

Space product assurance

The application of the black
electrically conductive coating
Aeroglaze H322

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Foreword

This Standard is one of the series of ECSS Standards intended to be applied together for the management, engineering and product assurance in space projects and applications. ECSS is a cooperative effort of the European Space Agency, National Space Agencies and European industry associations for the purpose of developing and maintaining common standards.

Requirements in this Standard are defined in terms of what shall be accomplished, rather than in terms of how to organize and perform the necessary work. This allows existing organizational structures and methods to be applied where they are effective, and for the structures and methods to evolve as necessary without rewriting the standards.

The formulation of this Standard takes into account the existing ISO 9000 family of documents.

This Standard has been prepared by editing the ESA PSS-01-734, reviewed by the ECSS Technical Panel and approved by the ECSS Steering Board.

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Introduction

The most critical use of paints in satellites is in the thermal-control subsystem. Electrically conductive thermal-control paints are utilized to avoid charging-up and discharges in geostationary orbit.

One such paint is Aeroglaze H322 (formerly Chemglaze H322), a proprietary black electrically conductive coating manufactured by Lord Corporation Ltd. Lesonal 01-66050 primer is manufactured by Lesonal GmbH, Germany. The coating is normally used without a primer. Exceptions are in particularly severe conditions such as low temperatures or where the coating is applied on very smooth surfaces (i.e. aluminized side of aluminized Kapton).

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Scope

This Standard defines the process for producing a low outgassing electrically conductive black coating to spacecraft or associated equipment, by means of the application of Aeroglaze H322 (formerly Chemglaze H322) with or without Lesonal 01-66050 primer.

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Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this ECSS Standard. For dated references, subsequent amendments to, or revisions of any of these publications do not apply. However, parties to agreements based on this ECSS Standard are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies.

ECSS-P-001	Glossary of terms
ECSS-Q-20	Space product assurance - Quality assurance
ECSS-Q-20-09	Space product assurance - Nonconformance control system
ECSS-Q-70	Space product assurance - Materials, mechanical parts and processes
ECSS-Q-70-02	Space product assurance - Thermal vacuum outgassing test for the screening of space materials (to be published)
ECSS-Q-70-09	Space product assurance - Measurement of thermo-optical properties of thermal control materials (to be published)
ECSS-Q-70-13	Space product assurance - Measurement of the peel and pull-off strength of coatings and finishes with pressure sensitive tapes
ASTM D257-93	Standard Test Method for DC Resistance or Conductivity of Insulating Materials
ASTM D1005-95	Standard Test Method for Measurement of Dry Film Thickness of Organic Coatings Using Micrometers
ASTM D1400-94	Standard Test Method for Nondestructive Measurement of Dry Film Thickness of Nonconductive Coatings Applied to a Nonferrous Metal Base

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Terms, definitions and abbreviated terms

3.1 Terms and definitions

The following terms and definitions are specific to this Standard in the sense that they are complementary or additional with respect to those contained in ECSS-P-001.

3.1.1 Flammability

A measure of the ease with which a material is set on fire.

3.1.2 Flashpoint

The flashpoint is the lowest temperature at which a material gives off flammable vapour which, when mixed with the test atmosphere and exposed to an ignition source, will provide a non-self sustaining flash.

3.1.3 Hemispherical emittance (ϵ_h)

Is the total energy emitted over the hemisphere above the emitting element for all wavelengths.

3.1.4 Solar absorptance (α_s)

The relationship between the absorptance of a test item irradiated with a solar simulator to the absorptance the test item would experience from the sun.

3.1.5 Toxic

Substances causing serious, acute or chronic effects, even death, when inhaled, swallowed or absorbed through the skin.

3.1.6 Viscosity

A measure of the fluidity of a liquid, in comparison with that of a standard oil, based on the time of outflow through a certain orifice under specified conditions.

3.2 Abbreviated terms

The following abbreviated term is defined and used within this Standard.

Abbreviation	Meaning
RH	relative humidity

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Preparatory conditions

4.1 Hazards, health and safety precautions

The details of hazards for each material used in the process are tabulated in Table 1. In addition, hazards to personnel, equipment and materials shall be controlled and reduced to a minimum.

