

AEROSPACE STANDARD

Submitted for recognition as an American National Standard

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NATIONAL AEROSPACE AND DEFENSE CONTRACTORS ACCREDITATION PROGRAM REQUIREMENTS FOR PAINTING AND DRY FILM COATINGS

1. SCOPE

This Aerospace Standard (AS) is to be used to supplement AS7108. In addition to the requirements contained in AS7108, the requirements contained herein shall apply to suppliers seeking NADCAP accreditation for painting and dry film coatings.

2. REFERENCES

2.1 SAE Publications

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15086-0001.

AS7108 National Aerospace and Defense Contractors Accreditation Program (NADCAP) -
Requirements for Chemical Processes

3. PAINTING AND DRY FILM COATINGS

3.1 Precleaning and pretreatment procedures shall be documented on shop paper.

3.2 Verification of cleaning shall be performed and documented prior to paint/film application.

3.3 Prepared surfaces shall be protected prior to paint/film application.

3.4 Paint/film material shall be purchased to customer approval or qualified products list (QPL).

3.5 Material shall have traceable certificate of conformance.

3.6 Material shall be applied traceable to the hardware to which it was applied and recorded on shop paper prior to use.

3.7 The supplier shall have a procedure for shelf-life control.

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- 3.8 There shall be evidence in the shop that shelf-life control is carried out (i.e., stickers on containers, no out of date material on the production floor, etc.).
- 3.8.1 The supplier shall have a documented procedure for requalification/disposal of material.
- 3.8.2 The supplier shall retain records of requalified materials and requalification test results.
- 3.9 Materials shall be stored under appropriate temperature controlled conditions.
- 3.10 Viscosity/thinning ratio of the coating material shall be controlled, checked, and documented immediately prior to use.
- 3.11 There shall be procedures for proper mixing/agitation of materials including mix ratios, order, shaking time, and mixing time.
- 3.12 Pot life and induction time shall be recorded on shop paper.
- 3.13 Mix, start, and finish times shall be recorded on shop paper.
- 3.14 Spray equipment cleanliness shall be maintained including guns, cups, feed lines, etc.
- 3.15 Dry-film and paint spray equipment and application areas shall be controlled to minimize contamination.
- 3.16 Grit blasting and coating spray equipment shall be segregated.
- 3.17 Required and actual drying times between coats and to final cure shall be documented on shop paper.
- 3.18 Thickness test results and methods shall be documented on shop paper.
- 3.19 Adhesion test results and methods shall be documented on shop paper.
- 3.20 Paint color standards shall be available.
- 3.21 There shall be procedures to assure that relative humidity and temperature meet manufacturer or customer requirements during application and air cure.
- 3.21.1 RH and temperature in the shop shall be recorded either continuously on a chart or manually at start of shift, before application, and every 4 hours thereafter in a log.
- 3.21.2 There shall be an individual identified to determine that environmental conditions in the shop are suitable for coating as described above.