

# GENERAL SPECIFICATIONS FOR ANODIZED PARTS

## 1. ANODIZE PER MIL-A-8625

- ☐ TYPE I (CHROMIC ACID ANODIZE) ☐ CLASS 1 (NON-DYED)
- ☐ TYPE IB (CHROMIC ACID LOW VOLT) ☐ CLASS 2 (DYED)
- ☐ TYPE II (SULFURIC ACID ANODIZE) ☐ COLOR: BLACK
- ☒ TYPE III (HARD ANODIC COATING) ☐ 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  $\perp$  PLACES. SEE NOTE 3

## 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 3

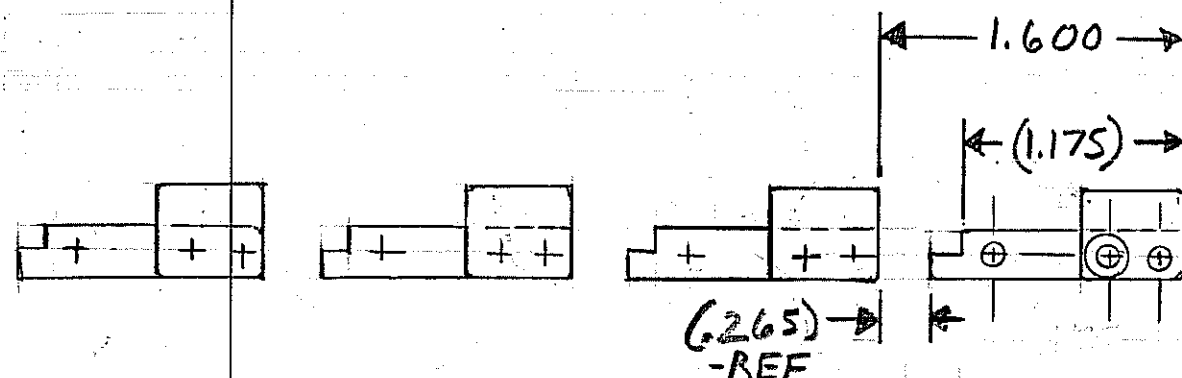
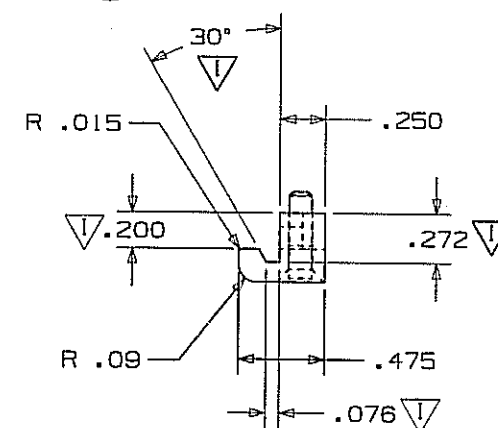
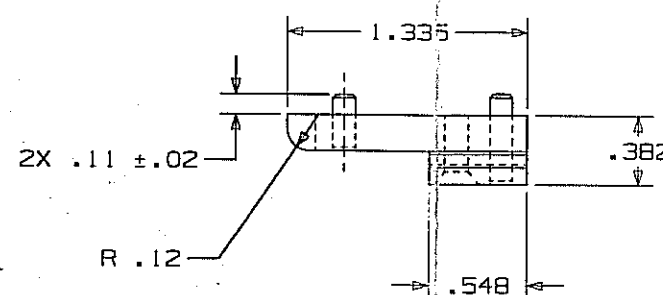
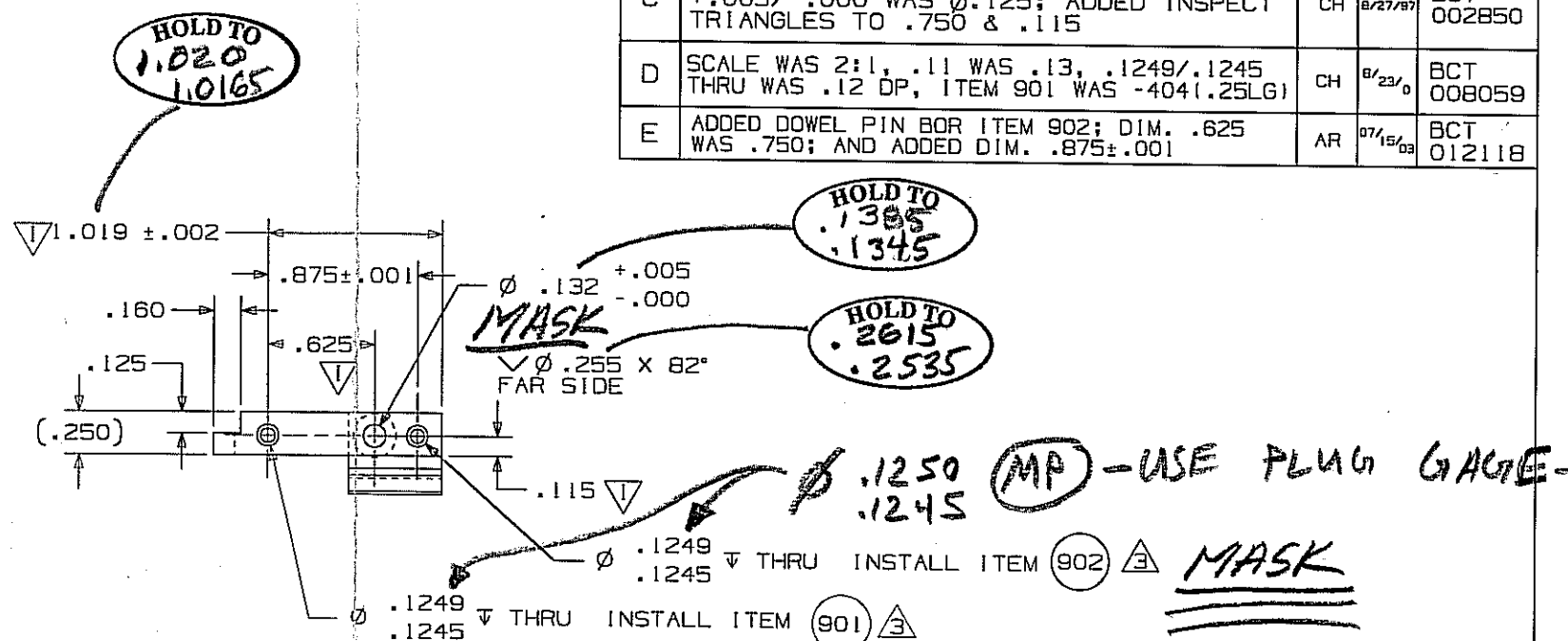
## 6. SEALING (IF UNSPECIFIED, SEAL WITH WATER)