4.2 Preparation of materials and workpieces

4.2.1 Handling and storage

The conditions for handling and storage of materials used in this process are given in Table 1.

The workpiece or sample shall only be handled with clean nylon or lint-free gloves and shall be stored in a cleanliness controlled area, with an ambient temperature of $(22 \pm 3) ^\circ\text{C}$ and relative humidity of $(55 \pm 10) \%$. Coated surfaces shall be shielded from contact by using polyethylene or polypropylene bags or sheets. Mechanical damage shall be avoided in the standard way by packing the polyethylene- or polypropylene-wrapped workpieces in clean, dust- and lint-free material.

Limited-life materials shall be labelled with their relative shelf-lives and dates of manufacture, or date of delivery if date of manufacture is not known.

4.2.2 Identification

- a. **Materials.** Materials used in this process shall be labelled as stated in sub-clause 4.2.1 (if applicable) and be fully identified by:
 1. Trade name and lot number.
 2. Name of manufacturer or agent through whom the purchase was made.
- b. **Workpiece.** The workpiece submitted for treatment shall as a minimum be identified by:
 1. Name and lot number of item.
 2. Name of manufacturer or supplier through whom item was obtained.
 3. Configuration-control status of the item.

4.2.3 Test samples

For spraying operation samples shall be produced at the same time as the painting operation in order to control the quality of the coating. The test pieces shall be of the same material and be surface treated in the same manner as the work-piece.

For the adhesion test a minimum of 5 samples of dimension 20 mm × 20 mm × 1 mm shall be prepared and tested according to ECSS-Q-70-13.

For the thermo-optical properties measurement at least 4 samples of dimension 20 mm × 20 mm × 1 mm shall be prepared and tested according to ECSS-Q-70-09.

The samples prepared above may be used for paint thickness measurement.

4.3 Procurement

The procurement details for each material used in the process are listed in Table 1.

4.4 Facilities

4.4.1 Cleanliness

The work area shall be clean and free of dust. Air used for ventilation shall be filtered to prevent contamination of the workpieces.

4.4.2 Environmental conditions

The ambient conditions for the process and work areas shall be $(22 \pm 3) ^\circ\text{C}$ with a relative humidity of $(55 \pm 10) \%$ unless otherwise stated. During painting operations the temperature of the workpiece shall not fall below the dew point of the ambient air. If condensation is observed on the workpiece, the painting operation shall be suspended immediately.

4.4.3 Special utilities

- a. **Oven.** Capable of maintaining the workpiece at $(125 \pm 5) ^\circ\text{C}$ in a clean environment.
- b. **Ultrasonic bath.** A combined system should be used, in which ultrasonic cleaning can be followed by vapour cleaning.
- c. **Fume cupboard.** For use when handling N.N. Dimethyl-formamide, paints or solvents.
- d. **Spray booth.** The air flow velocity at the spray table shall be sufficient to prevent dry overspray from settling on surfaces which have been painted and which are still tacky. Vapour from solvents shall be controlled by means of a positive exhaust at the rear of the spray booth.

4.5 Equipment

The following special items of equipment shall be used:

- a. **Spray-gun.** Size and type of spray-gun depend on the size and shape of the workpiece. For most of the work, a standard spray-gun of a good make, preferably with a gravity cup, is adequate. For small areas or places difficult to reach, an airbrush may be used. A spray-gun specifically for Aeroglaze H322. should be reserved.

The spray-gun used for Aeroglaze H322 shall be cleaned with toluene before and after spraying. Clean the spray-gun used for primer with a little 07-30090 thinner.

