

NOTICE OF CHANGE
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MIL-STD-340(AT)  
NOTICE 1  
2 May 1991

MILITARY STANDARD  
COATING, PACK CEMENTATION, CHROME  
ALUMINIDE, PROCESS FOR

TO ALL HOLDERS OF MIL-STD-340(AT):

1. THE FOLLOWING PAGES OF MIL-STD-340(AT) HAVE BEEN REVISED AND SUPERSEDE THE PAGE LISTED:

NEW PAGE	DATE	SUPERSEDED PAGE	DATE
5	2 May 1991	5	29 March 1988
5a	2 May 1991		

2. RETAIN THIS NOTICE AND INSERT BEFORE TABLE OF CONTENTS.

3. Holders of MIL-STD-340(AT) will verify that page changes and additions indicated above have been entered. This notice page will be retained as a check sheet. This issuance, together with appended pages, is a separate publication. Each notice is to be retained by stocking points until the military standard is completely revised or cancelled.

Custodians:  
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Preparing activity  
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(Project 8030-A135)

AMSC N/A

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FSC 8030

## MIL-STD-340(AT)

## NOTICE 1

2 May 1991

## 5. DETAILED REQUIREMENTS

5.1 Procedure. All part preparation, coating processes, and post cleaning shall be in accordance with Chromalloy Research and Technology Division.

5.1.1 Chromizing process. The detail parts and test panels shall be prepared and chromized in such a manner to provide a chromized coating weight of 35 to 60 mg per 100 square millimeters.

5.1.2 Fabrication. After chromizing, the parts shall be fabricated into assemblies by machining, brazing, or welding prior to aluminizing.

5.1.3 Aluminizing. The chromized assemblies and test panels shall be prepared and aluminized in such a manner to provide an aluminized coating weight of 1.5 to 6.0 mg per 100 square millimeters.

5.2 Test methods.

5.2.1 Visual. All parts or assemblies and test panels shall be visually inspected after chromizing and aluminizing. The surface shall be smooth in its entirety and without evidence of cracking and spalling. There shall be no evidence of untreated areas of pack material adhering to the surface. In addition, there shall be no significant difference in color indicative of uneven coating.

5.2.2 Test samples.

5.2.2.1 Chromizing. There shall be not less than two test panels placed in each retort of parts to be chromized. The test panels shall be placed in the retort in a manner which will accurately represent detail coating quality. In some cases, it may be required to place several test panels in the retort to provide a sufficient number of chromized test panels.

5.2.2.2 Aluminizing. There shall be not less than one acceptable chromized test panels (see 5.2.2.1) placed in each retort of parts or assemblies to be aluminized. The test panels shall be placed in the retort in a manner which will accurately represent part coating quality.

5.2.2.3 Reduced sampling. Once the chromizing and aluminizing cycles are fixed for a specific part, the use of the test panels may be reduced to a sampling plan approved by this contracting agency. When any changes are made in either the chromizing or aluminizing cycles, test panels shall again be processed with the parts in accordance with 5.2.2.1 and 5.2.2.2.

MIL-STD-340(AT)

NOTICE 1

2 May 1991

5.2.2.4 Resistance welding samples. When requested by manufacturing, test specimens for resistance welding shall be processed through the chromizing cycle. The test specimens for resistance welding shall be of the same thickness and material and chromizing cycle. The test specimens for resistance welding shall be of the same thickness and material and chromized in the same manner as the parts represented by the test specimens.