



AN INNOVATIVE COMPANY

EAST/WEST INDUSTRIES, INC.

EWI-PC-1000

Revision N
MAY 1, 2019

East/West

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5/1/2019

DATE

5/1/2019

DATE

5/10/19

DATE

TABLE OF REVISIONS

<u>Rev</u>	<u>Page</u>	<u>Date</u>	<u>By</u>	<u>Description of Change</u>	
A	2	9-21-94	J.W	PF: EW34002 (was) MIL-L-8937	
				PH: ASTM-E-1444 (was) MIL-STD-1949	
	PI: EWI-FC-1000 (was) EWI-FC-001				
	PK: MIL-STD-6866 (was) MIL-I-6866				
	3			PT: MIL-STD-2219 (was) MIL-W-8604	
	PV: MIL-STD-2219 (was) MIL-W-8611				
	4			PAB: S/S BY PAE	
		PAC: S/S BY PAE			
		PAF: S/S BY PAD			
		PAG: S/S BY PAE			
B	2	3-10-03	J.W.	PJ: ASTM-A-967 (was) MIL-S-5002 (EAI 1A)	
				PJ(C): Added (EAI 1A)	
				PS: S/S BY PU (conflict with GAC Code)	
				PK: ASTM-E-1417 (was) MIL-STD-6866 (Quality Assurance Log # 97-191) (EAI 1A)	
				PU: Added (S/S PS)	
C	1	9/8/06	J.W.	Para 1.2 "... MIL-HDBK-132 (cancelled), titled "Protective Finishes for Metal and Wood Surfaces" (Was "...MIL HDBK-132 titled Military Handbook.")	
				Para. 2.0"... the following Table ..." (Was "...Appendix I of this specification...")	
	2			PA SAE AMS 2175 (Was MIL-STD-2175)	
				PB: SAE AMS H 6088 (Was MIL-H-6088)	
				PC SAE AMS H 6875 (Was MIL-H-6875)	
				PD MIL HDBK 6870 (Was MIL-I-6970)	
				3	PL ASTM E 1742 (Was MIL-STD-453)
					PM MIL HDBK 1264 (Was MIL-STD-1264)
					PN MIL HDBK 1265 (Was MIL-STD-1265)
				Added: alternate PN(1)	
				Added: Specify Grade & Class on B/P	
				PN (1) (Added)	
	4			PO Cancelled Spec (Was DOD-STD-1866)	
PP Cancelled Spec (Was MIL-S-45743)					
PQ SAE AS 8879 (Was MIL-S-8879)					
PR SAE AS 7105 (Was MIL-P-7105)					
PV SAE AMS 2219 (Was MIL-STD-2219)					
PW SAE AMS W 6858 (Was MIL-W-6858)					
PY: Deleted Applicable Spec (Was MIL-STD-852)					

TABLE OF REVISIONS (cont.)

<u>Rev</u>	<u>Page</u>	<u>Date</u>	<u>By</u>	<u>Description of Change</u>
D	2 3 4	5/27/2009	J.W.	P1 thru P4 (ADDED) PJ See EWI-FC-1000 Code P PJ (C) See EWI-FC-1000 Code P(C) PR SAE AS71051 (WAS SAE AS7105) PW (SAE AMS W 6858) WAS SAE AMS W 6858 PX (MIL-STD-403) Was MIL-STD-403
E	2	5/21/2012	J.W.	PC (ADDED) Decarb Samples for 400 CRES
F	2	7/23/2012	J.W.	PC (ADDED) SAE AMS2759 Heat Treatment of Steel Parts (DELETED) Decarburation Samples are required for 400 Stainless (ref Para 3.4)
G	4	4/30/2013	C.I.	PT & PV AWS D17.1 (WAS) MIL-STD-2219
H	2 4 5		A.S.	(ADDED) COMBINATION CODES P5 (ADDED) Codes PC, PH, PY (1) PT(A) Welding, Fusion Aluminum, Class A PT(B) Welding, Fusion Aluminum, Class B PT(C) Welding, Fusion Aluminum, Class C PV(A) Welding, Fusion Steel, Class A PV(B) Welding, Fusion Steel, Class B PV(C) Welding, Fusion Steel, Class C PY(1) (ADDED) Shot Peen per SAE AMS2430
J	COVER	8/10/2016	CI	Deleted Chief Engineer sign off. Code PY Glass Bead Blast (WAS) Glass Bead Peening Procedures.
K	3	12/19/16	C.I.	CODE PK (Added) Acceptance Rejection Criteria. (Added) Etch Required.....
L	COVER		C.I.	Updated cover sheet to reflect new address.
M	3		C.I.	code "PK" (added) NOTE: Drawing should specify any ETCH MASK requirements or NO MASK.
N	8	5/1/2019	J.W.	PAH (ADDED) ref. ECR 19-081 PAJ (ADDED) ref. ECR 19-119

1.0 SCOPE

- 1.1 The purpose of this specification is to present, in abbreviated form, the various processes employed in preparing metals to accept protecting finish coats, as well as inspection processes.
- 1.2 Reference should be made to MIL-STD-171, titled "Finishing of Metal and Wood Surfaces" and to MIL-HDBK-132 (cancelled), titled "Protective Finishes for Metal and Wood Surfaces". Use of these two reference documents along with the process code index spelling out applicable specifications will ensure that the correct processes have been employed.

