

161Thorn Hill Road Warrendale, PA 15086-7527

# Program Document CPBOK

## PD 6103

# CPBok-010/OP-1 REV. A

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## **BODY OF KNOWLEDGE:**

ROLE DESCRIPTION: Operator/Technician SPECIAL PROCESS: Chemical Processing

**METHOD:** Corrosion Protection/Engineering Plating (Chromium, Nickel, Rhodium, Tin); Sacrificial Plating (Cadmium, Zinc); Plating for Electronics (Copper, Tin-Lead); Precious Metals Plating (Gold,

Palladium, Platinum, Silver)

All PRI Qualification<sup>SM</sup> program examinations are created using the applicable PRI Qualification<sup>SM</sup> program Body of Knowledge (BoK), which defines the baseline knowledge and experience required to be considered competent to perform the specified job role in aerospace special process manufacturing.

All BoKs are created by subject matter experts who participate in the PRI Qualification<sup>SM</sup> Body of Knowledge Review Boards. All BoKs are updated periodically according to the latest revision of PRI Qualification<sup>SM</sup> program documentation (PD6100: Industry Managed Special Process Bodies of Knowledge) to ensure consistency with current industry practice.

## 1. INTRODUCTION

This document has been created by the PRI Qualification<sup>SM</sup> program Chemical Process Body of Knowledge Review Board (CP-BoKRB) according to the requirements of PD6100.

This document constitutes the PRI Qualification<sup>SM</sup> program BoK for Chemical Processing Corrosion Protection/Engineering Plating (Chromium, Nickel, Rhodium, Tin); Sacrificial Plating (Cadmium, Zinc); Plating for Electronics (Copper, Tin-Lead); Precious Metals Plating (Gold, Palladium, Platinum, Silver); for the Operator Level. It defines the baseline knowledge and experience required to be considered competent to perform this role.

Unless otherwise stated, the CP-BoKRB has followed guidelines as detailed in the current version of International Aerospace Quality Group (IAQG) Guidance PCAP 001 (Competence Management Guideline) to develop this BoK.

The information in this BoK will provide guidance for the following:

- Training providers who wish to develop training courses intended to support PRI Qualification<sup>SM</sup> program examination candidate preparation
- Chemical Process Examination Review Board (CP-ERB) for the development of PRI Qualification<sup>SM</sup> program examinations
- Candidates taking PRI Qualification<sup>SM</sup> program who wish to prepare in advance

## 2. REFERENCES

PRI Qualification<sup>SM</sup> program documents:

PD6000 Governance & Administration of PRI Qualification<sup>SM</sup> Program PD6100 Industry Managed Special Process Bodies of Knowledge PD6200 Industry Managed Special Process Examinations System

IAQG documents:

IAQG Guidance PCAP 001 Competence Management Guideline

## 3. **DEFINITIONS**

Definitions described within are specific to the Special Process BoK. For program-specific definitions, please refer to either the PD 6000 or the PRI Qualification<sup>SM</sup> Dictionary.

BODY OF KNOWLEDGE (BoK): Baseline knowledge and experience required to be considered competent for a target position.

GENERAL EXAMINATION: The General Examination is designed to ascertain the candidate's general knowledge required for a particular job, role or activity. All of the questions will be derived from the corresponding BoK.

EXPERIENCE: The accumulation of knowledge or skill that results from direct participation in events or activities over a period of time.

KNOWLEDGE: Information / understanding acquired over a period of time. Information acquired through study and retained over that period of time (education, training, experience etc.) The combination of data and information, to which is added expert opinion, skills and experience, to result in a valuable asset which can be used to aid decision making and problem solving.

LEVEL: A class or division of a group based on education, training and experience. There are 3 levels: Operator/Technician, Planner and Owner. Please refer to the current version of PD 6000 for definitions.

METHOD: A well-defined division of a SPECIAL PROCESS widely recognised by industry. A specific area of a special process for example anodizing within Chemical Processing

NON-SPECIAL PROCESS RELATED REQUIREMENTS: Miscellaneous requirements such as Health and Safety, Environmental, etc.

PERSONAL ATTRIBUTES: A quality or characteristic expected and required for a particular job, role or activity.

PRACTICAL EXAMINATION: The Practical Examination shall consist of a demonstration of proficiency in performing tasks that are typical of those to be accomplished in the performance of the candidate's duties. The examination content is derived from the corresponding BoK.

