

Common Specifications

These specifications are subject to change.

It is the responsibility of the customer to verify that the information is correct and current.

Black Oxide: Steel or Stainless Steel:

MIL-C-13924	Class 1 – Steel Class 4 – Stainless Steel
MIL-DTL-13924	Class 1 – Steel Class 4 – Stainless Steel
Steel or Stainless Steel:	AMS 2485

Bright Nickel:

QQ-N-290	Class 1 – For Corrosion Protection Class 2 – For Engineering Applications
	Grade A: .0016 Thick
	Grade B: .0012 Thick
	Grade C: .0010 Thick
	Grade D: .0008 Thick
	Grade E: .0006 Thick
	Grade F: .0004 Thick
	Grade G: .0002 Thick

Dry Film Lube:

MIL-L-46010

Electroless Nickel:

MIL-C-26074/ AMS 2404	Class 1 – As Coated Class 2 – Steel or other Base Metals not Heat Treatable
	Grade A: .0010 Thick
	Grade B: .0005 Thick
	Grade C: .0015 Thick
ASTM B733	Class 3 – Beryllium Copper
	Type 1: No Requirement for Phosphorous
	Type 2: 1-3% - SMFI DOES NOT DO THIS TYPE
	Type 3: 2-4% - SMFI DOES NOT DO THIS TYPE
	Type 4: 5-9%
	Type 5: 10% and above – SMFI DOES NOT DO THIS TYPE
	SC 0: Min. Thickness .000004
	SC 1: .0002
	SC 2: .0005
	SC 3: .001
	SC 4: .003

Passivate (Stainless Steel Only):

ASTM A967	AMS 2700
QQ-P-35 (Replaced w/ ASTM A967)	AMS QQ-P-35 (Replaced w/ AMS 2700)
Spec 11200071 Code 2021	ASTM A380
IAW 79P050000, CODE 2041 (LOCKHEED)	IAW 79P050000, CODE 2042 (LOCKHEED)
MIL-F-14072-300 E	

Zinc:

ABB Spec	51042-A00 – Clear Zinc	
	51042-A01 – Yellow Zinc	
ASTM B633-15	51042-E01 – References QQ-Z-325C	
	83226GC/83125JM – Yellow Zinc (.0003)	
	83226GB/83125JM – Yellow Zinc (.0002)	
	Type 1 – No Chromate	
	Type 2 – Color (Yellow) Chromate	
	Type 3 – Clear Chromate	
	Type 5 – Colorless Passivate (RoHS / Trivalent Clear Zinc)	
	Type 6 – Colored Passivate (RoHS / Trivalent Yellow Zinc)	
	SC 1/FEZN 5	.0002 Thick
	SC 2/FEZN 8	.0003 Thick
QQ-Z-325B/C	FEZN 10	.0004 Thick
	SC 3/FEZN 12/13	.0005 Thick
	SC 4/FEZN25	.001 Thick
	Type 1 – W/Out Chromate	
	Type 2 – All Zinc (Incl. Clear)	
	Class 1	.001 Thick
	Class 2	.0005 Thick
	Class 3	.0002 Thick

Bake:

Grade 5 Steel – No Bake (under RC 31.2)
Grade 8 Steel or Above – Bake Required
Zinc Plating – RC Higher than 31.2 Bake Required
E/N or B/N Plating - RC Higher than 31.2 Bake Required
Black Oxide – RC Higher than 40 Bake Required

Nickel Strike:

S/S parts require a Nickel Strike for every process except Black Oxide.
Copper & Brass parts require a Nickel Strike for Electroless Nickel Only.