

	Supply Chain Specification		Document #	Revision	DCC #
	Coating Specification for Electro Zinc Plating		SCS-006	0	DCC0000010x

- **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
Electro Zinc Plating	EZP	See PO, if applicable	Steel, Stainless Steel, and Aluminum
Product Name		Manufacturer / Distributor	
Not Specified		Not Specified	

Surface Preparation

1. Before any plating, metal conversion or painting, all surfaces shall be free from soils and corrosion; for example, grease, oil, solder flux, welding flux, weld spatter, sand, rust, scale, and all other contaminants that might interfere with the intimate application of the finish.
2. Cleaning shall be done immediately before the finishing operation, or suitable precautions shall be taken to ensure that the surfaces remain clean until they are to be finished.
3. When a cleaning procedure is not specified by the procuring activity or as a part of the applicable finish specification, the supplier shall use any cleaning procedure which will produce a clean surface and not adversely affect the surface being cleaned, or the subsequently applied coating.
4. Mask surfaces, as required.
5. Forward to coating process for chemical cleaning.

Finish

Thickness	Appearance	Texture
Requirements per PO, drawings or other contractual document.	Uniform	Smooth
Workmanship / Surfaces	Application	
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.	Apply coating to all casting & fabrication surfaces that do not require masking per PO.	



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Notes

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

Revision History

Rev.	Date	DCC	Comments	Approved By
0	7-dd-2023	DCC000010x	Initial release	Robert Chianese