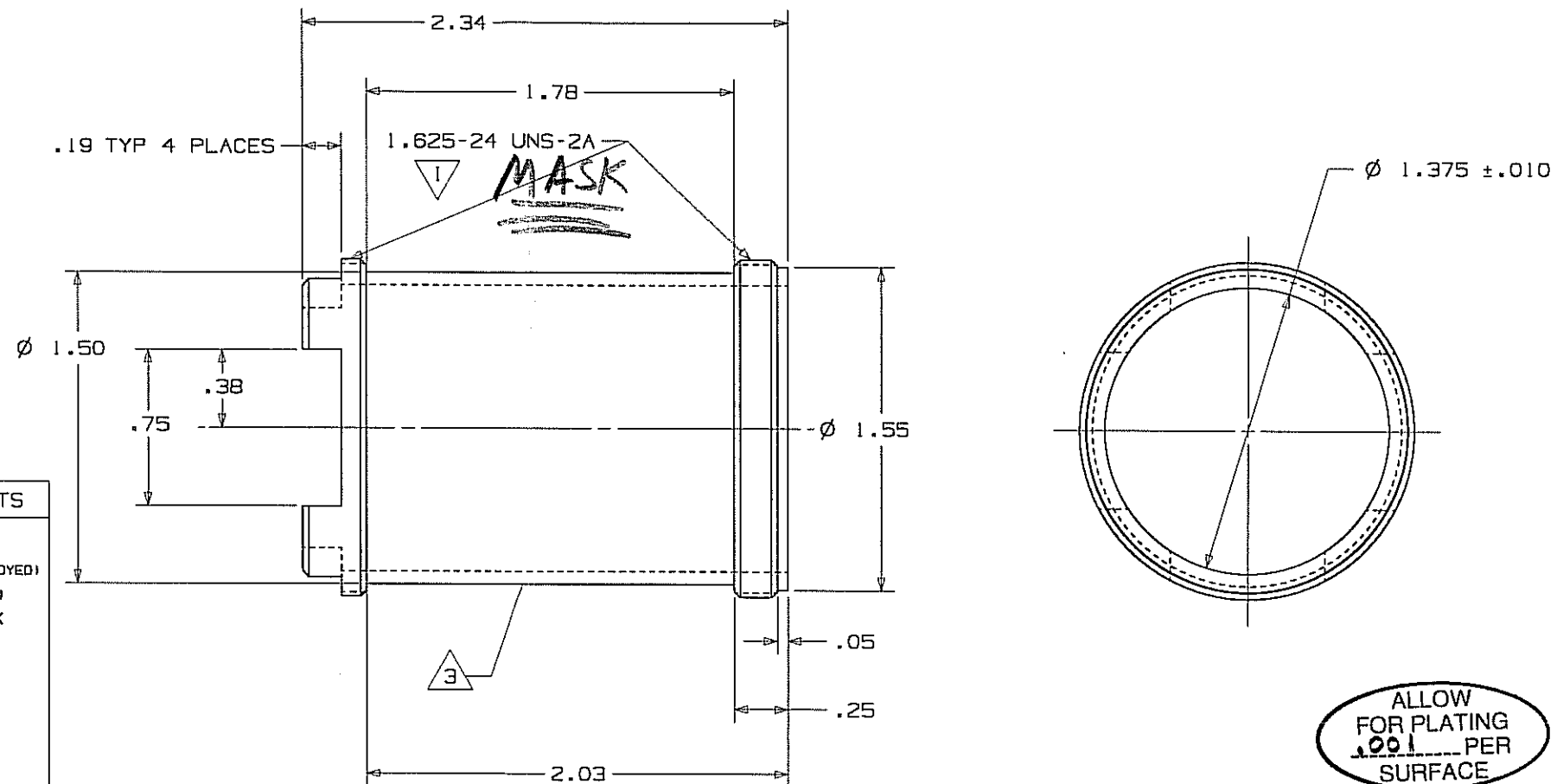


4. COAT THREADS: APPLY CHROMATE CONVERSION COATING PER MIL-DTL-5541F, TYPE II (ROHS COMPLIANT, NON-HEXAVALENT), CLASS 3. CERTIFICATE OF COMPLIANCE TO BE PROVIDED.




