AIT	Supply Chain Specification	Document #	Revision	DCC #
	Coating Specification for Electroless Nickel	**SCS-009**	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
Electroless Nickel	**HCP**	**See PO, if applicable**	**Steel, Stainless Steel, and Aluminum**

Product Name	Manufacturer / Distributor
Not Specified	Not Specified

Surface Preparation

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

Finish

Thickness	Composition	Appearance	Texture	Hardness
As per PO - stated as a range, minimum thickness, or per final drawing dimensions.	Low to Mid Phosphorous	Uniform, 45-50% reflectivity	Smooth	Min. 450DPH (Vickers) or 45HRC, inherent in product used in coating

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.

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