- b. **Brushes.** For repairing small damaged areas, brushes may be used. They shall be new and cleaned after use with toluene. Never use brushes that have been used for other types of paint.
- c. **Containers.** All containers to be used for preparing paints shall be cleaned and dried carefully so that the paint is not contaminated.
- d. **Test Equipment**
1. For acceptance tests the appropriate test equipment as specified in the following documents, shall be used:

ECSS-Q-70-09	Thermo-optical properties
ECSS-Q-70-13	Adhesion properties
ASTM D257-93	Standard Test Method for DC Resistance or Conductivity of Insulating Materials
ASTM D1005-95	Standard Test Method for Measurement of Dry Film Thickness of Organic Coatings Using Micrometers
ASTM D1400-94	Standard Test Method for Nondestructive Measurement of Dry Film Thickness of Nonconductive Coatings Applied to a Nonferrous Metal Base
 2. Suitable measuring equipment to fulfil the monitoring requirements of the process i.e.:

Temperature	10 °C to 130 °C accurate to ± 1 °C.
Humidity	RH 40 % to 70 % accurate to ± 1 % RH
Weight	Suitable range to weigh paint and thinner
Viscosity	Viscosity cup (Ford or DIN)
Volume	Graduated containers

Table 1: Materials: procurement, storage and hazards

Item no.	Description	Supplier	Storage	Safety precautions
1	Aeroglaze H322	Lord Corp. (Europe) Ltd., Chemical Products Division, Stretford Motorway Estate, Barton Dock Road, Stretford, Manchester M32 0ZH, UK	Shall be stored at a temperature of $(22 \pm 3) ^\circ\text{C}$ in a hermetically sealed tinned container. (Glass shall not be used). Shelf-life is 6 months from date of delivery.	Flashpoint $12,6 ^\circ\text{C}$. The paint shall only be used in well ventilated areas and contact with skin and eyes shall be avoided. Not all health effects have been investigated and it shall be handled with the utmost care. Flammable. Harmful.
2	Lesonal primer 01-66050 including thinner or hardener 07-30090	Lesonal GmbH Sieglestrasse 29, 70469 Stuttgart, Germany	Shall be stored at a temperature of $(22 \pm 3) ^\circ\text{C}$ in tinned metal or polypropylene containers. Shelf-life is 2 years from date of manufacture.	Use paint in well ventilated areas. Contact with skin and eyes shall be avoided. Flammable. Not all health effects have been investigated and utmost care shall be taken.
3	Toluene Analytical grade Water content below $0,05 \%$	Any supplier who meets this specification. (e.g. U.C.B, Fluka or Merck)	Shall be stored at a temperature of $(22 \pm 3) ^\circ\text{C}$ in a hermetically sealed container.	Flashpoint $4 ^\circ\text{C}$. Maximum allowable concentration shall be 200 ppm or 750 mg/m^3 . Use only in well ventilated areas. Contact with skin and eyes shall be avoided. Flammable.
4	Ethane, 1,1,2-trichloro -1,2,2-trifluoro-, Ethane, 1,1-dichloro-1- fluoro-, or equivalent ①	Any suitable supplier.	Shall be stored at a temperature of $(22 \pm 3) ^\circ\text{C}$ in their original containers. Preferably sealed to avoid contamination by improper use.	Shall be used in a well ventilated area in accordance with suppliers data sheet.
5	Isopropanol Analytical grade	As per item 3	As per item 3	Flashpoint $11 ^\circ\text{C}$. Maximum allowable concentration shall be 400 ppm or 980 mg/m^3 . Flammable.

Table 1: Materials: procurement, storage and hazards (continued)

Item no.	Description	Supplier	Storage	Safety precautions
6	Ethanol Analytical grade	As per item 3	As per item 3	Flashpoint 13 °C. Maximum allowable concentration shall be 1 000 ppm or 1 900 mg/m ³ . Flammable.
7	Methanol Analytical grade	As per item 3	As per item 3	Flashpoint 10 °C. Maximum allowable concentration shall be 200 ppm or 260 mg/m ³ . Use only in well ventilated areas. Contact with skin and eyes shall be avoided. Flammable.
8	Xylene Analytical grade	As per item 3	As per item 3	Flashpoint 30 °C. Maximum allowable concentration shall be 100 ppm or 435 mg/m ³ . Use only in well ventilated areas. Contact with skin and eyes shall be avoided. Flammable.
9	N.N. Dimethyl-formamide Analytical grade	As per item 3	As per item 3	Flashpoint 74 °C. Maximum allowable concentration shall be 10 ppm or 30 mg/m ³ . Shall only be used in a fume cupboard. Any contact with skin and eyes shall be avoided by wearing suitable gloves and safety goggles. In the event of any accident with this liquid, medical aid shall be sought at once. Toxic.
10	Polyethylene or polypropylene gloves, bags, sheets without any plasticizer or other contaminants	Any supplier that meets this specification.	Shall be stored in a cleanliness-controlled area to avoid contamination.	-
11	White cotton or nylon gloves ②	As per item 10	As per item 10	-

