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Program Document CPBOK

PD 6103

CPBoK-009/PL-2 REV. A

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BODY OF KNOWLEDGE:

ROLE DESCRIPTION: PLANNER

SPECIAL PROCESS: CHEMICAL PROCESSING

METHOD: PAINTING AND APPLICATION OF DRY FILM LUBRICANT

All PRI QualificationSM program examinations are created using the applicable PRI QualificationSM 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 QualificationSM Body of Knowledge Review Boards. All BoKs are updated periodically according to the latest revision of PRI QualificationSM 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 QualificationSM program Chemical Processing Body of Knowledge Review Board (CP-BoKRB) according to the requirements of PD6100.

This document constitutes the PRI QualificationSM program BoK for Chemical Processing, Painting and Application of Dry Film Lubricants for the Planner Level. It defines the baseline knowledge and experience required to be considered competent to perform this role.

Unless otherwise stated, the CP-BoK RB 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 QualificationSM program examination candidate preparation
- Chemical Processing Examination Review Board (CP-ERB) for the development of PRI QualificationSM program examinations
- Candidates taking PRI QualificationSM program examinations who wish to prepare in advance

2. REFERENCES

PRI QualificationSM program documents:

PD6000	Governance & Administration of PRI Qualification SM 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 QualificationSM 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. Skill is 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

4. GUIDANCE TO EXAMINATION CANDIDATES

All PRI QualificationSM program examination candidates are recommended to read all documents referenced in section 2 of this document.

As stated in PRI QualificationSM program document PD6200, 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

Descriptors	Level		
	Operator (OP) / Technician (T)	Planner (PL)	Owner (OW)
	<i>For descriptions, please refer to current version of PD6000</i>	<i>For descriptions, please refer to current version of PD6000</i>	<i>For descriptions, please refer to current version of PD6000</i>
Painting and Application of Dry Film Lubricant Process Specific Criteria	No additional criteria for the Painting and Application of Dry Film Lubricant process.	No additional criteria for the Painting and Application of Dry Film Lubricant process.	No additional criteria for the Painting and Application of Dry Film Lubricant process.
Technical Knowledge	Basic knowledge of the Painting process and application of Dry Film Lubricants, its main processes, methods and tools.	Good level of knowledge in all aspects of the Painting process and application of Dry Film Lubricants, all its processes, methods and tools. Ability to coach others on contents and methods in the context of their workplace.	High or extensive knowledge in all aspects of the Painting process and application of Dry Film Lubricants, all its processes, methods and tools to assess and validate improvements. 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 as a specialist within the special process.
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 System Requirements.		

6. TABLE 1

ROLE DESCRIPTION: Planner

SPECIAL PROCESS: Chemical Processing

METHOD: Painting and Application of Dry Film Lubricant

REFERENCE GUIDELINES: *Addendum 1 is a list of the International Standards and Reference Documents applicable to Painting and Application of Dry Lubricant Film processes.*

