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MCDONNELL AIRCRAFT CO ST LOUIS MO
ION VAPOR DEPOSITION PROCESSING OF ARMAMENT PARTS. (U)
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DAAK10-81-R-0325

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Department of the Army
U.S. Army Armament R&D Command
Attn: Edgardo Silvestre
Code DRDAR-SCM-P
Dover, New Jersey 07801

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SECURITY CLASSIFICATION OF THIS PAGE (When Data Entered)

REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER DAAK10-81-R-0325	2. GOVT ACCESSION NO. AD-A119810	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) Ion Vapor Deposition Processing of Armament Parts		5. TYPE OF REPORT & PERIOD COVERED Final Report for Period 01 Oct 1981 to 30 Jun 1982
		6. PERFORMING ORG. REPORT NUMBER
7. AUTHOR(s) J. J. Reilly		8. CONTRACT OR GRANT NUMBER(s) DAAK10-81-R-0325
9. PERFORMING ORGANIZATION NAME AND ADDRESS McDonnell Aircraft Company. McDonnell Douglas Corporation P.O. Box 516 St. Louis, MO 63166		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS
11. CONTROLLING OFFICE NAME AND ADDRESS Department of the Army U.S. Army Armament R&D Command Dover, NJ 07801 Attn: <u>Edgardo Silvestre, Code DkDAR-SCM-P, B1 355</u>		12. REPORT DATE 15 July 1982
14. MONITORING AGENCY NAME & ADDRESS (if different from Controlling Office)		13. NUMBER OF PAGES 27
		15. SECURITY CLASS. (of this report) Unclassified
15a. DECLASSIFICATION DOWNGRADING SCHEDULE		
16. DISTRIBUTION STATEMENT (of this Report) Distribution unlimited; approved for public release.		
17. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)		
18. SUPPLEMENTARY NOTES "THE VIEW, OPINIONS, AND/OR FINDINGS CONTAINED IN THIS REPORT ARE THOSE OF THE AUTHOR(S) AND SHOULD NOT BE CONSTRUED AS AN OFFICIAL DEPARTMENT OF THE ARMY POSITION, POLICY OR DECISION, UNLESS SO DESIGNATED BY OTHER DOCUMENTATION".		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Hydrogen Embrittlement Ion Vapor Deposited (IVD) Aluminum Coating Aluminum Coating Aluminum Coated Armament Details Non-toxic Aluminum Coatings		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) Over 3,000 armament components are currently electroplated with cadmium. All DoD organizations are committed to replace toxic cadmium wherever feasible. There is an equal need to alleviate the potential for hydrogen embrittlement failures. All electroplate processes introduce hydrogen. IVD aluminum coating per MIL-C-83488 has been identified by MIL-STD-1568 as an acceptable alternate to cadmium on steel stating its non-toxic and corrosion prevention characteristics. The object of the program is to establish IVD aluminum as a viable coating for armament hardware/parts.		

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FOREWORD

This report describes the work accomplished by the McDonnell Aircraft Company (MCAIR), McDonnell Douglas Corporation, St. Louis, Missouri on ARRADCOM Contract DAAK10-81-R-0352, "Ion Vapor Deposition Processing of Armament Parts". The program was administered under the direction of the Army Research and Development Command by Edgardo Silvestre. The contract period was 1 October 1981 to 30 June 1982. The program was conducted by the Material and Process Development Department at MCAIR, St. Louis, and was managed by E. R. Fannin with J. J. Reilly as Principal Investigator. J. C. Marzaloes and M. B. Munsell of the MCAIR Physics Laboratory were major contributors to the program.

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1. INTRODUCTION

Cadmium electroplating has been the favored method for protecting steel on aircraft structure for many years. Obvious problems with its use were minimal prior to the use of high strength steel and aluminum alloys. Cadmium electroplating on high strength steel often caused hydrogen embrittlement, and cadmium plated fasteners installed in high strength aluminum alloys helped promote exfoliation corrosion in the countersinks. More recently it has received further disfavor because it was found to cause solid metal embrittlement of titanium structure and because of its toxicity and harmful effects on the environment.

McDonnell Aircraft Company (MCAIR) started looking for a viable alternate for cadmium in the early 1960's. After extensive paper studies, aluminum coatings were selected as the best substitute. Being the least dissimilar to aluminum alloy structure, it is ideally compatible. Furthermore, aluminum is anodic to steel and provides galvanic protection as does cadmium.

It was quickly found that available processes for applying aluminum coatings such as metal spraying, electroplating, cladding, hot dipping and others had severe limitations such as thickness control, adhesion, size and shape of product that could be coated, and effect on substrate properties.

During this same period, we had selected vacuum deposited cadmium as the coating for solving the problem of hydrogen embrittlement of high strength steel. Our production experience with the vacuum coating process was very favorable. For this reason, we started looking at vacuum coating processes for aluminum. This included physical vapor deposition, ion vapor deposition, and chemical vapor deposition. Ion vapor deposition (IVD) provided the best adhesion and most uniform coating thickness and with other considerations was selected for further development.

Production equipment is now available for plating aluminum by the IVD process. It is recognized by a number of military, industrial and company specifications and is used for a broad range of applications on a growing number of programs (see Attachment A).

IVD aluminum is the baseline corrosion protection system for the U.S. Army Copperhead Cannon Launch Guided Projectile. MCAIR extensively uses IVD aluminum on the F-15, F-18 and AV-8B aircraft programs. We use it on high strength aluminum alloys, mild steels, including high strength steel landing gear details as well as on steel and titanium fasteners installed in aluminum structure.

Over 3,000 armament components are currently electroplated with cadmium. All DoD organizations are committed to replace toxic cadmium wherever feasible. There is an equal need to alleviate the potential for hydrogen embrittlement failures. All electroplate processes introduce hydrogen.

The U.S. Army Armament Research and Development Command (ARRADCOM) awarded MCAIR contract #DAAK10-81-R-0352, on 21 September 1981 to evaluate and establish IVD aluminum as a viable coating for armament hardware/parts. This is the final report as required by the contract.

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2. PROGRAM AND SCHEDULE

Schedule program tasks entailed:

- o Coating of a maximum of 17 types of weapon hardware with IVD aluminum. The ARRADCOM supplied hardware would be IVD aluminum coated by MCAIR.
- o Coating of (10) 3" x 4" 4340 steel panels and (10) 3" x 4" aluminum alloy panels with IVD aluminum. MCAIR will supply and coat the panels. MCAIR will supply ARRADCOM with a like number of uncoated steel panels for ARRADCOM to electroplate with cadmium. These panels will be used for comparative testing with the IVD aluminum coated panels.
- o MCAIR will judge the feasibility of IVD aluminum coatings for each of the finished details, document processing parameters including pre-cleaning and post-coating processing and record coating thickness. This information will be furnished to ARRADCOM.
- o MCAIR will perform adhesion and corrosion resistance testing on representative details coated with each run of details supplied to ARRADCOM.
- o Cost analysis of IVD aluminum processing for each of the ARRADCOM supplied details will be furnished by MCAIR.

Non-scheduled program tasks included:

- o Request by ARRADCOM through the University of Notre Dame for MCAIR to IVD aluminum coat 8 alloy steel test panels. Notre Dame will evaluate the effect of coating parameters on corrosion resistance, coating structure and adhesion in support of the ARRADCOM contract (see Attachment B).
- o Request by ARRADCOM that MCAIR furnish additional alloy steel test panels coated with IVD aluminum, and also panels electroplated with cadmium. ARRADCOM will evaluate the relative corrosion resistance characteristics of the 2 platings.
- o MCAIR offered to obtain budgetary coating quotes from outside plating-houses for several of the ARRADCOM furnished details. ARRADCOM accepted the offer.
- o A visit by MCAIR to ARRADCOM to discuss the program. MCAIR offered to IVD aluminum coat additional ARRADCOM prototype parts after the conclusion of the reference contract for applications deemed feasible by ARRADCOM.

