

	Supply Chain Specification	Document #	Revision	DCC #
	Coating Specification for Sulfuric Acid Anodizing	SCS-007	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
Sulfuric Acid Anodizing	SAA	See PO, if applicable	Aluminum
Product Name		Manufacturer / Distributor	
Not Specified		Not Specified	

Surface Preparation

1. The base metal shall be sufficiently free from surface defects, caused by machining, cutting, scratching, polishing, buffing, roughening, bending, stretching, deforming, rolling, sandblasting, vaporblasting, etching, heat treatment condition, alloy chemistry imbalance and inclusions, that will cause the parts to fail any of the requirements of this specification.
2. The base metal shall be subject to cleaning, etching, anodizing and sealing procedures as necessary to yield coatings meeting all requirements of this specification.
3. Mask surfaces, as required.
4. Forward to coating process for chemical cleaning.

Finish

Thickness (inch)	Weight (mg/ft ²)	Appearance	Texture
Requirements per PO, drawings or other contractual document.	Requirements per PO, drawings or other contractual document.	Uniform	Smooth
Workmanship / Surfaces		Application	
<p>The applied anodic coating shall be continuous, smooth, adherent, uniform in appearance, free from powdery areas, loose films, breaks, scratches and other defects which will reduce the serviceability of anodized parts or assemblies.</p> <p>Differences in anodic coating appearance resulting from inherent base metal differences in a component such as the presence of welds, components containing cast and machined surfaces, and differences in grain size within a forging shall not be cause to reject the anodic coating unless otherwise specified in the contract or purchase order. Slight discoloration from dripping or rundown of the sealing solution from designed crevices in a component shall be allowed.</p>		<p>Apply coating to all casting & fabrication surfaces that do not require masking per PO.</p>	

	Supply Chain Specification	Document #	Revision	DCC #
	Coating Specification for Sulfuric Acid Anodizing	SCS-007	0	DCC0000106

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	8-8-2023	DCC0000106	Initial release	Robert Chianese