SKILL: Ability to perform a particular task. The quality of being able to do something that is acquired or developed through training or experience.

SPECIFIC EXAMINATION: The Specific Examination shall cover requirements and use of the specifications, codes, equipment, operating procedures and test techniques the candidate may use in the performance of his/her duties with the employer. Examination content will be derived from the corresponding BoK where applicable.

WEIGHTING: The "weighting" of each line item, using a scale of 1, 3, 7, 10, (1 being least important; 10 being most important) indicates the relative importance of that aspect of the BoK and will determine the likelihood and frequency of a question on that topic appearing in the examination

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## 4. GUIDANCE TO EXAMINATION CANDIDATES

All PRI Qualification<sup>SM</sup> program examination candidates are recommended to read all documents referenced in section 2 of this document.

As stated in PRI Qualification<sup>SM</sup> program documentPD6200, every exam question shall relate directly to and be derived from the information as detailed in the current version of the BoK.

Re-assessment to this BoK is required every 5 years, unless otherwise specified.

Candidates are therefore advised to ensure familiarity with all aspects of the BoK as detailed in Table 1. This can be done through:

- Self-study
- · Completion of internal training
- Completion of external training (a list of Approved Training Providers can be found at https://p-r-i.org/)

Records of all qualified personnel shall be maintained and include:

- · Date of Qualification
- Results of Written Exam
- Results of Practical Exam (if applicable)
- Summary of Experience (Owner Level Only)

# 5. LEVELS

	Level				
Descriptors	Operator (OP) / Technician (T)  For descriptions, please	Planner (PL)  For descriptions, please refer to current version of	Owner (OW)  For descriptions, please refer to current versions of		
	refer to current version of PD6000	PD6000	PD6000		
Special Process Specific	No additional criteria for	No additional criteria for	No additional criteria for		
Criteria	the Plating process.	the Plating process.	the Plating process.		
Technical Knowledge	Basic knowledge of the special process, its main processes, methods and tools.	Good level of knowledge in all aspects of the special process, all its processes, methods and tools.	High or extensive knowledge in all aspects of the special process, all its processes, methods, and tools to assess and validate improvements.		
		Ability to coach others on contents and methods in the context of their workplace.	Able to contribute to set externally recognized standards.		
			Ability to define contents and methods for using knowledge effectively in influencing and developing international processes. Ability to influence the process with one's knowledge.		
Experience	Sufficient experience to deal with recurrent activity.	Has enough experience to deal with unforeseen issues.	Wide proven experience of the subject. Is recognized specialist within Plating processes		
Personal Attributes		Takes into consideration behavioral characteristics such as but not limited to: team working, communication, direction and purpose, innovation and problem solving, mutual trust and respect, confidentiality and trustworthiness.			
Skills		Describes the activities necessary to perform each level of job function to comply with the Body of Knowledge			
Non-Special Process Related Requirements Health & Safety, Environmental, Quality			l, Quality System Requirements.		

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## 6. TABLE 1

**ROLE DESCRIPTION: Operator** 

**SPECIAL PROCESS: Chemical Processing** 

SCOPE / METHOD: Corrosion Protection/Engineering Plating (Chromium, Nickel, Rhodium, Tin); Sacrificial Plating (Cadmium, Zinc); Plating for Electronics (Copper, Tin-Lead); Precious Metals Plating (Gold, Palladium, Platinum, Silver)

REFERENCE GUIDELINES: Addendum 1 is a list of the International Standards and Reference Documents applicable to Plating processes.

