

BAC5640

REVISION
NEW
1/27/1993

NITRIDING OF STEEL



<u>BAC 5640 DEPARTURES</u>	<u>EFF DATE</u>	<u>SUBCONTRACTOR(S) AFFECTED</u>	<u>ON MODELS</u>	<u>MFG DEPTS OF DIV BELOW AFFECTED</u>
6-1	1/27/1993	MESSIER-HISPANO-BUGATTI BIDOS, FRANCE	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE
6-2	1/27/1993	PARKER HANNIFIN CORP. AEROSPACE HYDRAULIC DIV. IRVINE, CALIFORNIA	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE
6-3	7/12/1994	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	BCAG AND SUPPORTING
6-4	3/25/1998	DOWTY AEROSPACE WOLVERHAMPTON	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	NONE
6-5	3/13/2001	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCAG AND SUPPORTING
6-7	10/13/2015	ALL	ALL COMMERCIAL AIRPLANES AND DERIVATIVES THEREOF	ALL BCA AND SUPPORTING
8-1	3/14/2003	ALL	ALL	ALL BOEING PHILADELPHIA AND SUPPORTING
9-1	12/20/2010	BODYCOTE THERMAL PRODUCTS AND NORTHSTAR AEROSPACE	494	NONE

THIS SPECIFICATION ESTABLISHES THE REQUIREMENTS FOR NITRIDING STEELS AS WELL AS THE PRIOR OR SUBSEQUENT HEAT TREATMENT OF THESE STEELS

REASON

TO ALLOW THE USE OF BRONZE PLATING FOR A NITRIDING STOP-OFF.

TO ALLOW THE USE OF BRONZE PLATING FOR A NITRIDING STOP-OFF.

TO ALLOW CHEMICAL REMOVAL OF WHITE LAYER ON NITRIDED PARTS.

TO ALLOW THE USE OF BRONZE PLATING FOR A NITRIDING STOP-OFF.

TO RAISE THE MAXIMUM QUENCH OIL TEMPERATURE TO 160 F.

CLARIFY STRIPPING OPERATIONS OF COPPER, NICKEL STRIKE AND OTHER MASKANTS IN ACCORDANCE WITH BACS771, ON CORROSION RESISTANT STEELS.

TO ADD REQUIREMENTS FOR NITRIDING ALLOY STEELS SUCH AS 8740 AND 4340 STEEL.

TO ADD PROVISION TO USE STOP-OFF PAINT AS SUPPLEMENT TO COPPER PLATING WHEN SELECTIVE NITRIDING.