

	Supply Chain Specification	Document #	Revision	DCC #
	Coating Specification for General Paint	SCS-010	1	DCC00000126

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
Paint	N/A	See PO, if applicable	Steel and Aluminum
Product Name		Manufacturer / Distributor	
Not Specified		Not Specified	

Surface Preparation

Steel Option 1:

1. All surfaces to be coated are to be cleaned to ensure the removal of all surface contaminants such as oil and grease, this may be achieved by using soap and water.
2. Plug all threaded holes. Mask areas that require protection from sandblasting.
3. Abrasive blast utilizing Aluminum Oxide 36 Grit or equivalent on all surfaces to be coated. All surfaces are to be abraded to provide a profile to aid adhesion of subsequent coatings.
Note: “Shot Blasting” or “Shot Peening” is strictly prohibited unless specifically called out on the engineering drawing.
4. Remove any residual from surface preparation using a vacuum, or blow off with clean, dry air.
5. Mask surfaces for painting, as required.

Steel Option 2:

1. All surfaces to be coated are to be cleaned to ensure the removal of all surface contaminants such as oil and grease. This may be achieved by using soap and water and water rinse.
2. Plug all threaded holes.
3. Hand Tool or Power Tool Clean all surfaces to be coated. All surfaces are to be abraded to provide a profile to aid adhesion of the subsequent coatings. Wire brushes or wire wheels are not to be used for final surface preparation.
4. Remove any residual from surface preparation using a vacuum, or blow off with clean, dry air.
5. Mask surfaces for painting, as required.



Aluminum:

1. All surfaces to be coated are to be cleaned to ensure the removal of all surface contaminants such as oil and grease. This may be achieved by using soap and water and water rinse.
2. Plug all threaded holes. Mask areas that require protection.
3. Remove any residual from surface preparation using a vacuum, or blow off with clean, dry air.
4. Mask surfaces for painting, as required.

Finish

Surface Primer:

Thickness	Gloss	Texture
2.0-3.0 mils dry film thickness	Flat	Smooth
Workmanship / Surfaces / Application		
Apply primer to all casting & fabrication surfaces that do not require masking.		

Topcoat:

Thickness	Gloss	Texture
2.0-3.0 mils dry film thickness	High	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.	

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
1	7-18-2024	DCC0000126	Steel Option 1: Updated item 3 to list acceptable and prohibited blast material.	Robert Chianese