



Minimizing the Use of Hexavalent Chromium Conversion Coatings

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PURPOSE & SCOPE

This Internal Specification (IS) authorizes the replacement of chemical conversion coatings containing hexavalent chromium with chemical conversion coatings containing no hexavalent chromium for the treatment of aluminum and aluminum alloys per MIL-C-5541 or MIL-DTL-5541, except where otherwise required by contract.

This internal specification is applicable to all L3Harris Technologies Inc. Communications Communication Systems-West (CSW) bills of material and drawings and shall take precedence over other existing CSW drawings, policies, and procedures.

Component Engineering shall be responsible for the review and update of this IS.

INTERNAL SPECIFICATION

Where drawings and bills of material are of significant quantity to make it unreasonable and unaffordable to implement individual Enterprise Change Notices (ECNs), this specification allows the replacement of MIL-C-5541 and MIL-DTL-5541 chemical conversion coatings containing hexavalent chromium (or Type I coatings) with MIL-DTL-5541 chemical conversion coatings containing no hexavalent chromium (or Type II coatings). This act is in direct response to the memorandum dated April 8, 2009 from the Under Secretary of Defense “Minimizing the Use of Hexavalent Chromium.”



Hexavalent Chromium Signed

CSW bills of material and drawings are affected as follows:

1. Where the bill of material invokes specification MIL-C-5541, refer to the latest version of MIL-DTL-5541.
2. Where the drawing specifically calls out Class 1A, yellow, the acceptable replacement for in-house builds shall be Type II, Class 1A. For parts built out of house, Type I, Class 1A, yellow or Type II, Class 1A shall be allowed.
3. Where the drawing specifically calls out Class 3, clear, the acceptable replacement shall be Type II, Class 3 for in-house builds. For parts built out of house, Type I, Class 3, clear or Type II, Class 3 shall be allowed.

END OF DOCUMENT

DOCUMENT INFORMATION

Responsible Organization: Engineering

Function/Sub-function: Component Engineering

Governing Document(s): Y-001, L3 Technologies CSW Quality Manual

Subordinate Document(s): NA

Related Document(s): MIL-C-5541
MIL-DTL-5541

Related Training: NA

Approval Requirements: Document Owner (Point of Contact)
Manager, Component Engineering
Document Control Administrator
Quality Representative
Engineering Representative
Operations Representative

Review Requirements: DCMA

Revision History Summary

Revision #	Description of Change	Date
New	Initial release.	03-26-2010
01	24 month review. No changes made	5/29/2012
NA	Updated legacy terms with new system terms. Updated org name due to org name change. Changes made indicated in blue text. No revision upgrade necessary.	11/01/2013
02	Overall update to clarify intent and to satisfy CAR 0640120130101 (CAPA 130217). Modified approval requirements. Changes are indicated with blue text.	9/25/2014
03	Updated Company Logo and Proprietary Statement. Updated Approval Requirements.	10/8/2025