2.0 APPLICABLE DOCUMENTS

The documents listed in the following Table set forth, in detail, the steps to be performed in order that the requirements of the process be fully met.

APPENDIX I**PROCESS CODE INDEX**

<u>E/W CODE</u>	<u>PROCESS</u>	<u>APPLICABLE SPECIFICATION</u>	<u>TITLE</u>
P1	General (& Sheet Metal)	MOI-1000 Section II	General Workmanship Standards
P2	Machining	MOI-1000 Sections II & III	General Workmanship Standards
P3	Assembly	MOI-1000 Section IV	General Workmanship Standards
P4	Finish	MOI-1000 Section V	General Workmanship Standards
COMBINATION CODES			
P5	Heat Treat Mag Particle Shot peen	per Code PC per Code PH per Code PY (1)	
INDIVIDUAL CODES			
PA	Castings	SAE AMS2175 (S/S AMS-STD-2175) (S/S MIL-STD-2175)	Castings, Classification and Inspection of
PB	Heat Treat (Aluminum)	SAE AMS2770 (S/S SAE AMS H 6088)	Heat Treatment of Aluminum Alloys
PC	Heat Treat (Steel)	Raw Materials use SAE AMS H 6875 (S/S MIL-H-6875)	Heat Treatment of Steel Raw Materials
		Parts use SAE AMS2759 (Ref. AMS-H-6875 para 6.3 & 3.4)	Heat Treatment of Steel Parts
PD	Inspection, General Requirements	MIL HDBK 6870 (S/S MIL-I-6870)	Inspection Requirements, Non-Destructive for Aircraft Materials and Parts
PE	Laminate	L-P-383 (1)	Plastic Material, Polyester Resin, Glass Fiber Base Low Pressure Laminated

<u>E/W CODE</u>	<u>PROCESS</u>	<u>APPLICABLE SPECIFICATION</u>	<u>TITLE</u>
PF	Lubrication	EW34002	Lubricant, Solid Film, Heat Cured, Corrosion Inhibiting
PH	Magnetic Particle	ASTM-E1444 (S/S MIL-STD-1949) (S/S MIL-I-6868)	Particle Testing, Magnetic
PI	Painting	EWI-FC-1000	Finish Specification
PJ	Passivation	See EWI-FC-1000 Code P	
PJ (C)	Passivation (Castings)	See EWI-FC-1000 Code P(C)	
PK	Penetrant Inspection	ASTM-E-1417 (S/S MIL-STD-6866) (S/S MIL-I-6866) Acceptance Rejection Criteria: Per MIL-STD-1907, Note 5, Quality Grade A. Etch required except where Tolerances of +/- .0003 are required	Liquid Penetrant Examination, Standard Practice for
NOTE: Drawing should specify any ETCH MASK requirements or NO MASK.			
PL	Radiographic Inspection	ASTM E1742 (S/S MIL-STD-453)	Radiographic Examination
PM	Radiographic Inspection	MIL HDBK 1264 (S/S MIL-STD-1264)	Radiographic Inspection for Soundness of Welds in Steel By Comparison to Graded ASTM-E-390 Reference Radiographs
PN	Radiographic Inspection	MIL HDBK 1265 (S/S MIL-STD-1265)	Radiographic Inspection Classification and Soundness Requirements for Steel Castings (Specify Grade & Class on B/P) Alternate: use PN (1)
PN (1)	Radiographic Inspection	SAE AMS 2175	Castings, Classification and Inspection of (Specify Grade & Class on B/P)
PO	Soldering-	Cancelled	Soldering Process, General

Non-Electrical

(Was DOD-STD-1866)