	COMPETENCE		1	I
Row#	COMPETENCE	Weight (1,3,7,10)	Exam Type Written (W) / Practical (P)	Reference Guidelines
	KNOWLEDGE:			
	The basic knowledge of the special processes, methods and tools			
_	GENERAL KNOWLEDGE:			
1.	Understand how to determine if there has been damage to the part surface.	10	GEN	AC 7108
2.	Full and complete understanding of Internal Work instructions	7	GEN	AC 7108
3.	Know how to access customer specifications and requirements (i.e. where to find them).	7	GEN	AC 7108
4.	Understand customer specification requirements in the context of performing the Plating process.	3	GEN	AC 7004; AS 9100; AC 7108/9; AC 7108/10
5.	Understand Industry Standards (see Addendum 1 of this document)	7	GEN	Addendum 1
6.	Knowledge of the Surface Preparation procedures	10	GEN	AC 7108/3; AC 7108/9; AC 7108/10; ASTM-B322; ISO 27831
7.	Basic understanding of the control and calibration requirements for equipment.	7	GEN	AC 7004; AS 9100;
8.	Know how to perform the Water Break Free Cleanliness Verification	10	GEN	AC 7108
9.	Knowledge and understanding of mathematics, including decimal and fractions	3	GEN	General Industry
10. 11.	Know how to use precision measuring instruments and equipment  Know and understand Job Documentation including Fixed and Frozen Process	7 10	GEN GEN	AC 7108/9; AC 7108/10
	requirements.			AC 7004; AS 9100; AC 7108
12.	Know and understand General Cleaning, Mechanical Cleaning, Chemical Cleaning, and Activation methods prior to Plating.	10	GEN	AC 7108/9; AC 7108/10; ASTM-B322; ISO 27831
13.	Know and understand how to correct or adjust the ASF/plating current for the Plating process.	3	GEN	AC 7108/9; AC 7108/10
14.	Know and understand the impact of material hardness pre and post plating	7	GEN	AC 7108/9; AC 7108/10
15.	Know when and why pre-plate stress relief is required	7	GEN	AC 7108/9; AC 7108/10
16.	Know and understand Post Plate Hydrogen embrittlement relief requirements	7	GEN	AC 7108/9; AC 7108/10
17.	Understand the need for pre-process checks (such as calibration status and solution	10	GEN	AC 7108
40	temperatures and understand proper verification methods.	40	CEN	AC 7409
18. 19.	Understand the mechanics and importance of Racking, Part Set-Up, and Masking.  Know how to recognize unsafe and/or inappropriate work practices.	10 7	GEN GEN	AC 7108 AC 7108; ISO 14001;
13.	Triow now to recognize unsafe and/or mappropriate work practices.	•	GLIN	OHSAS 18001
20.	Know and understand the effects and aspects of the Plating process on different alloys and materials (including chemicals, masking materials, tanks, work environment, etc.)	3	GEN	AC 7108/9; AC 7108/10
21.	Understand how to deal with incorrect or inappropriate Plating.	3	GEN	AC 7108/9; AC 7108/10
22.	General knowledge and understand of all the Plating processes and methods.	7	GEN	AC 7108/9; AC 7108/10
	CORROSION PROTECTION/ENGINEERING PLATING (CHROMIUM, NICKEL, RHODIUM, TIN)			
23.	Be aware of substrate requirements for this type of plating.	3	GEN	AMS-QQ-C-320; MIL-C-
24.	Know cleaning and activation steps and restrictions for this type of plating.	7	GEN	23422; MIL-STD-1501;
25.	Understand "Accept & Reject" Criteria and testing for this type of plating.	7	GEN	AMS 2406; AMS 2460;
26.	Understand how to identify which features require plating, masking, etc. as required by governing engineering documents.	3	GEN	BAC 5709; MIL-STD- 14538; AMS-QQ-N-290;
27.	Understand the environmental, worker safety and health concerns associated with this type of plating.	3	GEN	AMS 2403; AMS 2417; SAE-AMS-C-26074; MIL- P-27418; MIL-P-18317; MIL-R-46085; AMS 2408; ASTM B545;
	SACRIFICIAL PLATING (CADMIUM, ZINC)			
28.	Be aware of substrate requirements for this type of plating in particular, pits,	3	GEN	SAE-AMS-QQ-P-416;