Row #	COMPETENCE	Weight (1,3,7,10)	Exam Type Written / Practical	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	Written	AC 7108
2	Full and complete understanding of Internal Work instructions	10	Written	AC 7108
3	Know how to access customer specifications and requirements (i.e. where to find them).	7	Written	AC 7108
4	Understand how to interpret customer specification and requirements in the context of performing the Paint process.	3	Written	AC7108
5	Understand Industry Standards	7	Written	AC7108
6	Knowledge and understanding of the Accept/Reject Criteria for Paint / Dry Film, including thickness, adhesion and cure	7	Written	AC 7108, ASTM D3359
7	Knowledge of the Surface Preparation procedures	7	Written	AC7108
8	Have an awareness of the basic control and calibration requirements for equipment.	10	Written	AC7108
9	Know how to perform any cleanliness requirements for paint booth	10	Written	AC 7108/1
10	Knowledge and understanding of mathematics, including decimal and fractions	7	Written	General Industry
11	Know how to use precision measuring instruments and equipment	10	Written	General Industry
12	Know and understand Job Documentation including awareness of Fixed and Frozen Process requirements.	10	Written	AC7108
13	Know and understand the significance of delays between Surface Preparation and Painting operations.	10	Written	AC 7108/1
14	Have an awareness of Surface Preparation prior to Painting including General Cleaning, Mechanical Cleaning and Chemical Cleaning prior to Painting.	7	Written	AC 7108/1
15	Know and understand the importance of cleanliness of the work area.	10	Written	AC7108
16	Understand the importance of temperature control for paint storage and the need for the paint to be at the correct temperature before mixing or spraying.	10	Written	AC7108 AC7108/1
17	Know and understand how to mix, measure viscosity of paints and proper use of Zahn cups.	10	Written	AC 7108 AC7108/1
18	Know and understand how paint is cured and how to adjust the curing condition to match the paint.	10	Written	AC7108/1
19	Know and understand key paint Test Procedures such as airline cleanliness, visual, thickness, adhesion & cure etc.	10	Written	AC7108/1
20	Know and understand the importance of Part Set-Up and Masking. Especially matching masking materials to curing conditions and the need to remove inappropriate material and residues before curing.	10	Written	AC7108/1
21	Knowledge and understand about the selection of appropriate equipment for use in the Painting process.	10	Written	AC7108/1
22	Understand the need for pre-process checks (such as calibration status and environmental conditions).	10	Written	AC 7108 AC7108/1
23	Understand the mechanics and importance of allowing carriers (Solvent and Water) to Flash Off between coats and before curing,	10	Written	AC7108/1
24	Thoroughly understand the Painting process and an awareness of the different types of paints.	10	Written	AC7108/1
25	Have an awareness of the effects on painting of various pre-treatments such as blasting, chemical conversion coating anodizing, previous painting etc. on the paint application process.	7	Written	AC7108/1
26	Have an awareness of the Curing including Infrared and Thermal Curing, and the potential impact of the curing cycle on temperature sensitive substrates such as composites and some aluminum alloys,	7	Written	AC7108/1
27	Have an awareness of the significance of temperature and humidity on painting and curing.	10	Written	AC7108/1
28	Understand the importance and the need for keeping paint records.	10	Written	AC7108/1
29	Knowledge and ability to write and review internal procedures and practices.	7	Written	AC7108/1
30	Know how to recognize unsafe and/or inappropriate work practices.	10	Written	General Industry
31	Understand how to deal with incorrect or inappropriate Painting.	10	Written	AC7108/1

