Paste Printing.....	27
10.2.3 Reflow Process	28
10.2.3.1 Process Considerations	28
10.2.3.1.1 Prebake	28
10.2.3.1.2 Machine Configurations.....	28
10.2.3.1.3 Profile Development	28
10.2.3.1.4 Site Preparation.....	29
10.2.3.1.5 Rework/Repair Concerns	29
10.2.3.1.6 Process Validation.....	30
11.0 Post-Rework/Repair Processes	30
11.1 Cleaning	30
11.2 Inspection	30
11.3 Reapplication of Conformal Coating.....	30
Annex A – Termination Finishes	31
Annex B – Tin Whiskers.....	33

Foreword

This handbook is intended to facilitate the development of procedures and processes for use when undertaking the rework/repair of Aerospace and High Performance (AHP) electronics systems. It is intended to contain sufficient information to support the processing of equipment that incorporates either Tin-Lead (SnPb) or Lead-free (Pb free) solder alloy, SnPb or Pb-free piece parts and printed wiring board finishes, or a combination thereof.

This handbook may be used by original equipment manufacturers (OEMs), contract manufacturers (CMs) and commercial depots. This document may also be used by Department of Defense (DoD) personnel performing rework/repair at the Organizational (O) level, Intermediate (I) back shop level, and Depot (D) overhaul level.

The Aerospace Industries Association (AIA), Avionics Maintenance Conference (AMC), and Government Electronics and Information Technology Association (GEIA) formed the Lead-free Electronics in Aerospace Project Working Group (LEAP WG). The purpose of this Working Group is to generate a series of industry standards and handbooks intended to facilitate the maintenance of suitable equipment quality and reliability standards within the AHP industries during the general industry migration to Pb-free.

This handbook is intended to work in concert with other GEIA documents, including GEIA-STD-0005-1, GEIA-HB-0005-1, GEIA-STD-0005-2, and GEIA-HB-0005-2 (described herein).

This handbook may be referenced in proposals, requests for proposals, work statements, contracts, and other aerospace and high performance industry documents.

Introduction

Recent directives and legislation by nations around the world mandated elimination of Lead and other hazardous material usage in sectors of the electronics industry by 2006. In electronics, Lead (Pb) has been a primary component of Tin-Lead (SnPb) solder used in piece part attachment and PWB finishes for over 50 years, and more recently in the solder spheres for attachment of ball-grid-array (BGA) packages. Since there is no “drop-in” replacement for SnPb solder alloys, multiple Pb-free alloys have emerged in the manufacturing industry as replacements. These multiple replacement alloys are being used in PWB finish, piece part termination finish and as solder alloys, leaving the rework/repair technician with literally hundreds of possible combinations of metallurgy in the finished repair.

The majority of the Pb-free alloys being considered have melting temperatures 61 to 79°F (34 to 44°C) higher than that of SnPb eutectic solder. These higher Pb-free processing temperatures require significant changes to convective rework/repair procedures and minor adjustments in conductive hand soldering procedures to ensure that quality products will be produced.

Another major concern is the potential re-emergence of Tin Whiskers as an additional equipment failure mechanism. Tin Whiskers are electrically conductive, crystalline structures of Sn that grow under compressive force from surfaces where Sn [especially electroplated Sn] is used as a final finish. Tin Whiskers have been observed to grow to lengths of several millimeters (mm). Numerous electronic system failures have been attributed to short circuits caused by Tin

Whiskers that bridge closely-spaced circuit elements. Tin Whiskers have been successfully suppressed for decades by the addition of Pb to Sn plating used in high reliability applications. With the global shift to Pb-free solders, Tin Whiskers have re-emerged as a major concern to reliability. GEIA-STD-0005-02 further discusses Tin Whisker issues and mitigation techniques.

This document will provide guidance to the organization performing rework/repair on various combinations of SnPb, Pb-free and mixed technology assemblies likely to be seen as the global transition to Pb-free solder continues. The organization typically consists of program management, procurement, process engineering, bench technician, and quality assurance personnel.