- ☒ NICKEL ACETATE
- ☐ DO NOT SEAL (ONLY FOR TYPE III FOR MAXIMUM WEAR RESISTANCE)
- ☐ OTHER SEALANT REQUIRED:


## NOTES:

1. BREAK ALL SHARP EDGES AND CORNERS R.005-.015 (OR X 45°).
2.  $\nabla$  INDICATES KEY FEATURES TO BE VERIFIED AT INCOMING INSPECTION.
3.  $\triangle$  MASK PRIOR TO ANODIZATION.

REV	REVISION DESCRIPTION	BY	DATE	ECO #
A	INITIAL RELEASE	CH	5/30/87	BCT 002256
B	CHG ANGLE TOL TO $\pm 2^\circ$ FROM $\pm 1^\circ$	CH	8/15/87	BCT 002782
C	ADDED .475; $\phi .1249$ WAS .1250; $\phi .132$ $\pm .005/- .000$ WAS $\phi .125$ ; ADDED INSPECT TRIANGLES TO .750 & .115	CH	8/27/87	BCT 002850
D	SCALE WAS 2:1. .11 WAS .13, .1249/.1245 THRU WAS .12 DP, ITEM 901 WAS -404(.25LG)	CH	8/23/87	BCT 008059
E	ADDED DOWEL PIN BOR ITEM 902; DIM. .625 WAS .750; AND ADDED DIM. .875 $\pm .001$	AR	07/15/03	BCT 012118



UG DWG

902	1	EA	779029-406	Ø .125 X .500 LG. SST DOWEL PIN	
901	1	EA	779029-405	Ø .125 X .312 LG. SST DOWEL PIN	
ITEM NO.	QTY	U/M	PART NO.	DESCRIPTION	
BILL OF REFERENCE					
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TOLERANCES AND SYMBOLS PER ANSI Y14.5M-1982 DIMENSIONS SPECIFIED ARE AFTER ADDITIVE FINISH.		DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		TITLE  LATCH, LWR RIGHT, CARRIER PLATE	
.X± 0.1	ANGLES	MATERIAL 6061-T6 ALUMINUM			
.XX± 0.01	± 2°				
.XXX± 0.005	SURF. FINISH				
.XXXX± 0.0010	63 RMS				
SIZE	SCALE	DO NOT SCALE DWD	THIRD ANGLE	ORIGINATOR	DATE
C3:2	2	☐	☐	DRAWN C. HAKE	DATE 2/27/88
PART NO.				REV	SHT / OF
777096-624				E	1 / 1