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32	Know and understand how to review and take action on Paint test result data.	10	Written	AC7108/1
33	General knowledge and understanding of all the Painting processes including the general concepts of color and gloss.	7	Written	AC7108/1
	ONE PACK PAINTING (paints that can be used as supplied or with addition of a thinner only)			
34	Know uses, features and applications for this type of Paint.	7	Written	AC7108/1
35	Understand the limitations for this type of Paint.	7	Written	AC7108/1
36	Understand the Technical Data Sheets for this type of Paint.	10	Written	AC7108/1
37	Understand the mixing requirements for this type of Paint	10	Written	AC7108/1
38	Understand the curing requirements for this type of Paint	10	Written	AC7108/1
39	Understand the application requirements for this type of Paint	10	Written	AC7108/1
40	Have an awareness of the potential impact of high curing cycles on temperature sensitive substrates.	7	Written	AC7108/1
41	Have an awareness of the environmental, worker safety and health concerns associated with this type of Paint.	7	Written	General Industry
	MULTI-PACK PAINTING (Paints made by mixing two or more constituents such as base & hardening or curing agents)			
42	Know uses, features and applications for this type of Paint.	7	Written	AC7108/1
43	Have an awareness of the limitations for this type of Paint.	7	Written	AC7108/1
44	Understand the Technical Data Sheets for this type of Paint.	10	Written	AC7108/1
45	Understand the mixing requirements for this type of Paint including the pigmented constituent and using the correct ratios	10	Written	AC7108/1
46	Understand the curing requirements for this type of Paint	10	Written	AC7108/1
47	Understand the application requirements for this type of Paint	10	Written	AC7108/1
48	Understand the significance of Multipack paints including induction times, pot life and using the correct components.	10	Written	AC7108/1
49	Knowledge of the difference between Manufacture's shelf life and Open Tin shelf life.	10	Written	AC7108/1
50	Understand the environmental, worker safety and health concerns associated with this type of Paint.	7	Written	General Industry
	PRIMER APPLICATION			
51	Know the uses, features and applications for this type of paint.	7	Written	AC7108/3, MIL-C-8507, MIL-PRF-23377
52	Know and understand the limitations for this type of Paint.	7	Written	AC7108/3
53	Know and understand the difference between primer types such as bond primers, wash primers and normal primers and the differences in their storage, mixing and application.	7	Written	AC7108/3
54	Understand the need for and reactivation of old primed substrates	10	Written	AC7108/3
55	Understand the mixing requirements for this type of Paint including the pigmented constituent and using the correct ratios	10	Written	AC7108/3
56	Understand the curing requirements for this type of Paint	10	Written	AC7108/3
57	Understand the application requirements for this type of Paint	10	Written	AC7108/3
58	Have an awareness of the environmental, worker safety and health concerns associated with these types of Paint.	7	Written	General Industry
	TOP COAT PAINT APPLICATION			
59	Have an awareness of uses, features and applications for this type of Paint.	7	Written	AC7108/1, ASTM D16, MIL-DTL-24441D
60	Know and understand the limitations for this type of Paint.	7	Written	AC7108/1, ASTM D16,
61	Understand the need for and reactivation of old primed substrates	10	Written	AC7108/1, ASTM D16,
62	Have an awareness of the need to know paint thickness of primer in order to measure that of the Topcoat.	10	Written	AC7108/1, ASTM D16, ASTM D823
63	Know and understand the impact of spraying and curing conditions on the final appearance of Topcoat Paints.	10	Written	AC7108/1, ASTM D16,
64	Have an awareness of the importance of color and gloss to topcoat painting.	7	Written	AC7108/1, ASTM D16,
65	Understand the mixing requirements for this type of Paint including the pigmented constituent and using the correct catalysts and mixing ratios	10	Written	AC7108/1, ASTM D16,
66	Understand the curing requirements for this type of Paint	10	Written	AC7108/1, ASTM D16,
67	Understand the application requirements for this type of Paint	10	Written	AC7108/1, ASTM D16,
68	Have an awareness of the environmental, worker safety and health concerns associated with these types of Paint.	7	Written	General Industry
	DRY FILM LUBRICANT APPLICATION			
69	Have an awareness of uses, features and applications for this type of Coating	7	Written	AC7108/1, SAE AS5272, ASTM D5796
70	Have an awareness of the limitations for this type of Coating.	7	Written	AC7108/1, SAE AS5272
71	Understand the build-up of thicker films.	10	Written	AC7108/1, SAE AS5272
72	Understand the mixing requirements for this type of Coating	10	Written	AC7108/1, SAE AS5272
73	Understand the curing requirements for this type of Coating	10	Written	AC7108/1, SAE AS5272
74	Understand the application requirements for this type of Coating	10	Written	AC7108/1, SAE AS5272
75	Have an awareness of the local regulations, environmental, worker safety and health concerns associated with these types of Coating	7	Written	AC7108/1, SAE AS5272
76	Knowledge of proper cleaning of paint guns, hoses and other equipment.	3	Written	AC7108/1, SAE AS5272
77	Knowledge of proper painting techniques: Spray Application; Mixing of bases and curing solutions for primers and paints; Measuring of paint viscosity; Water-break free testing; Identification of improper and/or unacceptable finish application	7	Written	AC7108/1, AC7108/3, SAE AS5272

