Advanced Integration Technology

Manufacturing Coating Specification	MCS018
Coating Type: BLACK OXIDE	**AIT Reference: BLACK**

Substrate Material: Steel

1) Surface Preparation Requirements:
   a) Option1: 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.
   Option2: Glass bead, as required, to remove surface rust and metal scale.

   b) Mask surfaces, as required.
   c) Forward to coating process for chemical cleaning.

2) Black Oxide 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: Thick enough to achieve lustrous black coating.
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 by clicking on "About AIT/Quality" link and then the "Quality Clauses" link.)