



<b>Manufacturing Coating Specification</b>	<b>MCS015</b>
<b>Coating Type: HARD CHROME PLATING</b>	<b>AIT Reference: HCP</b>

*Substrate Material: Steel, Stainless Steel, Aluminum*

**1) Surface Preparation Requirements:**

- a) Hand sand/wire brush, as required, to remove surface rust, metal scale and give abrasion to smooth surfaces.
  - i. Wash with xylene using a brush to remove loose particulates.
  - ii. Dry part using compressed air.
- b) Mask surfaces, as required.
- c) Glass Bead, only if required by PO
- d) Forward to coating process for chemical cleaning.

**2) Hard Chrome Plating Requirements:**

Workmanship: The coating shall be smooth, adherent, uniform in appearance, and free from blisters, pits, nodules, flaking, and other defects that may affect the function of the coating.

Thickness: As per PO - stated as a range, minimum thickness, or per final drawing dimensions.

Hardness: 66-68HRC

Appearance: Uniform

Texture: Smooth

Surfaces: Apply coating to all casting & fabrication surfaces that do not require masking per PO.

**Notes:**

- 1. See industry standards/specifications for full application details.
- 2. Maintain all AIT tags and markings as supplied.
- 3. Remove all plugs and masking prior to shipping.
- 4. See AIT Quality Clause QA2 for Packing/Packaging requirements of finished parts. (The full text of the Quality Clauses can be obtained at [www.aint.com](http://www.aint.com) by clicking on "About AIT/Quality" link and then the "Quality Clauses" link.)