Procedurally, conductive Pb-free rework/repair is similar to that of SnPb. However, adjustments must be made to accommodate the generally poorer wetting ability of Pb-free solders as well as differences in appearance and inspection criteria. Convective rework/repair will require redevelopment of profiles to accommodate the higher melting temperature of Pb-free alloys. Also, Pb-free rework/repair has a tighter process window leaving a smaller margin for error in comparison to SnPb. With the proper materials, preparation, skill, and the use of fundamentally sound procedures, Pb-free rework/repair can be successfully and reliably accomplished. [1]

¹ <http://www.solder.net/leadfreerepair.asp>

1.0 Scope

This document provides technical background, procurement guidance, engineering procedures, and guidelines to assist organizations reworking/repairing aerospace and high performance electronic systems, whether they were assembled or previously reworked/repared using traditional alloys such as SnPb or Pb-free alloys, or a combination of both solders and surface finishes. This document contains a review of known impacts and issues, processes for rework/repair, focused to provide the technical structure to allow the repair technician to execute the task.

This document focuses on the removal and replacement of piece parts. For the purposes of this document, the term “Rework/Repair” is used as applicable.

NOTE: The information contained within this document is based on the current knowledge of the industry at the time of publication. Due to the rapid changing knowledge base, this document should be used for guidance only.

2.0 References

The following documents contain provisions that, through reference in this text, are needed for the understanding of this handbook. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. For undated references, the latest edition of the normative document referred to applies. Unless a specific revision is specified, all referenced documents are per the current and latest revision available at the time of this Handbook’s release.

GEIA-STD-0005-1	Performance Standard for Aerospace and High Performance Electronic Systems Containing Lead-free Solder
GEIA-STD-0005-2	Standard for Mitigating the Effects of Tin in Aerospace and High Performance Electronic Systems
GEIA-STD-0005-3	Performance Testing for Aerospace and High Performance Electronic Interconnects Containing Pb-free Solder and Finishes
GEIA-HB-0005-2	Technical Guidelines for Aerospace and High Performance Electronic Systems Containing Lead-free Solder
GEIA-HB-0005-1	Program Management / Systems Engineering Guidelines for Managing the Transition to Lead-Free Electronics

Industry Standards (IPC/JEDEC Standards)

J-STD-001	Requirements for Soldered Electrical and Electronic Assemblies
J-STD-004	Requirements for Soldering Fluxes
J-STD-006	Requirements for Electronic Grade Solder Alloys and Fluxed and Non-Fluxed Solid Solders for Electronic Soldering Applications
J-STD-020	Moisture/Reflow Sensitivity Classification for Nonhermetic

J-STD-033	Solid State Surface Mount Devices Handling, Packing, Shipping and Use of Moisture/Reflow Sensitive Surface Mount Devices-Includes Amendment 1
J-STD-609	Marking and Labeling of Components, PCBs and PCBA's to Identify Lead (Pb), Pb-Free and other Attributes
IPC-A-610	Acceptability of Electronic Assemblies
IPC 7711/7721	Rework of Electronic Assemblies/Repair and Modification of Printed Boards and Assemblies
IPC 4101	Specification for Base Materials for Rigid and Multilayer Printed Boards-Supersedes IPC-L-108, L-109, L-112, L-115, AM-361
ARINC Project 671	Guidance for the Transition to Lead-Free Soldering, Maintenance and Repair

Government Documents

RoHS Directive	DIRECTIVE 2002/95/EC OF THE EUROPEAN PARLIAMENT AND OF THE COUNCIL of 27 January 2003 on the restriction of the use of certain hazardous substances in electrical and electronic equipment (commonly known as the RoHS) (Restriction of Hazardous Substances Directive)
WEEE Directive	DIRECTIVE 2003/108/EC OF THE EUROPEAN PARLIAMENT AND OF THE COUNCIL of 8 December 2003 amending Directive 2002/96/EC on waste electrical and electronic equipment (WEEE)

Other Documents

- Altera Corporation White Paper, "Challenges in Manufacturing Reliable Lead Free Components;" February 2004, ver. 1.0
- Altera Corporation Application Note 353, "Reflow Soldering Guidelines for Lead-Free Packages," July 2004, ver.1.0
- Peter Biocca (Kester) White Paper, "Lead-free hand-soldering - ending the nightmares," http://www.emsnow.com/cnt/files/White%20Papers/biocca_hand_soldering.pdf
- Altera Corporation Application Note 81, "Reflow Soldering Guidelines for Surface-Mount Devices," June 2002, ver. 4

3.0 Terms and Definitions

For purposes of this document, the following terms and definitions apply:

Alloy Composition is stated as weight in percent. For instance 63Sn-37Pb corresponds to a mixture of 63% by weight of Tin (Sn) and 37% by weight of Lead (Pb).