REV	REVISION DESCRIPTION	BY	DATE	ECO #
A	ORIGINAL RELEASE	SD	11/27/08	BCT018343
B	ADDED NOTES 3 AND 4	TP	01/08/07	BCT018607
C	CLARIFIED NOTE 4	MY	02/28/07	BCT019052
D	CHGD NOTE 3 AND ADDED ID MARK	MY	04/08/08	BCT025009
E	REVISED NOTE 4	EK	6/27/11	BCT031229



GENERAL SPECIFICATIONS FOR ANODIZED PARTS

1. ANODIZE PER MIL-A-8625
- | | |
|--|--|
| <input type="checkbox"/> TYPE I (CHROMIC ACID ANODIZE) | <input type="checkbox"/> CLASS 1 (NON-DYED) |
| <input type="checkbox"/> TYPE IB (CHROMIC ACID LOW VOLT) | <input checked="" type="checkbox"/> CLASS 2 (DYED) |
| <input type="checkbox"/> TYPE II (SULFURIC ACID ANODIZE) | <input checked="" type="checkbox"/> COLOR: BLACK |
| <input checked="" type="checkbox"/> TYPE III (HARD ANODIC COATING) | <input type="checkbox"/> COLOR: |
2. THICKNESS OF COATING
(AN INCREASE IN DIMENSION, EQUAL TO ONE HALF OF THE THICKNESS OF THE APPLIED COATING, CAN BE EXPECTED FOR EACH SURFACE COATED DUE TO SURFACE GROWTH.)
- ☒ (TYPE III) .002
- ☐ (TYPE II CLASS 2) .0003 TO .0009
- ☐ (TYPE II CLASS 1) .0001 TO .0007
- ☐ SPECIFY OTHER
3. ALL DIMENSIONS TO BE HELD TO PRINT TOLERANCE AFTER ANODIZATION.
4. MASKING OF HOLE AND/OR OTHER FEATURES
IF UNSPECIFIED, ANY TAPPED OR NOT TAPPED HOLE 1/4 INCH OR LESS IN DIAMETER WILL BE FURNISHED FREE OF ANODIC COATING.
IF UNSPECIFIED, ANY TAPPED OR NOT TAPPED HOLE OVER 1/4 INCH IN DIAMETER SHALL BE ANODIZED.
- ☐ DO NOT MASK
- ☒ MASKING REQUIRED IN 2 PLACES - THREADS.
5. RACKING POINTS
IF UNSPECIFIED, SIZE AND NUMBER OF CONTACT MARKS SHALL BE AT A MINIMUM CONSISTENT WITH GOOD PRACTICE. IF UNSPECIFIED, THE LOCATION OF CONTACT MARKS SHALL BE AT ANODIZERS DISCRETION (IN AREAS OF MINIMUM EXPOSURE).
- ☐ RACK ONLY ON FEATURES INDICATED BY NOTE
6. SEALING (IF UNSPECIFIED, SEAL WITH WATER)
- ☒ NICKEL ACETATE
- ☐ DO NOT SEAL (ONLY FOR TYPE III FOR MAXIMUM WEAR RESISTANCE)
- ☐ OTHER SEALANT REQUIRED:

UNIGRAPHICS

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TOLERANCES AND SYMBOLLOGY PER ANSI Y14.5-1994 DIMENSIONS SPECIFIED ARE AFTER ADDITIVE FINISH.		DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		TITLE <div style="text-align: center; font-size: 2em;">TUBE, VIEWPORT</div>	
MATERIAL <div style="text-align: center; font-size: 1.5em;">6061-T6 ALUMINUM</div>		.X± 0.04 .XX± 0.010 .XXX± 0.005 .XXXX± 0.0020			
ANGLES <div style="text-align: center; font-size: 1.5em;">± 1</div>		SURF. FINISH <div style="text-align: center; font-size: 1.5em;">63</div>			
ORIGINATOR DATE		PART NO. REV SHT / OF			
SIZE <div style="font-size: 2em;">C2</div>	SCALE <div style="font-size: 1.5em;">1:1</div>	DO NOT SCALE DIMS 	THIRD ANGLE PROJECTION 	DRAWN S. DURKEE	DATE 10/15/03
				777094-141	
				E 1/1	