

# 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 2 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).

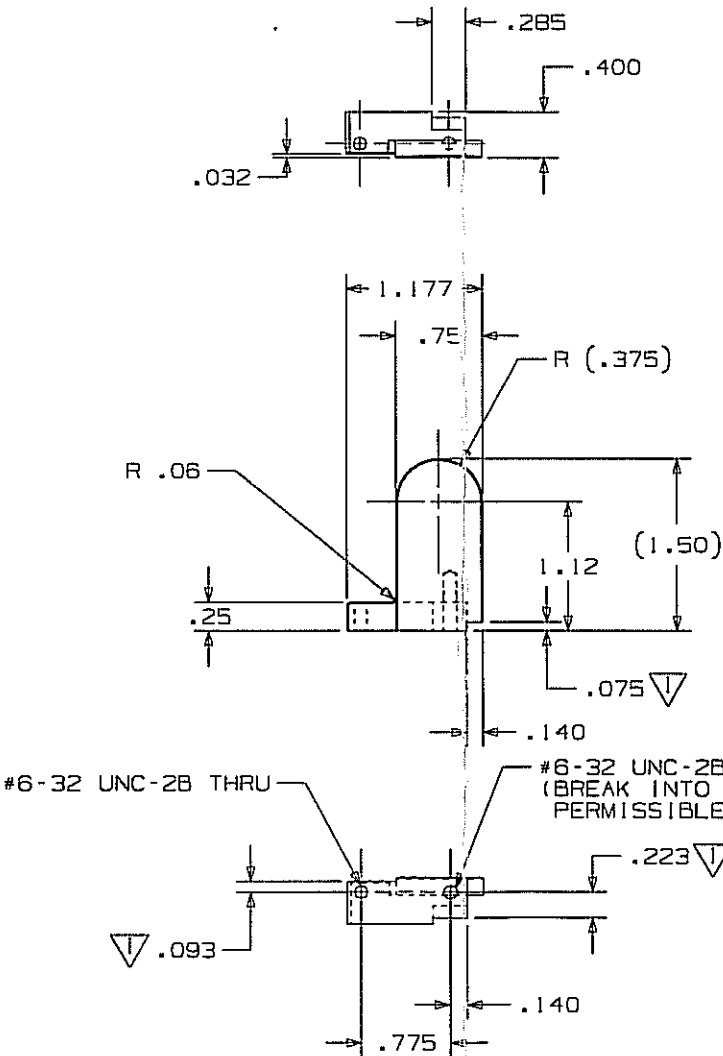
- ☐ RACK ONLY ON FEATURES INDICATED BY NOTE 3

## 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. ▽ INDICATES KEY FEATURES TO BE VERIFIED AT INCOMING INSPECTION.
3. △ MASK PRIOR TO ANODIZING.



REV	REVISION DESCRIPTION	BY	DATE	ECO #
A	ORIGINAL RELEASE	CH	3/7/97	BCT 001905
B	(1.50) WAS 1.50; #6-32 X .26 MIN DP WAS .40 MIN DP	CH	8/27/97	BCT 002850

TOLERANCES AND SYMBOLS PER MIL-STD-100-1002 DIMENSIONS SPECIFIED ARE AFTER ADDITIVE FINISH.		DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		CaridianBCT 10811 Collins Avenue Lakewood, Colorado 80215-4440 USA	
.XX ± 0.1 .XXX ± 0.01 .XXXX ± 0.005 .XXXXX ± 0.0010		ANGLES ± 2 SURF. FINISH 64 RMS		TITLE RELEASE HANDLE, CASSETTE	
SIZE C 1	SCALE 1:1	DATE 2/27/98	ORIGINATOR C. HAKE	DATE 2/27/98	PART NO. 777096-146
DATE 2/27/98	SCALE 1:1	DATE 2/27/98	ORIGINATOR C. HAKE	DATE 2/27/98	REV B 1/1

UG DWG

6-4-09 40B