Assemblies are electronic items that require electrical attachments, including soldering of wires or piece part terminations; examples include circuit cards and wire harnesses.

Backwards Compatibility refers to Pb-free materials compatible with a SnPb process.

Ball Grid Array (BGA) is a surface mount package type that uses a grid of solder balls arranged in an array to provide direct electrical interconnection between the part substrate and the circuit board.

Coefficient of Thermal Expansion (CTE) is the linear dimensional change of a material per unit change in temperature.

Conductive refers to the use of a contact heat source such as a soldering iron, hot bar, or resistance to transfer heat to the assembly.

Convective refers to the use of a non-contact heat source usually heated air, Nitrogen or infrared light to transfer heat to the assembly.

Copper Dissolution is the excessive loss of copper from plated-through-hole barrels and pads caused by wave or solder fountain processing primarily with high Tin (Sn) content solders.

Critical item or function, if defective, will result in the system's inability to retain operational capability, meet primary objective, or affect safety.

Customer refers to an entity or organization that (a) integrates a piece part, soldered assembly, unit, or system into a higher level system, (b) operates the higher level system, or (c) certifies the system for use. For example, this may include end item users, integrators, regulatory agencies, operators, original equipment manufacturers (OEMs), and subcontractors.

Delamination is a separation between plies within a base material, between a base material and a conductive foil, or any other planar separation with a printed board that may propagate under thermal stress.

Depot Level Maintenance (D) is maintenance requiring major overhaul or a complete rebuilding of parts, assemblies, subassemblies, and end items, including the manufacture of parts, modifications, testing, and reclamation as required. Depot maintenance serves to support lower categories of maintenance by providing technical assistance and performing that maintenance beyond their responsibility.

Dissolution is the process in which one substance is dissolved in another by chemical action.

Electroless Nickel / Immersion Gold (ENIG) is a two technology process for the application of a desired finish where Nickel is applied using Electroless plating, requiring the presence of a proper reducing agent in a plating bath that converts the metal salts into metal and deposits them onto the substrate. The immersion plating process deposits a new metal surface (Gold) by replacing the base metal; in this process, plating stops when the surface of the base metal is completely covered, thus only a limited coating thickness can be obtained through the immersion process. The control of the kinetics associated with both processes is vital to plating results.

Eutectic (Solder) is the alloy composition at which a solder alloy melts/freezes completely without going through a pasty (partially solid) phase.

High Performance System requires continued performance or performance on demand, or equipment down time cannot be tolerated, or end-use environment may be uncommonly harsh, and the equipment must function when required, such as life support or other critical systems.

Intermediate Level Maintenance (I) includes limited repair of commodity-orientated piece parts and end items, job shop, bay, and production line operations for special mission requirements; repair of printed circuit boards, software maintenance, and fabrication or manufacture of repair parts, assemblies, piece parts. Intermediate maintenance consists of repair of aircraft and engine components, WRAs, and LRUs forwarded to the Intermediate level {Navy (AIMD) or USAF Back Shops} by the organizational level flight-line activities. WRA and LRU repair is accomplished by the removal, troubleshooting, and replacement of faulty SRA and SRU, pieces, and parts within the WRA/LRU.

Lead (Pb) in this document, if the element “Lead” is implied, it will be stated as either Pb or as Lead (Pb).

Lead-Free (Pb-free) is defined as less than 0.1% by weight of Pb in accordance with Waste Electrical and Electronic Equipment (WEEE) guidelines.

Lead-Free Control Plan (LFCP) refers to an aerospace or military system supplier’s document that defines the processes that assure the plan owners, their customers, and all other stakeholders that aerospace and high performance high-reliability electronics systems containing Pb-free solder will continue to be reliable, safe, producible, affordable, and supportable. Technical guidance for a LFCP can be found in GEIA-HB-0005-1.

Line Replaceable Unit (LRU) is a black box of electronics removed and replaced at the flight-line level.

Liquidus is the minimum temperature at which all components of a mixture (such as an alloy) can be in a liquid state. Below liquidus, the mixture will be partly or entirely solid.

Measling is a condition that occurs in laminated base material in which internal glass fibers are separated from the resin at the weave intersection. This condition manifests itself in the form of discrete white spots or “crosses” that are below the surface of the base material.

Organic Solderability Preservative (OSP) is a thin organic compound that selectively bonds with Copper (Cu) used to preserve the solderability of bare Cu on printed wiring boards (PWB's).