Table 1: Materials: procurement, storage and hazards (continued)

Item no.	Description	Supplier	Storage	Safety precautions
12	Kimwipes	Kimberley Clark Ltd., UK	As per item 10	-
13	Masking tape: Sellotape D1610 or any tape which does not contaminate the surface of the workpiece	Sellotape Products Ltd., England	Shall be stored at a temperature of $(22 \pm 3) ^\circ\text{C}$ in a cleanliness controlled area. Shelf-life is 12 months.	-
14	Nitrogen, extra dry quality. Dew point less than $-70 ^\circ\text{C}$.	Any supplier that meets this specification.	-	-
15	Paint filters	-	As per item 10	-
16	Scotch-brite Medium grade	3M	As per item 10	-
<p>① The cleaning agents, mentioned under item 4, have ozone depletion coefficients that are considered by some countries to be too high and their use within these countries has been banned. Where the use of either cleaning agent is forbidden, an equivalent product(s) shall be used, providing it exhibits similar cleaning properties and conforms to all other requirements defined in this standard.</p> <p>② Gloves shall not leave any stain on a polished metal surface when they are used.</p>				

Procedures

5.1 Introduction

Depending whether a primer coating is applied one of the following procedures shall be selected and adhered to:

a. **With primer coat**

Process sequence shall be as follows:

1. Pre-treatment (see 5.2);
2. Preparation and application of Lesonal primer (see 5.3);
3. Preparation and application of Aeroglaze H322 (see 5.4).

b. **Without primer coat**

Process sequence shall be as follows:

1. Pre-treatment (see 5.2);
2. Preparation and application of Aeroglaze H322 (see 5.4).

NOTE For instance acceptance criteria and handling of finished items are common to either method.

5.2 Pre-treatment

5.2.1 Cleaning

Surfaces shall be free of dust and grease. This can be achieved by standard cleaning procedures. Before final cleaning all workpieces shall be dry. The final cleaning shall be ultrasonic, followed by vapour cleaning. This should be done in a combined installation with one of the fluorocarbon solvents mentioned in the materials list. Workpieces, especially with complex shapes, shall be ultrasonically cleaned for 1 minute and then transferred to the vapour cleaning compartment. Here they shall be held in the vapour for about 10 seconds and then slowly removed. For large pieces, which cannot be ultrasonically cleaned, surfaces shall be carefully cleaned by hand with cleaning solvents and tissues (e.g. Kimwipes). If a vapour cleaning unit of the desired size is available, the workpieces shall be held for at least one minute in the vapour and then withdrawn slowly to prevent drying marks.

Carbon fibre or fibreglass reinforced materials shall be abraded with medium grade Scotch-brite to remove any traces of release agent used in the lay-up pro-

cedure. After abrasion, the surface shall be washed with distilled water and dried. The surface shall then be scrubbed with isopropanol or ethanol. Rinse with either of the above alcohols, dry and then test for further contamination with the water break-free test. The surface shall remain wet when sprayed with distilled water. There shall not be any running away of the water to reveal grease like patches. Wipe with tissue and leave the surface to dry at least 1 hour before application of paint.

5.2.2 Handling and protection of surfaces.

Unless specified otherwise, all operations following cleaning shall be performed by personnel wearing clean cotton or nylon gloves. The handling of parts shall be kept to a minimum. Gloves shall be changed with sufficient frequency to ensure cleanliness.