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	scratches, surface roughness, etc.			AMS 2400; SAE-AMS-
29.	Know cleaning and activation steps and restrictions for this type of plating.	7	GEN	QQ-Z-325; ASTM B633;
30.	Understand "Accept & Reject" Criteria and testing for this type of plating.	7	GEN	AMS 2417
31.	Understand how to identify which features require plating, masking, etc. as required	3	GEN	_ /
32.	by governing engineering documents.  Understand the environmental, worker safety and health concerns associated with	3	GEN	-
	this type of plating. PLATING FOR ELECTRONICS (COPPER, TIN-LEAD)			
33.	Be aware of substrate requirements for this type of plating.	3	GEN	MIL-C-14550; AMS 2418;
34.	Know cleaning and activation steps and restrictions for this type of plating.	7	GEN	MIL-P-81728; SAE-AMS-
35.	Understand "Accept & Reject" Criteria and testing for this type of plating.	7	GEN	P-81728
36.	Understand how to identify which features require plating, masking, etc. as required by governing engineering documents.	3	GEN	
37.	Understand the environmental, worker safety and health concerns associated with this type of plating.	3	GEN	-
	PRECIOUS METALS PLATING (GOLD, PALLADIUM, PLATINUM, SILVER)			
38.	Be aware of substrate requirements for this type of plating.	3	GEN	MIL-G45204; MIL-P-
39.	Know cleaning and activation steps and restrictions for this type of plating.	7	GEN	45209; ASTM B679; SAE-
40.	Understand "Accept & Reject" Criteria and testing for this type of plating.	7	GEN	AMS-QQ-S-365; ASTM
41.	Understand how to identify which features require plating, masking, etc. as required	3	GEN	B700; AMS 2410; AMS
	by governing engineering documents.			2411; AMS 2412;
42.	Understand the environmental, worker safety and health concerns associated with this type of plating.	3	GEN	
	SKILLS:  Defined within these rolls describes the range of skills. The skills required to perform a particular special process task			
	READ AND UNDERSTAND WRITTEN INSTRUCTIONS:			
43.	Ability to understand specification requirements and customer flow-down requirements.	10	GEN	AC 7004; AS 9100; AC 7108
44.	Apply plating techniques appropriately.	10	GEN	AC 7108/9; AC 7108/10
45.	Verify and validate the plating results.	3	GEN	AC 7108/9; AC 7108/10
46.	Properly report nonconformance.	10	GEN	AC 7004; AS 9100; AC 7108
47.	Apply technical knowledge in a skillful way when solving problems.	10	GEN	AC 7004; AS 9100; AC 7108
48.	Be familiar with the scope and limitations of plating.	10	GEN	AC 7108/9; AC 7108/10
49.	Use of appropriate equipment for the plating process.	3	GEN	AC 7108/9; AC 7108/10
50.	Ability to follow instructions.	10	GEN	AC 7004; AS 9100; AC 7108
51.	Interpretation of an acceptable plating process.	10	GEN	AC 7108/9; AC 7108/10
52.	Must be able to read drawings and specifications.	10	GEN	AC 7004; AS 9100; AC 7108
53.	Must be able to interpret specification requirements.	10	GEN	AC 7004; AS 9100; AC 7108
54.	Must be able to set-up operations (equipment, rates, timers & temperatures) including alternate procedures as appropriate.	10	GEN	AC 7004; AS 9100; AC 7108
55.	Must be able to understand and interpret shop travelers.	10	GEN	AC 7004; AS 9100; AC
	PERSONAL ATTRIBUTES:			7108
	Are statements that will enable judgment of the person's personal attributes			
56.	Be able to work independently with a minimum of supervision.	3	GEN	General Industry
57.	Must have a high degree of integrity	10	GEN	General Industry
58.	Be attentive to details	10	GEN	General Industry
59.	Be flexible	3	GEN	General Industry
60.	Tolerate stress	7	GEN	General Industry
61.	Exhibit conflict resolution	3	GEN	General Industry
62.	Decision making ability Team Worker	3 10	GEN GEN	General Industry
63. 64.	Ethical Behavior	10	GEN	General Industry
65.	Exhibit Leadership	10	GEN	General Industry
00.	EXPERIENCE:			
	Are the minimum experience requirement expected to demonstrate their competence.			
	EDUCATION:			
66.	High School Diploma or GED or Secondary Education	10	GEN	General Industry
67.	Apprenticeship	7	GEN	General Industry
68.	Industry Training or Courses	3	GEN	General Industry
	TRAINING / HANDS-ON-EXPERIENCE:			
	Complete on the job training: Minimum number of hours-			