3. SIGNIFICANT RESULTS

- o The following ARRADCOM furnished details were coated with IVD aluminum and returned to ARRADCOM:

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BARREL FIXTURED

10 Couplings
15 Lockrings
15 Springs
15 Piston Washers
12 Fector Gear Washers

RACK FIXTURED

14 Key Washers
2 Bolts
2 Handles
1 Nut
6 Pins
2 Racks
2 Sleeves
15 Springs
2 Struts
6 Stress Rupture Specimens

- o ARRADCOM requested the specific fixturing for the aforementioned details. MCAIR deviated with the 14 key washers which cannot be barrel fixtured. Photographs of the coated details were furnished (see Attachment C).
- o The following MCAIR furnished details (scheduled items) were coated with IVD aluminum and were sent to ARRADCOM along with 10 bare alloy steel panels:

(10) 2" x 4" Alloy Steel Panels
(10) 2" x 4" Aluminum Alloy Panels

- o The coating parameters for the ARRADCOM and MCAIR furnished details (see Attachment D) were sent to ARRADCOM.
- o The recommended fixturing, approximate coating costs and throughput numbers (see Attachment E) for the ARRADCOM furnished details were also submitted.
- o The 8 panels furnished by the University of Notre Dame were coated with IVD aluminum and were returned to Notre Dame (see Attachment F).
- o Forty-eight additional 2" x 4" alloy steel panels (non-scheduled items) requested by ARRADCOM were furnished by MCAIR. The panels were coated as follows:

(12) panels - IVD aluminum; MIL-C-83488, Class I, Type II
(12) panels - IVD aluminum; MIL-C-83488, Class 2, Type II
(12) panels - Electroplated Cadmium; QQ-P-416, Class 1, Type II
(12) panels - Electroplated Cadmium; QQ-P-416, Class 2, Type II

(see Attachment G)

- o IVD aluminum coating adhesion and corrosion resistance properties test data performed on representative details coated with each run of details supplied to ARRADCOM is attached (see Attachment H).
- o Budgetary quotes for coating typical ARRADCOM details from 2 contractors with IVD aluminum coaters are attached (see Attachment I).

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PROGRAM SCHEDULE		TITLE: ION VAPOR DEPOSITION PROCESSING OF ARMAMENT PARTS - ABRADCOM P.O. DAAK10-81-R-0353		DATE		LEGEND:		APPROVAL	
		DATE	TIME	PREP. BY	DEPT. NO.	SCHED.	ACTUAL	APP.	APP.
1	Contract Award	Sept							
2		Oct							
3	Cost ABRADCOM Furnished Details	Nov							
4		Dec							
5	Cost WEAR Furnished Details	Jan							
6		Feb							
7	Submit First Progress Report	Mar							
8		Apr							
9	Ship Coated Details; Applicable Documentation	May							
10		June							
11	Cost and Ship Any Additional Details Submitted	Sept							
12	by ABRADCOM	Oct							
13		Nov							
14	Submit Second Progress Report	Dec							
15		Jan							
16	Cost and Ship Any Additional Details Submitted	Feb							
17	by ABRADCOM	Mar							
18		Apr							
19	Submit Pre-Publication Copy of Final Report	May							
20		June							
21	Submit Final Report	Sept							
22		Oct							
23		Nov							
24		Dec							
25		Jan							
26		Feb							
27		Mar							
28		Apr							
29		May							
30		June							
31									
32									
33									
34									
35									
36									

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4. CONCLUSION

MCAIR has completed all scheduled and non-scheduled items of the reference contract. IVD aluminum coating is a feasible corrosion protection system for all of the details coated during the contract period. The adhesion and corrosion resistance requirements of MIL-C-83488 were easily met. In fact, Attachment G shows the corrosion resistance characteristics of the IVD aluminum coating on all of the test specimens to be far in excess of the requirement. Most of the specimens are still in the test and some have exceeded 5,000 hours. Additional advantages of using IVD aluminum coating on armament hardware are:

- o An absence of hydrogen embrittlement caused by the process
- o A useful service temperature of 925°F
- o Compatibility of aluminum with fuel
- o The non-toxic properties of both the process and the coating

This program, sponsored by ARRADCOM, to evaluate the use of IVD aluminum coatings contributes to the United States Department of Defense effort to minimize the use of cadmium. The various federal specifications for cadmium deposition require the use of acceptable alternate processes where feasible. An excerpt from MIL-STD-1568 which recognizes IVD aluminum as an acceptable alternate to cadmium on steel is attached (see Attachment J).

The coating quotes received from outside contractors and reported herein could most likely be negotiated downward with normal procurement practices. For this program, no such special effort was made. Also, quotes would undoubtedly be lowered as orders were placed on a recurring production basis. Our experience in production has shown the processing costs for IVD aluminum to be comparable to vacuum cadmium but slightly greater than electroplated cadmium. However, if clean-up costs are separately factored, then the IVD process becomes even more cost efficient.

MCAIR will continue to work with ARRADCOM on feasible applications for IVD aluminum coating. The scope of this work can range from coordinating the coating of prototype details to advising the optimization of coating parameters and fixturing to minimize coating costs.

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15 August 1982

IVD ALUMINUM ACCEPTANCE

o **MILITARY SPECIFICATIONS**

- MIL-STD-1516 - Coatings for Aircraft and Missiles
- MIL-S-5002 - Surface Treatments and Metallic Coatings for Metallic Surfaces of Weapons Systems
- MIL-C-83488 - Coating, Aluminum, Ion Vapor Deposited
- MIL-STD-1515 - Fastener Systems for Aerospace Applications
- MIL-STD-1568 - Materials and Processes for Corrosion Prevention and Control in Aerospace Weapons Systems
- MIL-S-24149B - Studs, Arc Welding and Arc Shields (Ferrules); General Specifications for

o **INDUSTRY-WIDE SPECIFICATIONS**

- ASTM - Aluminum Coatings
- AMS 2427 - Aluminum Plating - Ion Vapor Deposition
- AS 1650 - Procurement Specification, Coupling, Fuel, Rigid, Threaded Type

o **COMPANY ISSUED SPECIFICATIONS**

- McDonnell Aircraft
- Douglas Aircraft
- Pratt & Whitney
- Raytheon
- Boeing
- Martin-Marietta
- Bell
- Northrop
- FMC
- Airbus Consortium
- Bendix
- General Electric

o **PROGRAMS USING IVDIZER**

AIRCRAFT

F-4 757
F-15 767
F-18 SAAB 340
AV-8B A-300
DC-9 DC-10

MISSILES

Harpoon
Patriot
MX

PROJECTILES

Copperhead (Army)
5" SAL GP (Navy)
8" SAL ER GP (Navy)

MISC.

MARK 34 Launcher
Space Shuttle
Trident Submarine
Centrifuge
A129 Helicopter
Multiple Launch
Rocket System
Mark 75 Gun

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**UNIVERSITY OF NOTRE DAME
DEPARTMENT OF METALLURGICAL ENGINEERING
AND MATERIALS SCIENCE**

BOX E
NOTRE DAME INDIANA 46556
AREA 219
PHONE 219-239-5330

January 15, 1982

Mr. Greg B. Smith
2033 Quiet Stream
Maryland Heights, MD 63043

Dear Mr. Smith:

Enclosed are four 2 x 2 x 1/16 inch samples each of Type 4340 steel which have been heat-treated to HRC50 and 55. As part of a U.S. Army ARRADCOM sponsored project (monitored by Dr. W. Ebihara of ARRADCOM) concerned with adhesion and corrosion resistance of ion vapor deposited steels, we need to have the steel samples ion vapor deposited with aluminum.

