

# Process List

<b><u>ANODIZE: MIL-A-8625F</u></b>			
CHROMIC	TYPE I	CLASS 1	GREY
SULFURIC	TYPE II	CLASS 1	dichromate sealed or clear
		CLASS 2	DYED
HARD	TYPE III	CLASS 1	NON-DYED
		CLASS 2	DYED
<b><u>CHEMICAL FILM: MIL-C-5541E</u></b>			
			(ALSO KNOWN AS: ALODINE & CHROMATE CONVERSION)
TYPE NA	CLASS NA	CLEAR	
	CLASS 1A	GOLD	
	CLASS 3	GOLD	
<b><u>CADMIUM PLATE: AMS QQ-P-416</u></b>			
TYPE 1	CLEAR (W/O CHROMATE)		
TYPE II GOLD	(OR OTHER CHROMATE)		CLASS 1
BAKE 8 HOURS			CLASS 2
BAKE 23 HOURS			CLASS 3
<b><u>ZINC PLATE: ASTM-B-633-98</u></b>			
TYPE I	CLEAR (W/O CHROMATE)	CLASS FE/ZN5 = CLASS SC1 .0002	
TYPE II GOLD	(OR OTHER CHROMATE)	CLASS FE/ZN8 = CLASS SC2 .0003	
TYPE III CLEAR	(BLUE CHROMATE)	CLASS FE/ZN12 = CLASS SC3 .0005	
		CLASS FE/ZN25 = CLASS SC4 .0010	
<b><u>ELECTROLESS NICKER: MIL-C-26074E (AMS 2404D)</u></b>			
CLASS 1 AS PLATED (HYDROGEN EMBRITTLEMENT RELIEF @ 375 F./3 HOURS MIN., if required)			grade a .0010"
Class 2 thermal treatment @ 450 f. or higher for 4 hours or longer			grade b .0005"
class 2 thermal treatment @ 375 f. for 1.0 - 1.5 hours			grade c .0015"
class 4 thermal treatment @ 250 f. for 1.0 - 1.5 hours			
<b><u>PASSIVATE: ASTM-A-967-99 (QQ-P-35)</u></b>			
NITRIC 1 (TYPE II)		NITRIC 2 (TYPE VI)	
<b><u>NICKEL PLATE: QQ-N-290 A</u></b>			
GRADES G (4,7) = .0002			
F (3,6,9,10) = .0004 C (1) = .0010			
E (2,5,8) = .0006 B = .0012			
D = .0008 A = .0016			
		CLASS 1	
		BAKE 3 HOURS (RC40/180 KSI OR HIGHER)	
<b><u>ZINC- NICKEL: AMS 2417F</u></b>			
TYPE I	CLEAR (RUN IF NOT SPECIFIED)		THICKNESS: 0003 - .0007
TYPE II GOLD			.0002 - .0004 WASHERS AND PARTS
BAKE PER CHART IN AMS 2759/9			
<b><u>ZINC COBALT: ASTM-B840-99 CLASS 1</u></b>			
TYPE A - COLORLESS		GRADE 1 - .00023	
TYPE B - YELLOW CHROMATE		GRADE 2 - .00046	
TYPE C - BRONZE CHROMATE		GRADE 3 - .00070	
TYPE D - BLACK CHROMATE			
TYPE E - ANY OF THE ABOVE PLUS ORGANIC TOPCOAT		BAKE 22 HRS @ 375 F. - 425 F. (31 HRC OR HIGHER)	



NATIONAL ASSOCIATION OF METAL FINISHERS



Metal Finishing Association of Southern California

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