Throughout all operations, adequate care shall be taken to avoid contamination of surfaces by e.g. fingerprints, hair or dust. The hardware shall be protected from random temperature extremes, high humidity and physical damage. The paint shall not be applied before any mechanical operations such as machining, drilling, forming or welding. Adhesive bonding on surfaces to be painted shall be completed before paint application.

5.2.3 Masking

Surfaces that shall be free of paint shall be masked with the pressure-sensitive tape named in Table 1 and clean non-absorbent paper. Parts that are subject to damage by tape removal, such as thin-gauge materials or thin plating, parts that are subject to possible contamination by tape adhesive, i.e. optical components, or other temperature control surfaces, shall be noted and suitable protective measures taken. If the wearing of cotton or nylon gloves during masking is not feasible, contact with thermal control surfaces shall be kept to an absolute minimum and the hands of the operators shall be clean. Any areas which may have been touched by hand shall be degreased with one of the solvents mentioned in Table 1.

Parts shall be painted as soon as possible after cleaning. If the time before application is likely to exceed eight hours, the parts shall be stored in polyethylene or polypropylene bags as specified in Table 1.

5.3 Lesonal primer

5.3.1 Preparation

The base constituent 01-66050 shall be stirred thoroughly to disperse the pigment and ensure an homogeneous mixture. The two components of the primer shall be mixed by weight or volume in the following proportions:

Lesonal 01-66050	1 part
Hardener or thinner 07-30090	1 part

After obtaining a homogeneous mixture, filter through a 50 μm mesh nylon filter.

The primer thus prepared shall be used within 12 hours because its adhesion ability deteriorates with longer storage.

5.3.2 Application

Using dry nitrogen as spray gas, a layer of primer of thickness 10 μm - 15 μm shall be applied. On metallic substrates, it is essential to keep the layer as thin as possible in order to retain electrical conductivity from the paint to the substrate.

5.3.3 Curing

The primer shall be cured in a clean and dust-free area for a minimum period of 1 hour. The conductive paint shall be applied within 4 hours.

5.4 Aeroglaze H322 coating

5.4.1 Preparation

The paint shall be shaken for at least 15 minutes in its original container. After the desired amount has been poured into a dry, clean container, 20 % by weight of toluene or xylene shall be added and the mixture homogenized. The amount of toluene required depends on the type of spray gun and shall be established by making test pieces which bear a strongly adhering, homogeneous layer. Once the amount of toluene is defined for a certain set-up, the viscosity shall be measured, and instructions for the workshop set down to obtain good duplication of the process. The paint shall be filtered through a 50 μm mesh filter. Dry nitrogen shall be used as spray gas. This is considered to be the most reliable procedure.

5.4.2 Application

The first layer shall be sprayed until the surface just attains an overall wet appearance. This layer shall then be air-dried for a minimum of 30 minutes to allow the solvent to evaporate. Further layers shall be applied in the same manner to obtain a dry paint thickness of 30 μm - 50 μm . Each layer shall be air-dried for 30 minutes to allow the solvent to evaporate. Each layer shall be applied at an angle of 90° to the previous one in order to obtain a final paint layer of even thickness.

5.4.3 Unmasking

After a drying time of 24 hours at a temperature of $(22 \pm 3)^\circ\text{C}$ in a dust-free room with relative humidity of $(55 \pm 10) \%$, the masking shall be carefully removed. No attempt shall be made to clean the areas covered by tape until after cure.

5.4.4 Curing

The workpiece shall be placed in a clean, controlled oven and baked for 15 minutes at 125 °C and then finally cured for 50 hours at 100 °C or 100 hours at 80 °C.

After final cure, the residual adhesive of the masking tape shall be removed.

5.5 Handling and packaging of finished parts

Conditions of subclause 4.2.1 shall apply.