Non-electrical, Metric

<u>E/W CODE</u>	<u>PROCESS</u>	<u>APPLICABLE SPECIFICATION</u>	<u>TITLE</u>
PP	Soldering-Electrical	Cancelled (Was MIL STD 2000) (S/S MIL-S-45743)	Soldering, Manual Type, High Reliability, Electrical And Electronic Equipment
PQ	Threads, J	SAE AS8879 (S/S MIL-S-8879)	Screw Threads, UNJ Profile, Inch Controlled Radius Root with Increased Minor Diameter
PR	Threads, Pipe	SAE AS71051 (S/S MIL-P-7105)	Pipe Threads, Taper, Aeronautical National Form, Symbol ANPT, Design and Inspection Standard
PS	Superseded By PU		
PT	Welding, Fusion Aluminum	AWS D17.1 (Was MIL-STD-2219) (Was AWS D17.1) (S/S SAE AMS 2219) (S/S MIL-STD-2219) (Was MIL-W-8604)	Fusion Welding for Aerospace Application (use PT(A), PT(B), or PT(C), see below)
PT(A)	Welding, Fusion Aluminum, Class A	AWS D17.1	Class A Weld (For Critical Applications) (ref. AWS D17.1 para. 6.4) (Radiographic Inspection & Liquid Penetrant Inspection, except as outlined in AWS D17.1)
PT(B)	Welding, Fusion Aluminum, Class B	AWS D17.1	Class B Weld (For Non-Critical Structural Applications) (ref. AWS D17.1 para. 6.4) (Liquid Penetrant Inspection)
PT(C)	Welding, Fusion Aluminum, Class C	AWS D17.1	Class C Weld (For Non-Critical & Non-Structural Applications) (ref. AWS D17.1 para. 6.4) (Visual Inspection Only)
PU	Ultrasonic Inspection	Cancelled (Was MIL-STD-1875)	Inspection, Ultrasonic, Requirements for
PV	Welding, Fusion Steel	AWS D17.1 (See PT above) (Was MIL-W-8611)	Fusion Welding For Aerospace Applications (Use PV(A), PV(B), or PV(C), see below)

<u>E/W CODE</u>	<u>PROCESS</u>	<u>APPLICABLE SPECIFICATION</u>	<u>TITLE</u>
PV(A)	Welding, Fusion Steel, Class A	AWS D17.1	Class A Weld (For Critical Applications) (ref. AWS D17.1 para. 6.4) (Radiographic Inspection & Liquid Penetrant Inspection, except as outlined in AWS D17.1)
PV(B)	Welding, Fusion Steel, Class B	AWS D17.1	Class B Weld (For Non-Critical Structural Applications) (ref. AWS D17.1 para. 6.4) (Liquid Penetrant Inspection)
PV(C)	Welding, Fusion Steel, Class C	AWS D17.1	Class C Weld (For Non-Critical & Non-Structural Applications) (ref. AWS D17.1 para. 6.4) (Visual Inspection Only)
PW	Welding, Spot	(SAE AMS W 6858) (S/S MIL-W-6858)	Welding, Resistance, Spot and Seam
PX	Riveting	(MIL-STD-403)	Preparation for and Installation of Rivets and Screws, Rocket, Missile, and Airframe Structures
PY	Glass Bead		Glass Bead Blast
PY(1)	Shot Peen	SAE AMS2430	Shot Peening
PZ	Part Marking	MIL-STD-130	Identification Marking of U.S. Property
PAA	Cleaning	EWI-CP-001	Oxygen Cleaning with Isopropyl Alcohol
PAB	Cleaning	EWI-CP-002 (S/S by EWI-CP-202)	Oxygen cleaning with Low Titre Soap
PAC	Cleaning	EWI-CP-003 (S/S by EWI-CP-202)	Oxygen cleaning with Detergent
PAD	Cleaning	EWI-CP-201	Cleaning Procedure for Oxygen Cylinders
PAE	Cleaning	EWI-CP-202	Oxygen Cleaning with Aqueous System
PAF	Cleaning	EWI-CP-203 (S/S by EWI-CP-201)	Re-Cleaning of Oxygen Cylinders

<u>E/W CODE</u>	<u>PROCESS</u>	<u>APPLICABLE SPECIFICATION</u>	<u>TITLE</u>
PAG	Cleaning	EWI-CP-61-101 (S/S by EWI-CP-202)	Cleaning Oxygen Components with Freon
PAH	Acid Clean (Cylinders)	AMS 2700 Method 1 (Nitric) Type VI, Class 2 (Alternate use PAJ)	Nassau Chrome Pickle Passivate Processes PP-01 & PP-15 (ref. EWI-TP-001, para. 6.0)
PAJ	Acid Clean (Cylinders)	Alkaline Clean Al ₂ O ₃ Blast (120 grit) Alkaline Clean Passivate (AMS 2700, TY VI) Bake 350°F – 30 minutes (Alternate use PAH)	Aircraft Finishing (AFC) Mechanical Clean & Passivate (ref. EWI-TP-001, para. 6.0)