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78	Knowledge and ability to perform thickness and dry/wet tape adhesion tests.	10	Written	AC7108/1, SAE AS5272, ASTM D5796, ASTM D3359, AC7108/4
79				
80	Knowledge of temperature limitations for accelerated cures.	7	Written	AC7108/1, SAE AS5272
81	Knowledge of paint stripping and removal for rework purposes.	7	Written	AC7108
SKILLS:				
Defined within these rolls describes the range of skills. The skills required to perform a particular special process task				
82	READ AND UNDERSTAND WRITTEN INSTRUCTIONS:	10	Written	General Industry
83	Ability to understand specification requirements and customer flow-down requirements	10	Written	General Industry
84	Apply Painting techniques appropriately	10	Written	General Industry
85	Verify and validate the Painted results.	10	Written	General Industry
86	Properly report non-conformances	10	Written	AC7108
87	Apply technical knowledge in a skillful way when solving problems	7	Written	General Industry
88	Be familiar with the scope and limitations of Painting.	7	Written	General Industry
89	Use of appropriate equipment for the Painting process.	10	Written	General Industry
90	Ability to follow instructions	10	Written	General Industry
91	Ability to write Work Instructions and Procedures	7	Written	General Industry
92	Interpretation of an acceptable Painting process	7	Written	General Industry
93	Must be able to read drawings and specifications	10	Written	General Industry
94	Must be able to interpret specification requirements	10	Written	General Industry
95	Must be able to set-up operations (equipment e.g., gravity fed guns, viscosity, timers & temperatures) including alternate procedures as appropriate	7	Written	General Industry
96	Must be able to understand and interpret shop travelers	10	Written	AC7108
97	Ability to identify training needs and coordinate the training	7	Written	AC7108
98	Be able to identify strengths and weaknesses in the personnel involved in the painting activity	3	Written	AC7108
Sequencing				
99	Has an appropriate understanding of where this process falls in the sequence of events.	3	Written	General Industry
PERSONAL ATTRIBUTES:				
Are statements that will enable judgment of the person's personal attributes				
100	Be able to work independently with a minimum of supervision	10	N/A	General Industry
101	Must have a high degree of integrity	10	N/A	General Industry
102	Be attentive to details	10	N/A	General Industry
103	Be flexible	7	N/A	General Industry
104	Tolerate stress	7	N/A	General Industry
105	Exhibit conflict resolution	7	N/A	General Industry
106	Decision making ability	10	N/A	General Industry
107	Team Worker	10	N/A	General Industry
108	Ethical Behavior	10	N/A	General Industry
109	Exhibit Leadership	7	N/A	General Industry
EXPERIENCE:				
Are the minimum experience requirement expected to demonstrate their competence.				
EDUCATION:				
110	High School Diploma or GED or Secondary Education	10	N/A	General Industry
111	Apprenticeship	3	N/A	General Industry
112	Industry Training or Courses	3	N/A	General Industry
113	TRAINING / HANDS-ON-EXPERIENCE:	10	N/A	General Industry
114	Complete on the job training: Minimum number of hours-		N/A	
115	OPERATOR – 160 Hours		N/A	General Industry
116	PLANNER – 160 Hours	10	N/A	General Industry
NON-SPECIAL PROCESS RELATED REQUIREMENTS:				
Defined within these rolls are other general or pre-requisite needed				
117	Capability to lift up to 30 lbs. (e.g. up to 14 kg)	7	Written	General Industry
118	Able to deal with repetitive bending and stooping	7	Written	General Industry
119	General understand of Quality Systems AS/EN/JISQ 9100, or AC 7004, or equivalent	7	Written	General Industry
120	SAFETY & ENVIRONMENTAL REQUIREMENTS:		Written	
121	Knowledge and understanding of safety, and handling and disposal of hazardous materials, paints, etc. including safe storage, interpretation of Health & Safety Data Sheets and Regulatory Requirements.	10	Written	AC7108
122	Understand Safety Data Sheets (SDS) and Personal Protective Equipment Requirements: When and how to use appropriate personal protective equipment (masks, respirators, gloves, aprons, etc.)	10	Written	Environmental Laws & Regulations
123	Ability to prepare and administer appropriate safety and environmental procedures and controls.	10	Written	General Industry
124	Understand which personal protective equipment to use, when and why	10	Written	General Industry
125	Understand the safe storage, shelf life and mixing of paints, solvents and chemicals	10	Written	AC7108
126	Ability to recognize symbols associated with paint related products and their usage	10	Written	AC7108