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69.	OPERATOR – 160 Hours	10	GEN	General Industry
70.	PLANNER – 160 Hours			
71.	OWNER – 640 Hours			
	NON-SPECIAL PROCESS RELATED REQUIREMENTS:			
	Defined within these rolls are other general or pre-requisite needed			
72.	Capability to lift up to 50 lbs. (23 kg)	7	GEN	General Industry
73.	Able to deal with repetitive bending and stooping	10	GEN	General Industry
74.	General understand of Quality Systems AS/EN/JISQ 9100, or AC 7004, or equivalent	3	AS	AS/EN/JISQ 9100 AC7004
	SAFETY & ENVIRONMENTAL REQUIREMENTS:			
75.	Knowledge and understanding of safety and handling of hazardous material, chemicals, etc. including safe storage, interpretation of Health & Safety Data Sheets and Regulatory Requirements.	7	GEN	AC 7108; ISO 14001; OHSAS 18001
76.	Understand Safety Data Sheets (SDS) and Personal Protective Equipment Requirements: When and how to use appropriate personal protective equipment (goggles, gloves, rubber boots, aprons, etc.)	7	GEN	AC 7108; ISO 14001; OHSAS 18001
77.	Understand which personal protective equipment to use, when and why.	10	GEN	AC 7108; ISO 14001; OHSAS 18001
78.	Understand the safe storage, shelf life and mixing of chemicals.	10	GEN	AC 7108; ISO 14001; OHSAS 18001
79.	Ability to recognize symbols associated with chemicals and their usage.	10	GEN	AC 7108; ISO 14001; OHSAS 18001

# 7. DOCUMENT REVISION HISTORY

REVISION DATE	SUMMARY
17 May 2018	Updated to new template
16 November 2018	Reviewed by eQualified Content Developer to ensure document is up to date.
4 December 2019	Editorial revision to update program name from eQualified to PRI Qualification <sup>SM.</sup>

# ADDENDUM 1

# LIST OF INTERNATIONAL STANDARDS & REFERENCE DOCUMENTS FOR PLATING PROCESSES

SPECIAL	DOCUMENT TITLE	DOCUMENT NUMBER	
PROCESS		10.700	
Quality	Audit Criteria for Aerospace Management System	AC 7004	
Chemical Process	Audit Criteria for Chemical Processing	AC 7108	
Chemical Process	Audit Criteria for Electroless Plating	AC 7108/10	
Chemical Process	Audit Criteria for Surface Preparation Prior to Metal Bond	AC 7108/3	
Chemical Process	Audit Criteria for Electroplating and Electroforming	AC 7108/9	
Cadmium Plating	Cadmium Plating	AMS 2400	
Nickel Plating	Plating, Nickel, General Purpose	AMS 2403	
Chromium Plating	Plating, Chromium, Hard Deposit	AMS 2406	
Tin Plating	Plating, Tin	AMS 2408	
Silver Plating	Plating, Silver, Nickel Strike, High Bake	AMS 2410	
Silver Plating	Plating, Silver, for High Temperature Applications	AMS 2411	
Silver Plating	Plating, Silver, Copper Strike, Low Bake	AMS 2412	
Zinc Nickel Plating	Plating, Zinc-Nickel Alloy	AMS 2417	
Copper Plating	Plating, Copper	AMS 2418	
Gold Plating	Plating, Gold	AMS 2422	
Chromium Plating	Plating, Chromium	AMS 2460	
Quality	Quality Management System-Requirements for Aviation, Space and Defense Organization	AS 9100	
Chemical Process	Standard Guide for Cleaning Metals Prior to Electroplating	ASTM B322	
Tin Plating	Standard Specification for Electrodeposited Coatings of Tin	ASTM B545	
Zinc Plating	Standard Specification for Electrodeposited Coatings of Zinc on Iron and Steel	ASTM B633	
Palladium Plating	Standard Specification for Electrodeposited Coatings of Palladium for Engineering Use	ASTM B679	
Silver Plating	Standard Specification for Electrodeposited Coatings of Silver for Engineering Use	ASTM B700	
Chromium Plating	Cadmium Plating Types I, II & III	BAC 5709	
Safety	Occupational Health and Safety Management	BS OHSAS 18001	
Environment	Environment Management System	ISO 14001	
Chemical Process	Metallic and other inorganic coatings Cleaning and preparation of metal surfaces	ISO 27831	
Copper Plating	Military Specification: Copper Plating (Electrodeposited)	MIL-C-14550	
Chromium Plating	Chromium Plating, Electrodeposited	MIL-C-23422	
Gold Plating	Military Specification Gold Plating Electrodeposited	MIL-G-45204	
Nickel Plating	Plating, Black Nickel (Electrodeposited) On Brass, Bronze, Or Steel	MIL-P-18317	
Sulfamate Nickel	Military Specification: Plating, Soft-Nickel Electrodeposited Sulfamate Bath	MIL-P-27418	
Palladium Plating	Military Specification: Palladium Plating (Electrodeposited)	MIL-P-45209	
Tin-Lead Plating	Military Specification: Electrodeposited or Hot Dipped, For Ferrous & Non-Ferrous Metals	MIL-P-81728	
Rhodium Plating	Military Specification: Rhodium Plating (Electrodeposited)	MIL-R-46085	
Chromium Plating	Chromium Plating, Black (Electrodeposited)	MIL-STD-14538	
Chromium Plating	Chromium Plating, Low Embrittlement, Electrodeposition	MIL-STD-1501	
Brush Plating	Military Standard: Selective (Brush Plating) Electro-Deposition	MIL-STD-865	
Tin Plating	Military Specification: Electrodeposited or Hot Dipped, For Ferrous & Non-Ferrous Metals	MIL-T-10727	
Chromium Plating	Chromium Plating (Electrodeposited)	SAE AMS-QQ-C-320	
Cadmium Plating	Plating Cadmium (Electrodeposited)	SAE AMS-QQ-P-416	
Electroless Nickel Plating	Military Specification: Coatings – Electroless Nickel	SAE-AMS-C-26074	
Nickel Plating	Electroless Nickel Coatings	SAE-AMS-C-26074	
Tin-Lead Plating	Plating, Tin-Lead (Electrodeposited)	SAE-AMS-P-81728	
Nickel Plating	Federal Specification: Nickel Plating (Electrodeposited)	SAE-AMS-QQ-N-290	
Silver Plating	Federal Specification: Silver Plating, Electrodeposited)	SAE-AMS-QQ-S-365	
Zinc Plating	Federal Specification: Zinc Coating, Electrodeposited	SAE-AMS-QQ-Z-325	
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## ADDENDUM 2