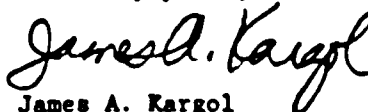
We are interested in studying the corrosion resistance with electro-chemical techniques, and the adhesion and coating structure with surface wave ultrasonic techniques. To make the study, we need one sample of each hardness steel deposited with a 0.001 inch thick aluminum coating according to your standard manufacturing practice. We request that the coated steel not be shot peened nor chromate rinsed.

Our goal is to compare the standard Al-coating to three alternative Al-coatings of equivalent thickness which are deposited by modified practice such that the coating structures differ. For example, we may wish to study the effects of Al-crystal size and shape, or coating porosity which may vary with coating deposition rate or other factors.

I cannot be more specific regarding my request because I am not familiar enough with the ion vapor deposition process. Therefore, I request that you call me at 219-239-5891 so that we may discuss possible changes to the deposition process.

Thank you for your willingness to provide us with your coating service. Our project could not be carried out without your cooperation.

Sincerely yours,



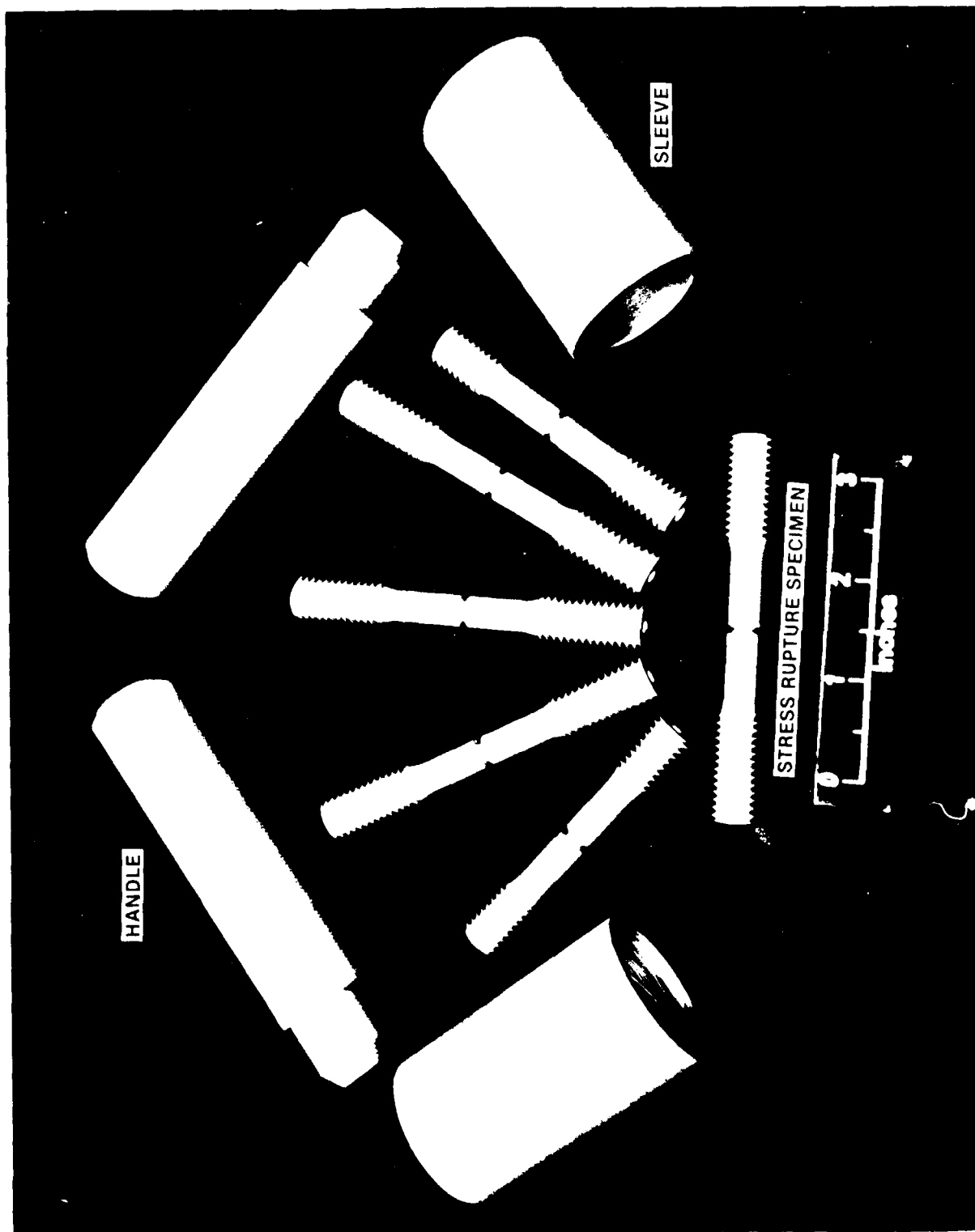
James A. Kargol
Assistant Professor

JAK/jp
Enc.

cc: W. T. Ebihara- U.S. Army ARRADCOM

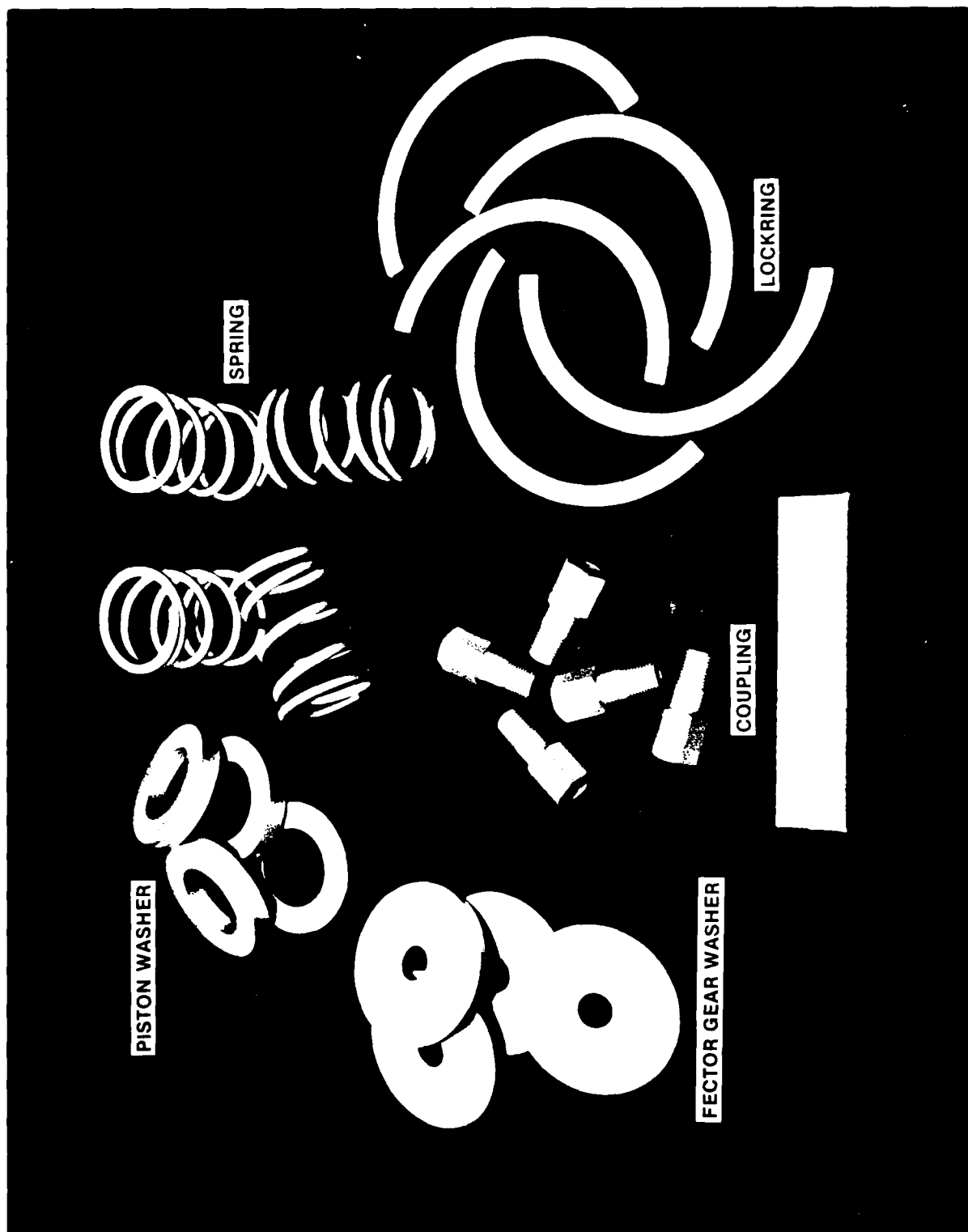
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MCDONNELL AIRCRAFT COMPANY



