



PROCESSES

PROCESS	TYPE	CLASS	MILITARY SPECIFICATION
ANODIZE			
Chromic Anodize Including Type 1B & 1C	Type I	Class 1	MIL-A 8625
	Type I	Class 2	
Sulfuric Anodize (RoHS compliant) *	Type II	Class 1	MIL-A 8625
	Type II	Class 2	
	Type III	Class 1	
	Type III	Class 2	
Sulfuric Anodize (Teflon Impregnation)	Type I		MIL-A 63576
* Sulfuric Anodize is RoHS compliant except when used with a dichromate seal.			
Titanium Anodize	Type II		AMS 2488
Phosphoric Acid Anodize			ASTM D3933 / BR 127 ASTM D3933-98
CONVERSION COATING ON ALUMINUM			
Chem Film	Type I	Class 1A	MIL-C 5541 / MIL-DTL-5541
	Type I	Class 3	
Chem Film , Hexavalent Chrome free *	Type II	Class 1A	
	Type II	Class 3	
* RoHS compliant			
MAGNESIUM DICHROMATE TREATMENT			
Dow 1	Type I		AMS M 3171 (MIL M3171)
Dow 7	Type III		
Dow 15	Type IV		
Dow 19	Type VIII		
CONVERSION COATING ON TITANIUM			
Fluride Phosphate			AMS 2486
COVERSION COATING ON ZINC DIE CASTING			

Conversion Coating			
CADMIUM			
Cadmium Plate w/o chromate treatment	Type I		AMS 2400, QQ-P-416, AMS QQ-P-416, ASTM B766
Cadmium Plate with chromate treatment	Type II		
Cadmium Plate with phosphate treatment	Type III		
Cadmium Brush Plate			MIL-STD-865
ZINC			
Zinc Plate	Type I		ASTM B633
	Type II		
	Type III		
	Type IV		
Zinc Brush Plate			MIL-STD-865
ZINC NICKEL			
Zinc Nickel Plating	Type I		AMS 2417
	Type II		
	Type III		
ELECTROLESS NICKEL*			
Electroless Nickel No Phosphorus requirement	Type I		ASTM B733
Electroless Nickel Low Phosphorus (1-3%)	Type II		
Electroless Nickel Low Phosphorus (2-4%)	Type III		
Electroless Nickel Med Phosphorus (5-9%)	Type IV		
Electroless Nickel High Phosphorus (10%+)	Type V		
Electroless Nickel	Class I		AMS-C-26074 / AMS 2404
Electroless Nickel	Class II		
Electroless Nickel	Class III		
Electroless Nickel	Class IV		
* RoHS Compliant			
NICKEL			
Nickel Brush Plating			MIL-STD-865
Nickel Plate			AMS-QQ-N-290 / QQ-N-290
Nickel Plate / Black			MIL-P-18317
Sulfamate Nickel			AMS 2424 / MIL-P-27418

COPPER

Copper Plate			AMS 2418 / MIL-C-14550
Copper Brush Plating			MIL-STD-865

TIN

Tin Plate			ASTM B545 / MIL-T-10727 / AMS 2408
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TIN LEAD

Tin Lead Plate			AMS-P-81728
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PHOSPHATE

Phosphate Coating	Type M	Class I	MIL-DTL-16232
		Class II	
		Class III	
	Type Z	Class I	
		Class II	
		Class III	
		Class IV	

BLACK OXIDE COATING

Black Oxide Coating		Class I	MIL-DTL-13924
		Class IV	

PASIVATION

Pasivation Process			AMS-2700 / AMS-QQ-P-35 / ASTM A 967 / ASTM 380
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SUPPLEMENTARY PROCESSES

Abrasive Blasting (Glass Bead / Alum Oxide)			
Bake			
Embrittlement Relief			
Marking			
Masking			
Product Assembly			
Silk Screening			

INSPECTION

Fluorescent Penetrant Inspection			ASTM-E-1417
Hardness (Rockwell)			ASTM-E-18
Magnetic Particle Inspection			ASTM-1444
Nital Etch			MIL-STD-867
X-Ray Fluorescent			ASTM-B-568

TESTING

Adhesion			ASTM-B-571
Conductivity			AMS- 2658
Copper Sulfate			MIL-STD-753
Humidity			MIL-STD-753
Salt Spray			ASTM-B117

PAINT / COATINGS

Dry Lube			
Fuel tank Coating			AMS-C-27725
Paint / Primer			MIL-F-18264