

DATE <u>6-24-52</u>	<b>TMC SPECIFICATION NO. S-101</b>		
SH. <u>1</u> OF <u>1</u>			
COMPILED BY <u>L.N.H</u>	TITLE: <u>CAUSTIC DIP FOR ALUMINUM</u>		JOB
APPROVED <u>AMB</u>	PAGE ISSUE	A	B

PURPOSE

This specification covers the process of applying caustic dip finish for use on aluminum parts.

PROCEDURE

1. Dip in 10% solution of Sodium Hydroxide (NaOH) in water at 180° F for 30 to 60 seconds depending on time necessary for full etching of the part.
2. Rinse in cold water.
3. Dip in neutralizing solution, 10% Nitric Acid, (HNO<sub>3</sub>), at 70° F.
4. Rinse in cold water.
5. Rinse in hot water (180° F).
6. Dry.
7. ~~Cover all etched surfaces with thin coat of clear water dip lacquer. As per S-107.~~ Deleted

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