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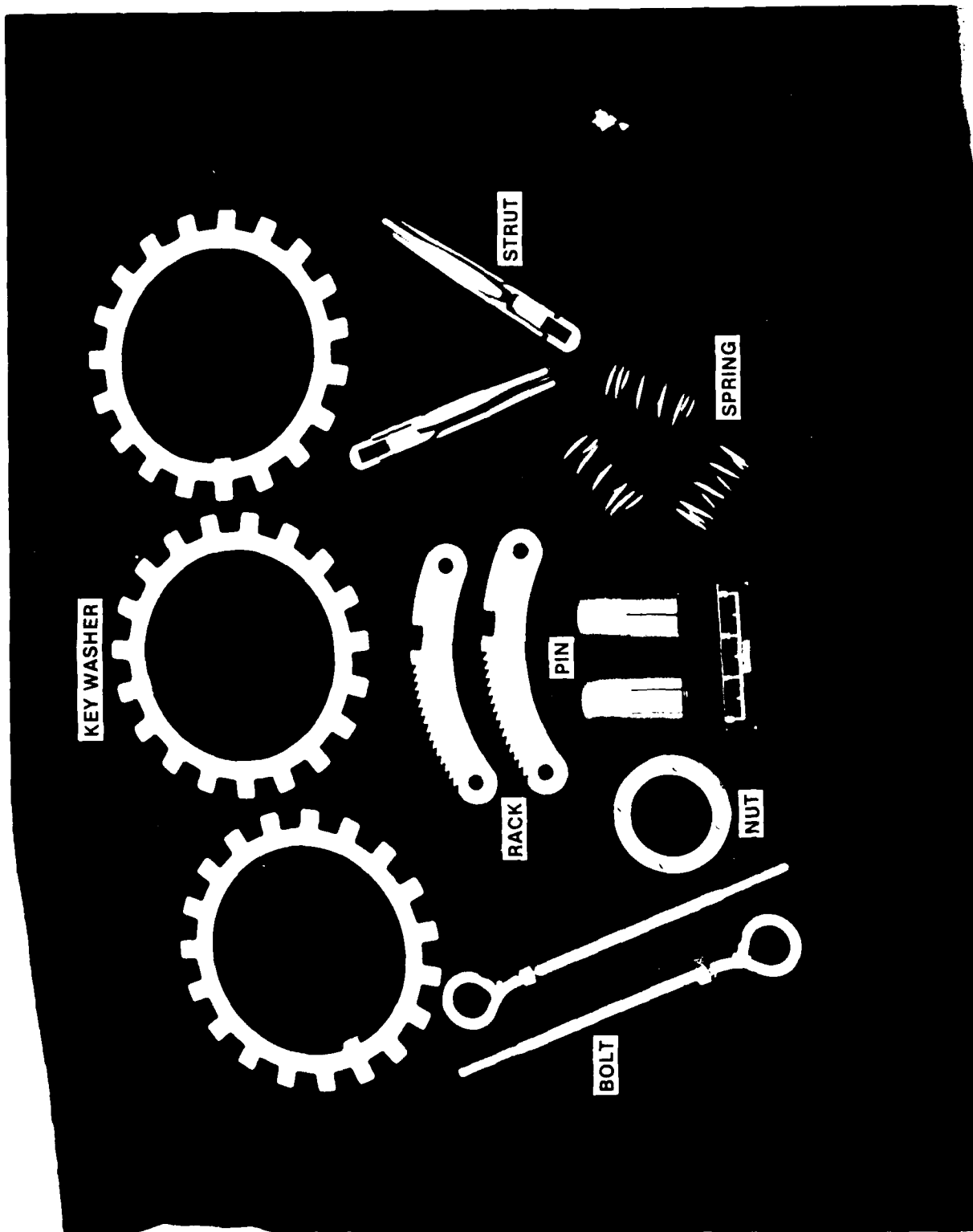
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Attachment (C)

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Attachment (C)

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MCDONNELL AIRCRAFT COMPANY

Box 516, Saint Louis, Missouri 63166 (314) 232-0232

26 January 1982
USA-347-7385

Commander
U.S. Army - ARRADCOM
Dover, NJ 07801

Attention: Mr. Edgardo Silvestre, DRDAR-SCM-P, Bldg. 355

Subject: Processing Parameters for Ivdized Details

Reference: ARRADCOM Contract DAAK10-81-R-0352, "Ion Vapor Deposition
Processing of Armament Parts"

Dear Edgardo:

The processing parameters used to IVD aluminum coat both the ARRADCOM supplied armament details and the McDonnell Aircraft supplied panels that were recently returned to your attention are shown in the enclosed table. The applicable MIL-C-83488, "Coating, Aluminum, Ion Vapor Deposited" class and type and the approximate coating thickness are also shown.

I have also enclosed several photographs of the coated details with identification.

I plan to supply cost and throughput data for each detail within the next month.

Please call me at (314) 233-8663 if you have any questions.