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127	General understanding of Quality System, AS/EN/JISQ 9100 or AC7004 or equivalent	7	Written	AC7108
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7. DOCUMENT REVISION HISTORY

REVISION DATE	SUMMARY
04Oct17	Updated to new BoK Template
16Nov18	Reviewed by eQualified Content Developer to ensure it was up to date
3 December 2019	Editorial revision to update program name from eQualified to PRI Qualification SM .

ADDENDUM 1

LIST OF INTERNATIONAL STANDARDS & REFERENCE DOCUMENTS FOR CHEMICAL PROCESSING

SPECIAL PROCESS	DOCUMENT TITLE	DOCUMENT NUMBER
Chemical Process	Nadcap Audit Criteria for Chemical Processing	AC 7108
Chemical Process	Nadcap Audit Criteria for Application of Painting & Dry Film Lubricants and Application of Sol Gel as a Preparation for Paint	AC 7108/1
Chemical Process	Nadcap Audit Criteria for Surface Preparation Prior to Metal Bond	AC 7108/3
Chemical Process	Lubricant Application, Solid Film, Heat Cured, Corrosion, Inhibiting	AS5528
Chemical Process	Standard Test Method for Measurement of Coating Thicknesses by the Magnetic Method: Nonmagnetic Coatings on Magnetic Basis Metal	ASTM B499
Chemical Process	Standard Terminology for Paint, Related Coatings, Materials, and Applications	ASTM D16
Chemical Process	Standard Test Method for Adhesion of Solid Film Lubricants	ASTM D2510
Chemical Process	Standard Test Methods for Measuring Adhesion by "Tape Test	ASTM D3359
Chemical Process	Standard Test Method for Hydrophobic Surface Films by the Water-Break Test	ASTM F22
Chemical Process	Standard Test Method for Measurement of Dry Film Thickness	ASTM-D5796
Chemical Process/Paint	Standard Practice for Thickness of Paint	ASTM-D-823
Chemical Process	Coating, Wash primer (Pretreatment) for metals, Application of (for Aeronautical Use)	MIL-C-8507
Chemical Process	Finishes, Organic, Weapons Systems, Application and Control of	MIL-DTL-18264
Chemical Process/Paint	Paint, Epoxy-Polyamide General Specification for	MIL-DTL-24441D
Chemical Process	Chemical Agent Resistant Coating System Application Procedures and Quality Control Inspection	MIL-DTL-53072
Chemical Process/Finishes	Organic Weapons Systems, Application and Control of	MIL-F-18264
Chemical Process/Primer	Primer Coating, Epoxy – Polyamide Chemical & Solvent Resistance	MIL-PRF-23377
Chemical Process/Lubricant	Lubricant, Solid Film, Heat Cured, Corrosion Inhibiting, Procurement Specification	SAE AS5272E

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):
 - carcinogenic, mutagenic or toxic to reproduction (CMRs);
 - persistent, bio-accumulative and toxic (PBTs);
 - very persistent and bio-accumulative (vPvBs);
 - seriously 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
 - Chromium trioxide
 - Sodium 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 (<http://www.echa.europa.eu/web/guest/candidate-list-table>)