## ADDITIONAL SAFETY & ENVIRONMENTAL REQUIREMENTS

## REACH REGULATION INFORMATION

Several metal finishing processes (painting, anodize, chromate conversion, passivate, electroplating) may have REACh regulated substances that are either used as process chemicals or are contained within the finished product after a process is completed. Chemical suppliers are obliged to provide a legislatively compliant safety data sheet. Below are topics of concern that a chemical processing owner should be aware of and have adequate understanding if products are produced within or shipped to the European Union.

- REACh (Regulation on Registration, Evaluation, Authorization and Restriction of Chemicals)
- Affects raw materials/substances that go into products either produced within or shipped to the European Union.
- •Under EU REACh regulation, substances that are one of the following can be regarded as substance of very high concern (SVHC):
  - ocarcinogenic, mutagenic or toxic to reproduction (CMRs);
  - opersistent, bio-accumulative and toxic (PBTs);
  - overy persistent and bio-accumulative (vPvBs);
  - oseriously and / or irreversibly damaging the environment or human health, as substances damaging the hormone system;
- •The SVHC candidate list is a moving target that will continue to grow with 168 substances as of January 2016. This list is reviewed nominally twice a year by ECHA.
- Some typically used SVHC's contained in or used but not limited to during chemical processing are;
  - Cadmium
  - Strontium Chromate
  - oChromium trioxide
  - oSodium dichromate
- •SVHC content is allowable up to 0.1% of an article produced within or shipped to the EU.
- Additionally, SVHC's may at some time be added to the Authorization List known as Annex 14 or XIV which contains a sunset date for each SVHC in this list.
- •Owner needs to be aware of sunset dates for SVHC's contained in the Authorization list. Once an SVHC from the Authorization List reaches the sunset date, it can no longer be used in the EU without specific authorization from ECHA (European Chemicals Agency).
- •Manufacturing sites either located within or if shipping product to the EU must comply with all aspects of REACh. Chemical suppliers in the EU must provide safety data sheets that reflect any conditions of an authorization.
- •Further information/current SVHC and Authorization list with sunset dates can be obtained by accessing (<a href="http://www.echa.europa.eu/web/guest/candidate-list-table">http://www.echa.europa.eu/web/guest/candidate-list-table</a>)