Very truly yours,



J. J. Reilly
Technical Specialist
Ivdizer Technology

JJR:gah

Enclosures

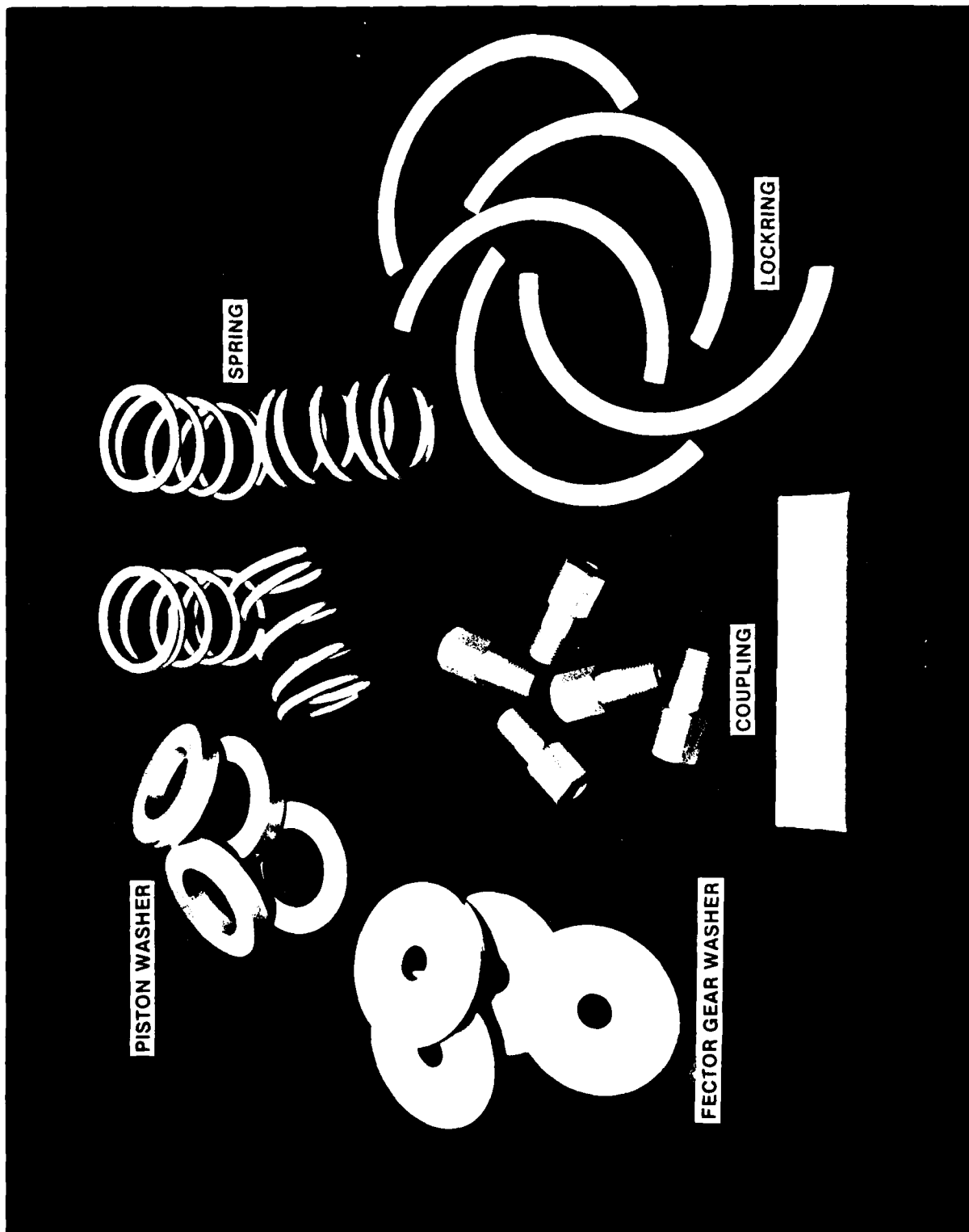
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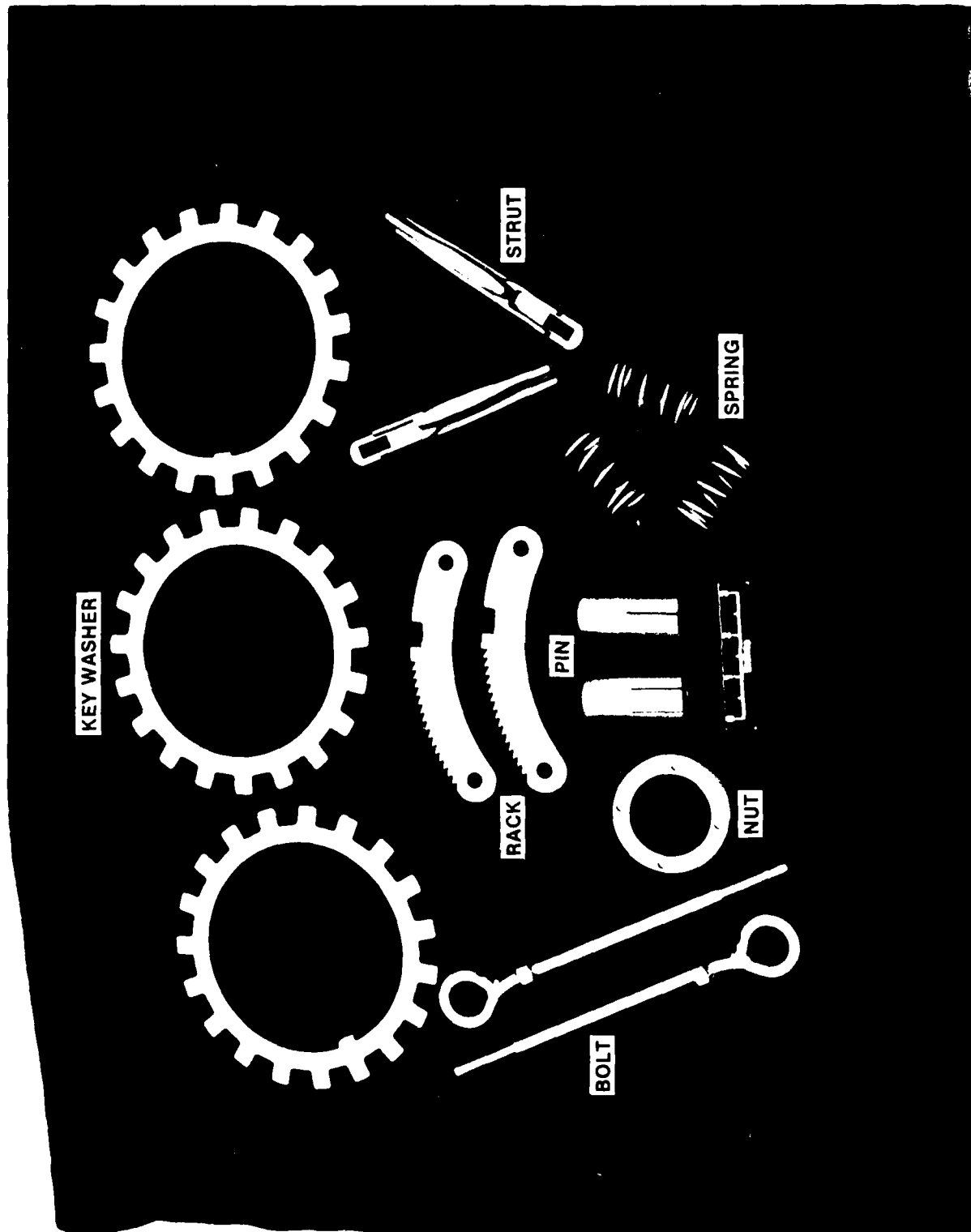