Organizational Level Maintenance (O) is maintenance normally performed by an operating unit on a day-to-day basis in support of its own operations. Organizational-level maintenance typically includes "inspections," "servicing," "handling," and "preventive maintenance" and is limited to the replacement of electronics assemblies at the WRA and LRU (black box) level of

major aircraft and engine components. An exception is U.S. Navy ships, where troubleshooting and piece parts level repair are accomplished at the Organizational level.

Pb-free Tin is any Tin alloy with <3% Lead (Pb) content by weight. This means that some Pb-free finishes other than Pb-free Tin, such as Tin-Bismuth and Tin-Copper, are considered to be “Tin” for the purposes of this handbook. Many of these alloys have not been assessed for whiskering behavior.

Pb-free Tin Finish is Pb-free Tin final finishes or underplating either external or internal to a device, PWB, or other hardware. This includes all terminations and surfaces, even those coated, encapsulated, or otherwise not exposed. It may include finishes on electrical piece parts, mechanical piece parts, and PWBs. It does not include Pb-free bulk solders, assembly materials, solder balls, or those devices where the Pb-free Tin finish has been completely replaced.

Piece Part is an electronic component that is not normally disassembled without destruction and is normally attached to a printed wiring board to perform an electrical function.

Procurement is the process of obtaining services, supplies, and equipment.

Plated-Through-Hole (PTH) is a Cu-plated hole in a circuit board used to accommodate a through-hole piece part termination.

Quality Assurance is a planned and systematic set of activities to ensure that requirements are clearly established and that the defined process or product complies with these requirements.

Repair is the act of restoring the functional capability of a defective article in a manner that precludes compliance of the article with applicable drawings or specifications.

Rework is the act of reprocessing non-complying articles, through the use of original or equivalent processing in a manner that assures full compliance of the article with applicable drawings or specifications.

Rework/Repair is the term used in this document where the processes identified apply to either rework or repair.

SAC (Tin Silver Copper) refers to the family Pb-free alloys containing Tin (Sn), Silver (Ag), and Copper (Cu) used in surface mount technology or sometimes in wave solder processes. The alloys typically have a composition near the eutectic (Sn3.5Ag0.9Cu).

Shop Replaceable Assembly (SRA) is a component assembly inside a black box (LRU or WRA) typically consisting of individually replaceable circuit cards.

Shop Replaceable Unit (SRU) is a component assembly inside a black box (LRU or WRA) typically consisting of individually replaceable circuit cards.

SnCu (Tin Copper) solder or alloy refers to Pb-free alloys that are comprised of Tin-Copper (Sn-0.7Cu).

SnCuNi (Tin Copper Nickel) solder or alloy refers to Pb-free Tin-Copper with trace Nickel concentration alloy (Sn0.7Cu0.05Ni). Some formulations also include other minor additions such as Germanium (Ge).

SnPb (Tin Lead) solder or alloy refers to Tin-Lead alloys at or near the eutectic composition (63Sn37Pb).

Soldered Assembly is an assembly of two or more basic parts interconnected by a solder alloy. A Pb-based soldered assembly is one in which the solder alloys are solely Pb-based. A Pb-free soldered assembly is one in which the solder alloys are solely Pb-free.

System is one or more units that perform electrical function(s).

Termination is the term used in this document to identify the area to be soldered of the piece part termination, castellations, or metallized surface(s) of an electronic device.

Ternary Alloy is a solder alloy containing three component metals.

Tg refers to the glass transition temperature of laminate material.

High Tg refers to the glass transition temperature of laminate material $\geq 338^{\circ}\text{F}$ (170°C).

Tin Whisker is a spontaneous crystal growth that emanates from a Sn surface. They may be cylindrical, kinked, or twisted. Typically they have an aspect ratio (length/width) greater than two, with shorter growths referred to as nodules or odd-shaped eruptions. See GEIA-STD-0005-2 for further description of Tin Whiskers and their physical attributes.

Underplating is the plating made as a base of a surface overplating usually required as a barrier to prevent leeching of two dissimilar metals into one another.

Weapons Replaceable Assembly (WRA) is a black box of electronics, replaced at the flight-line level.

X-Ray Fluorescence (XRF) is a form of metallurgical analysis that uses x-rays to identify composition of solder alloys and termination finishes.

4.0 Symbols and Abbreviated Terms

Ag	Silver
AHP	Aerospace and High Performance
AIA	Aerospace Industries Association
AMC	Avionics Maintenance Conference
Au	Gold
Bi	Bismuth