
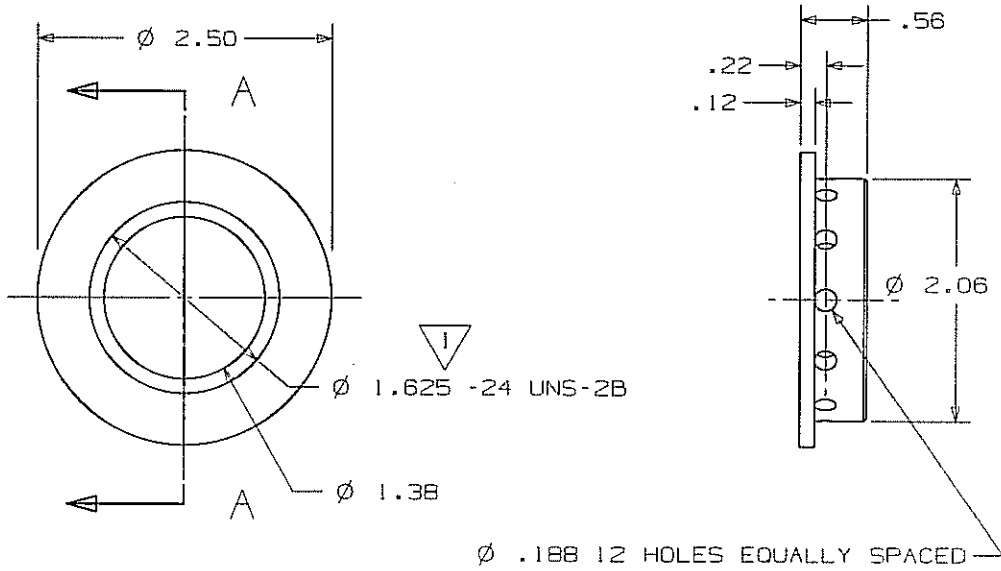


NOTES

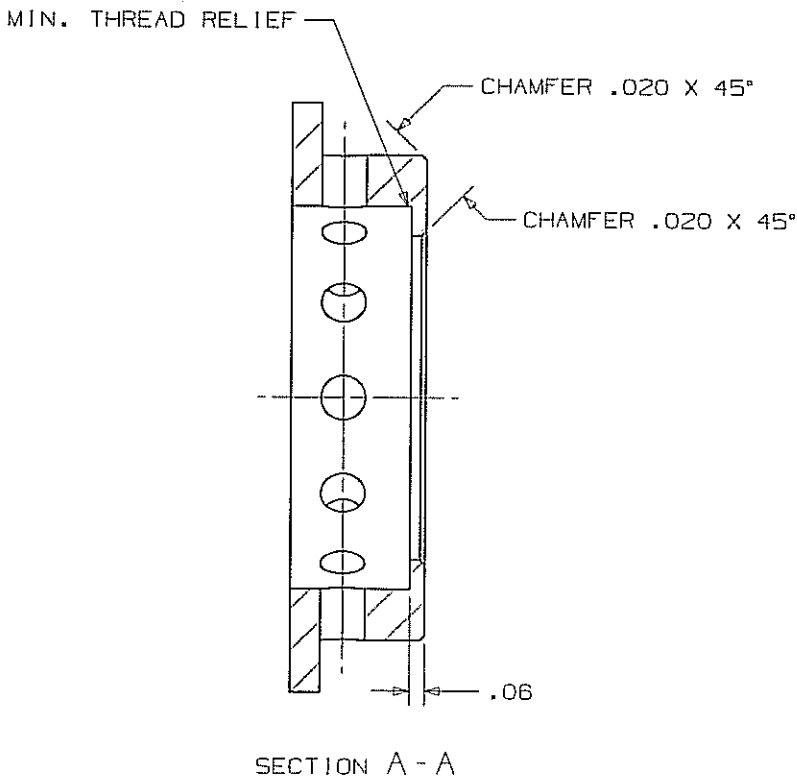
1. BREAK ALL SHARP EDGES AND CORNERS.
2.  INDICATES FEATURE/DIMENSION TO BE CHECKED AT INCOMING INSPECTION.
3. ALL DIMENSIONS ARE AFTER ANODIZATION
4. APPLY CONVERSION COATING PER MIL-DTL-5541F, TYPE II (ROHS COMPLIANT, NON-HEXAVALENT), CLASS 3. CERTIFICATE OF COMPLIANCE TO BE PROVIDED. COATING TO COVER THREADS AFTER ANODIZING.



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 1 PLACE - 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:

REV	REVISION DESCRIPTION	BY	DATE	ECO #
A	ORIGINAL RELEASE	TP	11/27/06	BCT018343
B	ADDED NOTES 3 AND 4	TP	01/08/07	BCT018607
C	REVISED NOTE 4	EK	6/27/11	BCT031229



7-22-11 408

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TOLERANCES AND SYMBOLS PER ASME Y14.5M-1995 DIMENSIONS SPECIFIED ARE AFTER ADDITIVE FINISH.		DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
.X±0.04 .XX±0.010 .XXX±0.005 .XXXX±0.0020		MATERIAL ALUM. 6061-T6	
ANGLES ± 1		SURF. FINISH 125	
ORIGINATOR		DATE	
T. PEARCE		11/17/06	
SIZE SCALE DO NOT SCALE DRO		PART NO. 777094-476	
C 2:1		REV 1/1	

UNIGRAPHICS