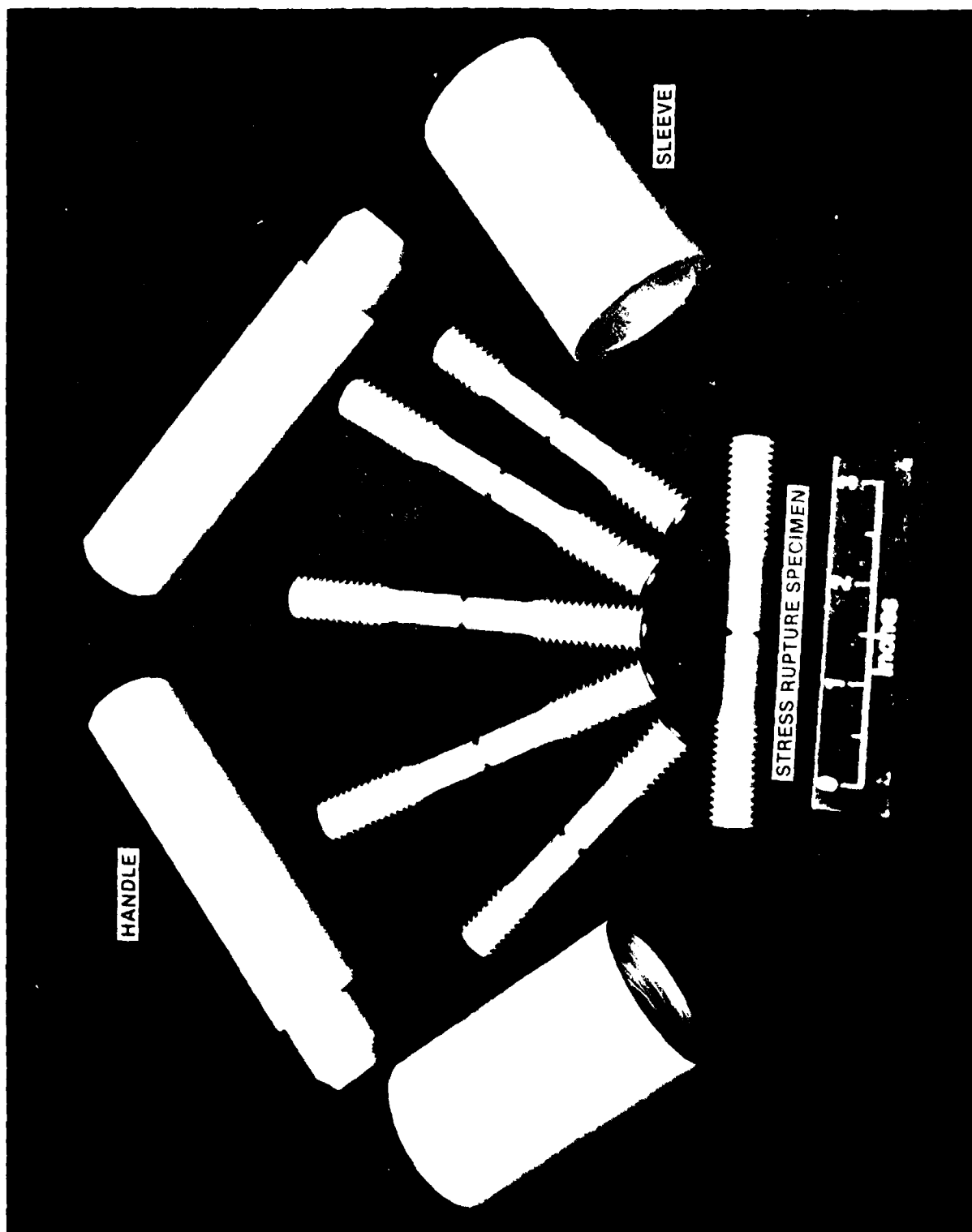
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SPECIMEN	MIL-C-83488		COATING THICKNESS APPROXIMATE (MILS)	GLOW DISCHARGE CLEANING PARAMETERS			COATING PARAMETERS		
	CLASS	TYPE		PRESSURE (MICRONS)	VOLTAGE (VOLTS)	AMPERAGE (AMPS)	PRESSURE (MICRONS)	VOLTAGE (VOLTS)	AMPERAGE (AMPS)
<u>Rack Fixtured</u>									
Nut	2	II	0.7	10	900	1.5	10	1500	0.2
Bolt	2	II	0.7	10	900	1.5	10	1500	0.2
Handle	1	II	2.0	10	900	1.5	10	1500	0.2
Key Washer	1	II	1.6	10	900	1.5	10	1500	0.2
Pin	1	II	2.0	10	900	1.5	10	1500	0.2
Rack	1	II	2.0	10	900	1.5	10	1500	0.2
Sleeve	1	II	2.0	10	900	1.5	10	1500	0.2
Spring	1	II	1.8	10	900	1.5	10	1500	0.2
Strut	1	II	2.0	10	900	1.5	10	1500	0.2
Stress Rupture	1	II	1.7	10	900	1.5	10	1500	0.2
Steel Panel (High Voltage)	1	II	2.0	10	900	1.5	10	1500	0.2
Steel Panel (Low Voltage)	1	II	2.0	10	500	0.9	10	750	0.1
Aluminum Panel (High Voltage)	1	II	2.0	10	900	1.5	10	1500	0.2
Aluminum Panel (Low Voltage)	1	II	2.0	10	500	0.9	10	750	0.1
<u>Barrel Fixtured</u>									
Coupling	2	II	0.7	10	500	2.0	10	1400	0.1
Lockring	2	II	0.9	10	500	2.0	10	1400	0.1
Spring	2	II	0.8	10	500	2.0	10	1400	0.1
Piston Washer	2	II	0.9	10	500	2.0	10	1400	0.1
Washer Gear	2	II	0.9	10	500	2.0	10	1400	0.1

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MCDONNELL AIRCRAFT COMPANY

Box 516, Saint Louis, Missouri 63166 (314) 232-0232

24 March 1982
USA-347-7594



Commander
U.S. Army - ARRADCOM
Dover, NJ 07801

Attention: Mr. Edgardo Silvestre, DRDAR-SCM-P, Bldg. 355

Subject: Processing Costs for Ivadized Details

Reference: ARRADCOM Contract DAAK10-81-R-0352, "Ion Vapor Deposition
Processing of Armament Parts"

Dear Edgardo:

The reference contract requires cost analysis by McDonnell Aircraft Company (MCAIR) for IVD aluminum processing of the items furnished to MCAIR by ARRADCOM. I have enclosed a table (Enclosure 1) which lists the furnished items and shows the approximate processing cost based on production size loads.

The detail throughputs are approximate and are based on our latest barrel coater design and on our standard rack coater design. The hourly cost is a MCAIR figure. This cost differs among the various facilities that offer IVD aluminum coating services on a subcontract basis (Enclosure 2). Profit is not included in the cost per detail amount.

More realistic cost data can be obtained by asking for budgetary quotes from several of the job shop plating facilities. I will be happy to obtain this data if you so desire. Drawings of the items in question and approximate usage requirements would be beneficial. Please advise me on this matter.

Please contact me at (314) 233-8663 if you have any questions.

Very truly yours,

A handwritten signature in cursive script, appearing to read "Jim".