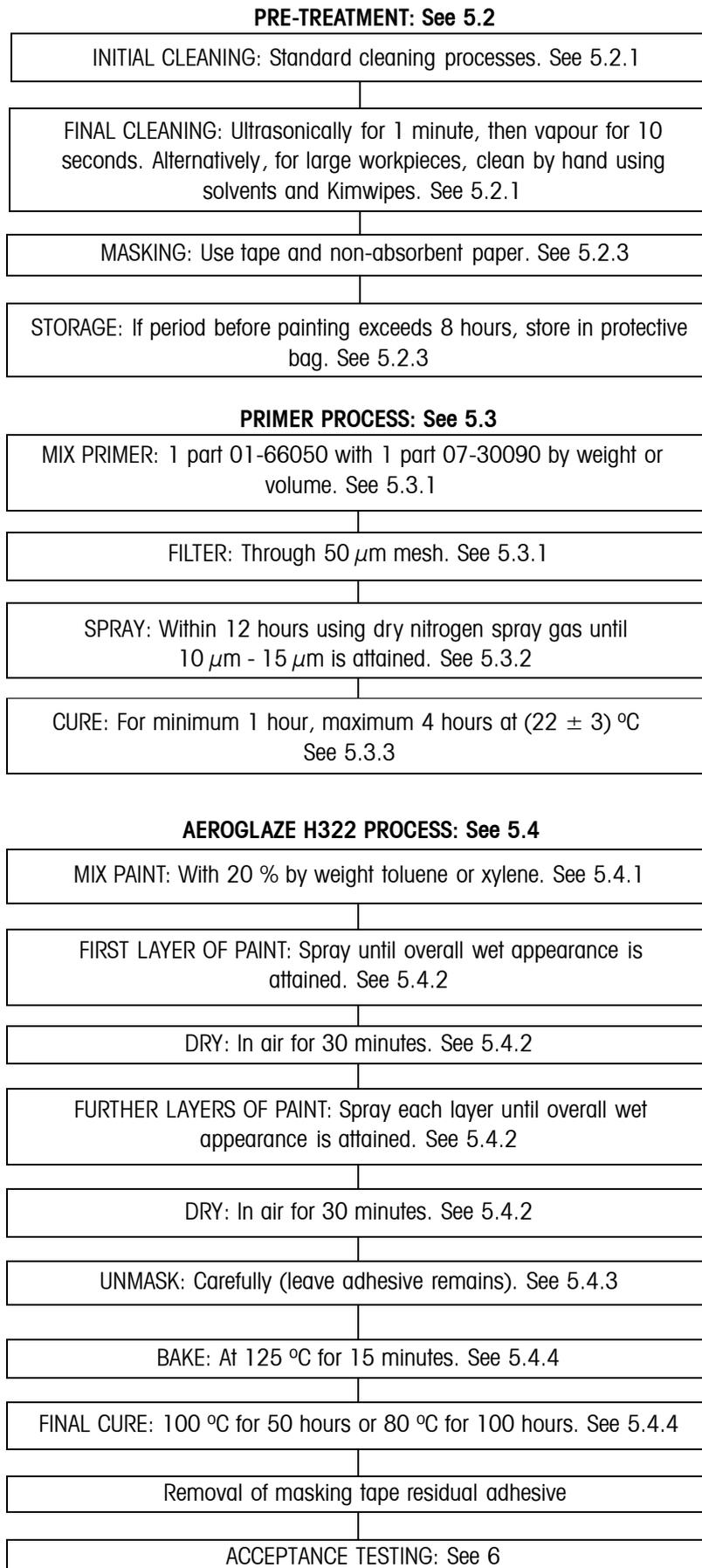


Figure 1: Procedure flow diagram

Acceptance criteria

Test pieces that were prepared at the same time as the workpieces shall be tested for the following properties.

