

Material Standards & Specifications

Specialty Products Company



MSS	2.005	Nitrocarburizing
Approved by:	CCH	
Revision:	B	
Date:	12/10/08	

Scope:

This specification is intended to cover nitrocarburizing of individual parts and assemblies. This specification replaces IP-268 & IP-305.
(Revision B: corrects the scope statement.)

Background:

Nitrocarburizing was chosen due to its potential to prevent corrosion and provide wear resistance. A finish inspection specification was needed due to the complexity of the process callout for the Compact JounceShock.

General Requirements:

1. The finish is to uniformly cover the part unless specified on the part drawing.
2. The finished surface is to be smooth and free of any debris.
3. Finish is to be gaseous ferritic nitrocarburizing per SAE AMS 2757 using oxidizing oil quench. The depth and hardness per SAE AMS 2757.
4. Post-quench surface polishing is to be used to improve corrosion resistance and surface finish.
5. Finished parts must be capable of passing the 280 hour salt spray test per ASTM B117.
6. Specialty Products Company is to be advised of any failures.
7. Sample size per Quality requirements.