

IMPREGNANTS FOR ALUMINUM, COPPER, IRON, MAGNESIUM AND ZINC ALLOY CASTINGS

1.0 GENERAL

This standard describes the performance requirements of organic resin type sealers suitable for impregnation of porous metal castings.

1.1 Purpose

1.1.1 Purpose of the Standard

This standard supersedes previous requirements described in Chrysler Materials Standards MS-6784 and MS-3297; Sealer and Catalyst-Porous Castings and Powder Metal Parts, Organic Type, Anaerobic and Aerobic, respectively. In addition to providing a uniform method for evaluating the effectiveness of the material in sealing porosity, the standard defines requirements for determining the solvent and temperature resistance of the cured sealants.

1.1.2 Purpose of the Material

The impregnants are intended for use in salvaging castings exhibiting microscopic porosity. Castings with structural defects are to be excluded.

1.2 Scope

1.2.1 Application

The standard is for use in supplying certain parts under purchase orders of Chrysler Corporation or its subsidiaries. This standard is limited in its application to those drawings or engineering illustrations which call out this standard number or the superseded Material Standards MS-6784 or MS-3297, or which refer to this standard within some other standard or specification.

The standard also applies to any Corporate plant electing to impregnate castings.

1.2.2 Hazardous Material Control

Products furnished to Chrysler Corporation or its subsidiaries and products and processes used by suppliers to manufacture those products must conform to

A single asterisk "*" after the paragraph header denotes a technical change to the paragraph. A triple asterisk before and after an item (***) identifies the specific changed text.

Date	Mdl. Yr. Eff. Code & Disp Code	PCN No.	Change	Text Changes and Cancellations

Date Issued	10/13/94	Dept	5350	Contact	E. A. Tosolt (956-4567)
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IMPORTANT: Chrysler Corporation standards, specifications and drawings are subject to frequent revision. It is the users' responsibility to comply with current versions. Distribution of standards to parties other than Chrysler Corporation suppliers, whether with or without charge, is for information only. A subscription service is available at reasonable cost, which will automatically provide the subscriber with current standards. Subscription information or copies of current standards are available from the Engineering Standards & Information Services Department, Vehicle Engineering Office, Chrysler Corporation.

the employee and consumer health, employee safety, and environmental requirements contained in CS-9003.

1.2.3 Coverage of this Standard

This standard covers the chemical, physical, source approval, and quality control requirements for three types of organic resin impregnating material:

- Class 1 - Aerobic/thermal cure, suitable for service temperatures up to 300 degrees Fahrenheit (°F) 149 degrees Celsius (°C).
- Class 3 - Aerobic/thermal cure, for use where air pollution requirements apply. Suitable for service temperatures up to 300°F (149°C).
- Class 4 - Anaerobic/ion cure, suitable for service temperatures up to 300°F (149°C).

2.0 REQUIREMENTS

The requirements determining acceptability of the material for impregnation purposes are identical to criteria detailed in Military Specification MIL-I-17563C. The specification includes the requirements of the superseded Military Specification MIL-I-17563B.

Copies of the documents - Impregnants for Cast or Powder Metal Components and Impregnants for Aluminum, Copper, Iron, Magnesium and Zinc Alloy Castings are available from:

Defense Printing Service
700 Robbins Avenue
Bldg. 4, Section D
ATTN: Standardization Document Order Desk
Philadelphia, PA 19111-5094
Telephone: (215) 697-2179 or (215) 697-2667
FAX: (215) 697-1462

Products meeting these requirements and appearing on the Qualified Products List of products qualified under Military Specification MIL-I-17563 are considered to meet Chrysler Corporation standards for approved material.

The activity responsible for this List is the Naval SEA Systems Command, SEA 03Q42, 2531 Jefferson Davis Highway, Arlington, VA 22242-5160.

A listing of suppliers on the Qualified Products List currently furnishing material to suppliers impregnating castings for Corporate use appear on the Engineering Approved Source List.

3.0 CONTROL

Parts shall be impregnated only with materials available from sources shown on the above described lists. A supplier who furnishes parts to Chrysler is responsible for the quality of all components of the shipped assembly or end

item, whether component parts are processed/manufactured by him or purchased from another source.

The supplier shall not change any material or process requirements without consent of the Organic Materials Engineering Department.

4.0 CONTACTS

Questions concerning this standard should be directed to Chrysler Corporation, Vehicle Engineering, Materials Engineering.

5.0 REFERENCES

CS-9003
MS-6784
MS-3297
MIL-I-17563B
MIL-I-17563C

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CHRYSLER CORPORATION ENGINEERING APPROVED SOURCE LIST

Engineering Standard Title: **IMPREGNANTS FOR ALUMINUM, COPPER, IRON, MAGNESIUM AND ZINC ALLOY CASTINGS**

APPROVED SOURCE:

<u>Supplier</u>	<u>Product Name</u>	<u>Supplier Code</u>	<u>Manufacturer Name & Address</u>
Imprex Inc.	Imprex 95-1000 Imprex 95-1000A		Imprex Inc. 3260 S. 108th St. Milwaukee, WI 53227
Loctite Corp. Corporation Rd.	Resinol 90C Resinol RTC Resinol PMS-10E		Loctite 705 N. Mountain Newington, CT 06111
Ultraseal	Ultraseal PC 504/66		Castite Systems, Inc. 5007 Superior Ave. Cleveland, OH 44103 (Distributor)
Impco	RC80		Impco, Inc. 335 Valley St. Providence, RI 02908
Chemence	Anaseal HC90 Anaseal RT20		Chemence, Inc. 6425 Industrial Way Alpharetta, GA 30201-3382

The above Chrysler Engineering Approved Source List names those sources and sub-sources currently approved for the product or process indicated. By furnishing this list to you, Chrysler in no way assumes responsibility for the performance of any named suppliers or sub-sources and specifically reserves all rights to insist upon full and complete performance of all Chrysler purchase orders. Further, it should be understood that this list is not all-inclusive as to all qualified sources. No supplier should be precluded from fair and appropriate consideration as a source or sub-source solely because it has not been included in the list furnished herewith. You are therefore urged to furnish us with the names of any additional sources or sub-sources you believe are qualified, for investigation by Chrysler Corporation for possible approval in accordance with this policy.

Date Changes and Cancellations