- a. **Thermo-optical properties** shall be measured according to ECSS-Q-70-09. Solar absorptance (α_s) or solar absorptance with portable equipment (α_p) Hemispherical emittance (ϵ_h) or normal emittance with portable equipment (ϵ_n).
- b. **Adhesion properties** shall be measured according to ECSS-Q-70-13. There shall be no sign of paint lifting from the substrate.
- c. **Thickness** shall be measured in accordance with ASTM D1005-95 or ASTM D1400-94. The thickness of the primer shall be 10 μm -15 μm and not less than 30 μm for the Aeroglaze H322.
- d. **Electrical properties** shall be measured in accordance with ASTM D257-93. Acceptance limit: 1 000 Ω square (to be checked for each project).
- e. **Outgassing properties** shall be measured according to ECSS-Q-70-02 acceptance criteria:
 - RML 1 %
 - CVCM 0,1 %

NOTE Since the paint is somewhat hygroscopic, the TML (Total Mass Loss) value can be above 1 %. It is therefore proposed to use the RML (Recovered Mass Loss) value.

Tests detailed in ECSS Standards shall be used whenever possible in preference to other documents.

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Quality assurance

7.1 General

The quality assurance requirements are defined in ECSS-Q-20. Particular attention shall be given to the following points.

7.2 Data

The quality records (e.g. logbooks) shall be retained for at least ten years or in accordance with project contract requirements, and contain as a minimum the following:

- a. copy of the final inspection documentation;
- b. index of limited-life materials and their use times;
- c. nonconformance reports and their corrective actions;
- d. copy of the inspection and test results with reference to relevant procedure;
- e. an event log which is a chronological history of process operations, inspections and tests;
- f. details of failure mode (if applicable).

7.3 Nonconformance

Any nonconformance which is observed in respect of the process shall be dispositioned in accordance with the quality assurance requirements, see ECSS-Q-20-09. However, if reworking or cleaning is recommended the following procedures shall be used:

- a. **Rework and touching up of damaged areas.**

The paint can be stripped by soaking workpieces for about 2 minutes in N.N. Dimethyl-formamide. This shall only be done when no organic materials are attached to the workpieces, because they can be affected. When organic materials cannot be detached, the areas can be moistened with the stripper and the paint removed. After stripping the workpiece shall be cleaned in accordance with subclause 5.2, and repainted in the manner laid down in subclause 5.3 and 5.4. Small areas may be cleaned with toluene and repainted with a brush. They can be handled carefully after 24 hours.
- b. **Cleaning of painted surfaces.**

Cleaning with ethanol, methanol or iso-propanol, with lint-free cloth

(e.g. Kimwipe) does no harm to the properties of the paint. Methyl ethyl ketone shall not be used because it will damage the paint.

c. **Cleaning of unpainted areas.**

If tape adhesive remains on the unpainted surface, it shall be cleaned off carefully with any of the solvents mentioned in subclause 7.3 b. and allowed to dry.

7.4 Calibration

Each reference standard and piece of measuring equipment shall be calibrated. Any suspected or actual equipment failure shall be recorded as a project nonconformance report so that previous results may be examined to ascertain whether or not re-inspection or retesting is required. The customer shall be notified of the nonconformance details.

7.5 Traceability

Traceability shall be maintained throughout the process from incoming inspection to final test, including details of test equipment and personnel employed in performing the task.

Bibliography

Informative references are listed hereafter.

- | | |
|--------------|--|
| ECSS-Q-70-22 | Space product assurance - The control of limited-life materials (to be published) |
| ECSS-Q-70-71 | Space product assurance - Data for the selection of space materials (to be published)
(or MSFC-SPEC-250 Protective finishes for space vehicle structures) |

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ECSS Document Improvement Proposal

1. Document I.D. ECSS-Q-70-34A	2. Document date 30 July 1999	3. Document title The application of the black electrically conductive coating Aeroglaze H322
4. Recommended improvement (identify clauses, subclauses and include modified text or graphic, attach pages as necessary)		
5. Reason for recommendation		
6. Originator of recommendation		
Name:	Organization:	
Address:	Phone: Fax: E-Mail:	7. Date of submission:
8. Send to ECSS Secretariat		
Name: W. Kriedte ESA-TOS/QR	Address: ESTEC, P.O. Box 299 2200 AG Noordwijk The Netherlands	Phone: +31-71-565-3952 Fax: +31-71-565-6839 E-Mail: wkriedte@estec.esa.nl

Note: The originator of the submission should complete items 4, 5, 6 and 7.

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