	SARA SAE ENGINEERING SPECIFICATION	
	Section: SES 26 – 774	
	Issue: “A”	Rev. No.: “0”
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PHOSPHATE COATING FOR CARBON STEEL PARTS
(AS PER FMC)

Rev	Reason of Change	Date	Made By	Reviewed By	Approved By	Status
0		24-07-2014	KKM	AMIT S	KKD	Released

Summary:

This specification defines the requirements for phosphate coating of approved iron and steel parts.

COATINGS MAY NOT BE USED TO IMPROVE THE MATERIAL CLASS OF THE BASE MATERIAL, MAY BE USED IN CO₂ < 30 PSI PARTIAL PRESSURE ONLY

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PHOSPHATE COATING FOR CARBON STEEL PARTS **(AS PER FMC)**

1.0 SCOPE

1.1 This specification defines the requirements for phosphate coating of approved iron and steel parts.

1.2 This specification applies when the "as coated" properties of the coating are acceptable.

2.0 DESCRIPTION and GENERAL REQUIREMENTS

2.1 Vendor processes and quality control procedures must be approved by the Quality Assurance Department.

2.2 All parts must be coated and areas protected as specified on the engineering drawings.

3.0 PREPARATION of PARTS by SARA PRIOR TO COATING:

3.1 All parts shall be inspected to assure suitability for coating. Edges must be properly deburred.

3.2 Parts shall be kept dry and shipped in an approved manner to prevent damage to critical surfaces.

4.0 VENDOR COATING REQUIREMENTS:

4.1 All parts shall be preinspected for coating suitability.

4.2 Parts shall be cleaned, degreased, coated and rinsed in the approved manner. The process shall not impair the surface finish of ring grooves, threads and critically machined surfaces.

4.3 Maximum coating thickness is not to exceed 0.6 mil. (15µm)

5.0 COATING INSPECTION:

5.1 Visually inspect all parts for coating uniformity.