J. J. Reilly
Technical Specialist
Ivadizer Technology

JJR:gah

Enclosures

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16

CORPORATION

ATTACHMENT (E)

MCDONNELL AIRCRAFT COMPANY

THROUGHPUT AND COST DATA

<u>ITEM</u>	<u>FIXTURING</u>	<u>APP. THROUGHPUT PER HOUR</u>	<u>APP. COST PER HOUR</u>	<u>APP. COST PER DETAIL</u>
Coupling	Barrel	3523	\$120	\$.03
Spring	Barrel	2040	\$120	\$.06
Piston Washer	Barrel	4715	\$120	\$.03
Pector Gear Washer	Barrel	5333	\$120	\$.02
Nut	Barrel	800	\$120	\$.15
Bolt	Rack	288	\$125	\$.43
Handle	Rack	549	\$125	\$.23
Key Washer	Rack	309	\$125	\$.40
Pin	Rack	883	\$125	\$.14
Rack	Rack	343	\$125	\$.36
Strut	Rack	686	\$125	\$.18

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COMPANIES OFFERING IVADIZE ALUMINUM SUBCONTRACT WORK

Embee Plating (Subcontract Plater)
Los Angeles, CA
John Dahlberg (714) 546-9842
6' x 12' Rack Coater

Michigan Chrome & Chemical (Subcontract Plater)
Detroit, MI
Jim Kerrigan (313) 921-3711
6' x 12' Rack Coater

Voi-Shan (Fastener Mfg.)
Culver City, CA
Boyd Sellers (213) 870-5321
4' x 6' Barrel Coater

Metals Applied (Subcontract Plater)
Division of Cleveland Pneumatic Company
Cleveland, OH
Pablo Prieto (216) 241-5913
4' x 8' Rack Coater
6' x 12' Rack Coater

Ekco Products, Inc. (Subcontract Plater)
Chicago, IL
Norm Gemignani (312) 237-6000
7' x 12' Rack Coater

McDonnell Aircraft Co.
St. Louis, MO
E. Fannin (314) 232-9924
7' x 12' Rack Coater
6' x 12' Rack Coater (2)
4' x 7' Barrel Coater
2' x 3' Rack/Barrel Coater

St. Charles Metal Finishing
St. Charles, MO
Quince Parker (314) 724-6851
6' x 12' Rack Coater

Robert Stuart (London) Ltd
London, England
M.H.C. Maxwell 01-267-2414
4' x 6' Barrel/Rack Coater

AAA Plating Co. (Subcontract Plater)
Los Angeles, CA
Joe Trankla (213) 979-8930
4' x 6' Barrel/Rack Coater

Martin Marietta Aerospace (Missile Mfg.)
Orlando, FL
George Bean (305) 352-4018
6' x 12' Rack Coater

Northrop Corporation (Aircraft Mfg.)
Los Angeles, CA
Tom Thomas (213) 970-3497
6' x 12' Rack Coater (3)

Blanc Aero
Paris, France
J. Ordines 307-00-11
4' x 6' Barrel Coater

Tokyo Rashi Co.
Kanagawa, Japan
Yukio Arimi 0466 (23) 2131
4' x 6' Barrel Coater

Turbine Support (Engine Overhaul)
Manchester, CN
Roy F. Cannon (512) 333-6010
6' x 12' Rack Coater

SPS Technologies
Jenkintown, PA
Ken Kulju (215) 572-3309
4' x 6' Barrel Coater

Cametoid Platers (Subcontract Plater)
Ontario, Canada
D. G. Newman (416) 683-6450
4' x 6' Barrel Coater
6' x 12' Rack Coater

MCDONNELL DOUGLAS CORPORATION

MCDONNELL AIRCRAFT COMPANY

Box 516, Saint Louis, Missouri 63166 (314) 232-0232

17 March 1982
UND-347-7571

Mr. James A. Kargol
Assistant Professor
Dept. of Metallurgical Engineering
and Materials Science
University of Notre Dame
Box E
Notre Dame, IN 46556

Subject: Return of Panels for Evaluation for ARRADCOM

Dear Jim:

The 8 test panels that you submitted have been coated with IVD aluminum and were returned to you under separate cover. Per our agreement, the test panels were processed as follows:

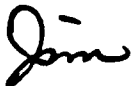
- o 2 at 10 micron coating pressure and 3.1 gram/minute wire feed rate.
- o 2 at 18 micron coating pressure and 3.1 gram/minute wire feed rate.
- o 2 at 10 micron coating pressure and 6.0 gram/minute wire feed rate.
- o 2 at 18 micron coating pressure and 6.0 gram/minute wire feed rate.

The coating is approximately 0.001" and 1 panel from each of the 4 processing parameter sets was burnished with glass beads and chromated. The other panel from each set was left as-coated.

The 10 micron coating pressure and 3.1 gram/minute wire feed rate are the normal processing parameters. Details are also normally burnished and chromated after coating. Chromating enhances corrosion protection and provides a base for subsequent processing like a paint topcoat. We burnish the details with glass beads at 40 PSI. This step also enhances corrosion protection, checks the adhesion of the coating and improves appearance.

Please call either Greg Smith at (314) 233-8658 or myself at (314) 233-8663 if we can be of any assistance.

Best regards,



J. J. Reilly
Technical Specialist-Ivadizer Technology

JJR:gah

MCDONNELL DOUGLAS

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ATTACHMENT (F)

MCDONNELL AIRCRAFT COMPANY

19 April 1982
USA-347-7572

Box 516 Saint Louis, Missouri 63166 (314) 232-0232

Commander
U.S. Army - ARRADCOM
Dover, NJ 07801

Attention: Mr. Edgardo Silvestre, DRDAR-SCM-P, Bldg. 355

Subject: Shipment of Test Coupons

Reference: ARRADCOM Contract DAAK10-81-R-0352, "Ion Vapor Deposition
Processing of Armament Parts"

Dear Edgardo:

The 24 additional alloy steel parts that you requested have been coated with IVD aluminum and are being sent to you under separate cover. The coating is Class 1, Type II on 12 panels, and Class 2, Type II on the other 12 panels.

The processing parameters used to IVD aluminum coat the panels are shown in the enclosed table.

I am also sending you the 24 cadmium plated coupons that you requested in the same shipment. Twelve of the panels are plated per QQ-P-416, Class 1, Type II, and the other 12 per QQ-P-416, Class 2, Type II.

Since you intend to compare the corrosion resistance characteristics of aluminum and cadmium, you may be interested in the conclusions we have reached after extensive testing:

- o Cadmium protects steel better than aluminum in neutral salt fog environments.
- o Aluminum protects steel better than cadmium in acidic salt fog environments.
- o Aluminum protects steel better than cadmium in most outdoor environments.
- o Aluminum on steel fasteners protects aluminum alloy structure better than cadmium on steel fasteners regardless of the environment.

Please call me at (314) 233-8663 if you have any questions.

Best regards,



J. J. Reilly
Technical Specialist
Ivadizer Technology

JJR:gah

MCDONNELL DOUGLAS

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ATTACHMENT (G)

MCDONNELL AIRCRAFT COMPANY

USA-367-7572
Enclosure

SPECIMEN	MIL-C-83488		COATING THICKNESS APPROXIMATE (MILS)	GLOW DISCHARGE CLEANING PARAMETERS			COATING PARAMETERS		
	CLASS	TYPE		PRESSURE (MICRONS)	VOLTAGE (VOLTS)	AMPERAGE (AMPS)	PRESSURE (MICRONS)	VOLTAGE (VOLTS)	AMPERAGE (AMPS)
<u>Back Plated</u> (12) Panels	1	II	1.5	10	500	2.0	10	1200	.15
(12) Panels	2	II	0.7	10	500	2.0	10	1200	.15

