

	Supply Chain Specification	Document #	Revision	DCC #
	Coating Specification for Black Oxide	SCS-005	0	DCC00000106

The Supplier should always follow any Customer flow downs or drawing specific requirements first. When these requirements or drawings do not specify, AIT specifications apply. AIT specifications for multiple types of surface coatings, stress relief, or heat treating for machined and fabricated parts can be found at the link below: https://www.aint.com/about_ait/quality/overview

The latest specification available at the link above applies unless otherwise noted on the PO.

If the Supplier believes there to be a conflict between any requirements, please contact the Buyer.

General Requirements

Coating Type	AIT Reference Code	Standard Reference	Applicable Materials
Black Oxide	BLK	See PO, if applicable	Steel and Stainless Steel
Product Name		Manufacturer / Distributor	
Not Specified		Not Specified	

Surface Preparation

1. Prior to the application of the black coatings, the basis metal shall be thoroughly cleaned. The cleaned surfaces shall be free of rust, scale, grease, oil, paint, or other foreign matter.
2. Supplier validated cleaning materials and methods shall be selected at the option of the Supplier.
3. The cleaning process shall be performed without measurable abrasion or erosion unless abrasive blasting or hand tool cleaning is permitted by drawing or contract and dimensional tolerances are maintained.
4. Should the cleaning process or application of coating create a possibility of hydrogen embrittlement, the contractor shall take the appropriate steps for stress relief.
5. Mask surfaces, as required.
6. Forward to coating process for chemical cleaning.

Finish

Thickness	Appearance	Texture
N/A	Uniform black color	Smooth
Workmanship / Surfaces		Application
The surface of the coated part shall be uniform in appearance and free of visible coating defects, such as blisters, pits, roughness, nodules, burning, cracks, or uncoated areas, and other defects that will affect the function of the coating. The coated parts shall be clean and free of damage.		Apply coating to all casting & fabrication surfaces that do not require masking per PO.

Notes

1. Maintain all AIT tags and markings as supplied.
2. Remove all plugs and masking prior to shipping.



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Revision History

Rev.	Date	DCC	Comments	Approved By
0	8-8-2023	DCC0000106	Initial release	Robert Chianese