MCDONNELL DOUGLAS CORPORATION

MCDONNELL AIRCRAFT COMPANY

COATING ADHESION AND CORROSION RESISTANCE DATA

MCAIR RUN NUMBER	COATING ADHESION (BEND-TO-BREAK)	REPRESENTATIVE TEST SPECIMEN (ALLOY STEEL)	COATING CLASS/TYPE	SALT FOG DURATION (HOURS)		
				MIL-C-83488 REQUIREMENT	ACTUAL DURATION	STILL IN TEST
2269	Passed	2" Diameter Washer	Class 2, Type II	504	1584	5688
2270	Passed	2" Diameter Washer	Class 2, Type II	504		5688
2280	Passed	4" x 6" Panel	Class 2, Type II	504		4800
2306	Passed	2" x 4" Panel	Class 1, Type II	672		4800
2308	Passed	2" x 4" Panel	Class 1, Type II	672		4800
602	Passed	1" x 4" Panel	Class 1, Type II	672		3048
603	Passed	1" x 4" Panel	Class 2, Type II	504		2808
595	Passed	1" x 3" Panel	Class 1, Type II	672		
596	Passed	1" x 3" Panel	Class 1, Type II	672		
598	Passed	1" x 3" Panel	Class 1, Type II	672		
600	Passed	1" x 3" Panel	Class 1, Type II	672		
601	Passed	1" x 3" Panel	Class 1, Type II	672		2808
617	Passed	1" x 6" Panel	Class 1, Type II	672		2684
618	Passed	1" x 6" Panel	Class 2, Type II	504		2684
2397	Passed	1" x 4" Panel	Class 2, Type II	504		2636
2398	Passed	1" x 4" Panel	Class 1, Type II	672		2636
2407	Passed	1" x 4" Panel	Class 2, Type II	504		2160
2409	Passed	1" x 4" Panel	Class 1, Type II	672		2160

MCDONNELL DOUGLAS CORPORATION

Attachment (H)

MCDONNELL AIRCRAFT COMPANY



Highland Avenue
Jenkintown
Pennsylvania 19046
215-572-3000
TWX: 510-665-1718
Telex: 83-4254

QUOTATION

MCDONNELL DOUGLAS AIRCRAFT CO.
Box 516
St. Louis, Missouri 63166

Attn: J. J. Reilly, Tech. Spec.

Thank you for your inquiry. We are pleased to quote as follows

SPS QUOTE DATE	SPS QUOTE NO	YOUR REFERENCE	INQUIRY DATE	TERMS
6-10-82	BD257	LTR	OF 5-13-82	1/2% 10 Net 30
QUANTITY	DESCRIPTION		PRICE	DELIVERY
	SEE ATTACHED LIST OF ITEMS		AS NOTED	AS NOTED
	QUOTATION FIRM FOR 30 DAYS			

F O B

JENKINTOWN, PA.

SPS TECHNOLOGIES, AREA REPRESENTATIVE

D. FIELD

SPS TECHNOLOGIES, INC.

Robert P. Decembrino

ROBERT P. DECEMBRINO, SLS. REP
AEROSPACE FASTENER SALES

258 J RE 887

MCDONNELL DOUGLAS CORPORATION

MCDONNELL AIRCRAFT COMPANY

6-10-82

MCDONNELL DOUGLAS CORPORATION

ST. LOUIS, MISSOURI

Page 1

QUANTITY	DESCRIPTION	PRICE	DELIVERY
10,000	10903625 WASHER PISTON ROD	21.27/C	TO BE NEGOTIATED
20,000	"	20.89/C	
10,000	10891983 SPRING VALVE HANDLE	38.35/C	
20,000	"	37.95/C	
10,000	8430285 LOCKING RING	17.60/C	
20,000	"	17.21/C	
10,000	10913585 HANDLE	50.87/C	
20,000	"	50.47/C	
10,000	12000541 COUPLING	38.35/C	
20,000	"	37.95/C	
10,000	12010424 STRUT	50.87/C	
20,000	"	50.47/C	
10,000	6222781 RACK	21.27/C	
20,000	"	20.89/C	
10,000	10908460 WASHER KEY	NO QUOTE	
20,000	"	AT THIS TIME	
NOTE: QUOTING IVD ALUMINUM COATING ONLY			
QUOTATION FIRM FOR 30 DAYS			

MCDONNELL DOUGLAS CORPORATION

MCDONNELL AIRCRAFT COMPANY

MC DONNELL AIRCRAFT COMPANY

Customer

Box 516

Saint Louis, Missouri 63166

Attn: J. Reilly

Emile Mating

2436 South Hathaway Road

Santa Ana, California 92705

(714) 746-9842

(214) 589-6451

This is a Quotation			Terms Net 10th Day	
Part Number	Description	Price	Quantity	Unit Price
10903625	Washer	I.V.D.		\$.15 Each
10891983	Spring	I.V.D.		\$.23 Each
8430289	Ring	I.V.D.		\$.25 Each
10913585	Handle	I.V.D.		\$.85 Each
12000541	Coupling	I.V.D.		\$.20 Each
12010424	Strut	I.V.D.		\$1.25 Each
6222781	Rack	I.V.D.		\$.90 Each
10908460	Washer	I.V.D.		\$1.50 Each
		Minimum Charge: \$175.00		
		F.O.B.		
		Santa Ana, California		
THIS QUOTATION GOOD FOR 100 DAYS				

This quotation is subject to Embair's approval to process in accordance with the referenced specifications

Signature

James P. Rantall

Title

Sales Manager

Date

May 28, 1982

MCDONNELL DOUGLAS CORPORATION

MCDONNELL AIRCRAFT COMPANY

MIL-STD-1568A(USAF)
24 October 1979
SUPERSEDING
MIL-STD-1568(USAF)
18 November 1975

MILITARY STANDARD

**MATERIALS AND PROCESSES FOR
CORROSION PREVENTION AND CONTROL IN
AEROSPACE WEAPONS SYSTEMS**



See Paragraph 5.6.1.3.

FSC MFFP

MCDONNELL DOUGLAS CORPORATION

ATTACHMENT (J)

5.5.3 Marking pencils. Ordinary lead pencils containing graphite shall not be used to mark metal parts. Nongraphitic marking pencils covered by MIL-P-83953 shall be used.

5.5.4 Cleaning after assembly. All closed compartments shall be cleaned after assembly to remove debris such as metal chips, broken fasteners, and dust. Particular attention shall be given to insure that drain holes are not blocked.

5.5.5 Protection of parts during storage and shipment. All parts and assemblies shall be given adequate protection to prevent corrosion and physical damage during temporary or long term storage and shipment.

5.6 Inorganic finishes.

5.6.1 Detail requirements. Cleaning, surface treatments and inorganic finishes for metallic surfaces of aerospace weapons systems parts shall be in accordance with MIL-S-5002. Those parts or surfaces of parts located in corrosion susceptible areas or which form exterior surfaces of the system shall require chemical finishing to provide maximum corrosion resistance.

5.6.1.1 Aluminum. All nonclad parts made from 7000 series aluminum alloys shall be sulfuric acid anodized in accordance with MIL-A-8625, Type II. They may be chromic acid anodized, MIL-A-8625, Type I, provided the anodized 7000 series test specimens meet the weight and corrosion resistance requirements of MIL-A-8625, Type II. All nonclad parts made from 2000 series aluminum alloys shall be anodized in accordance with MIL-A-8625, Type I or II. Clad 2000 and 7000 series aluminum alloys may be anodized in accordance with MIL-C-5541 as a minimum corrosion preventative coating.

5.6.1.2 Cadmium coatings. Cadmium coatings for all steel parts including fasteners shall have a minimum thickness of 0.0003 inch (0.008 mm) and shall be subsequently treated with a chromate conversion coating. High strength steels having an ultimate tensile strength of 180,000 psi (1230 MPa) and above shall be coated with the titanium-cadmium process in accordance with MIL-STD-1500, the vacuum deposition process in accordance with MIL-C-8837, or a similar non-embrittling process.

5.6.1.3 Aluminum coatings. Aluminum coating per MIL-C-83488 or equivalent shall be considered acceptable alternative coatings to cadmium. Decreased toxicity and decreased environmental contamination are obtained by using aluminum coatings.

DATE
ILME