

Aerospace Finishing

Specification Guide



**MacDermid Enthone & OEM's:
Driving Finishing Innovations**



MacDermid Enthone
INDUSTRIAL SOLUTIONS

Aerospace Finishing

Preparation and Performance Enhancement. The Full Range.

OEM	Specification	Product	Description
Airbus	AIPS 02-04-006	Enviralloy Ni 12-15	Zinc-nickel
AMS	2400	Iridite 1 OD	Olive drab passivation
AMS	2402	Iridite 1 OD	Olive drab passivation
AMS	2403	Barrett Nickel	Sulphamate nickel
AMS	2404	NiKlad 768, Vand-alloy 5000	Electroless nickel
AMS	2404	NiKlad 766, NiKlad 767	Electroless nickel low P
AMS	2408B	Stantek	Tin
AMS	2417E	Enviralloy Ni	Zinc-nickel
AMS	2418	Metex S-1	Alkaline copper
AMS	2433C	NiKlad 752	Electroless nickel-boron
AMS	2473	Iridite 14-2	Chromate conversion coating
AMS	2475	Iridite 15	Conversion coating magnesium
American Airlines	0874406	Isoprep 44	Magnesium cleaner
American Airlines	5996447	Isoprep 54P	Cleaner
American Airlines	670546	Isoprep 54P	Cleaner
Boeing	BAC -5714	ALUMON D Liquid	Zincate solution to activate Al
Boeing	BAC-5714	ENPREP 114	Compound, Alkali Smut removal
Boeing	BAC-5749	ENPREP 114	Compound, Alkali Smut removal
Boeing	BAC-5749 / 5751		
Boeing	BAC-5728	ENSTRIP 165S	Stripper
Boeing	BAC-5771	ENSTRIP S	Stripper
Boeing	BAC-5771	ENSTRIP NP	Alkaline stripper
Boeing	BAC-5771	ENSTRIP S	Alkaline stripper
Boeing	BAC-5771	ENSTRIP S	Alkaline stripper
Boeing	BAC-5771	ENSTRIP TL CONCENTRATE	To strip Tin, Lead & Tin/Lead
Boeing	BAC-5728	NiKlad 794	Electroless nickel
Boeing	BAC-5625	Metex M-689	Activator for steel
Boeing	BAC-5701	Iridite 80	Iridescent passivation
Boeing	BAC-5719	Chemidize 727ND	Conversion coating
Boeing	BAC-5725	Isoprep 177	Alkaline deruster
Boeing	BAC-5726	Iridite 14-2	Chromate conversion coating
Boeing	BAC-5749	Isoprep 44, Isoprep 500 L	Cleaner
Boeing	BAC-5765	Isoprep 161	Multi-prep acid cleaner
Boeing	D6-7172	Chemidize 727ND	Conversion coating



OEM	Specification	Product	Description
General Dynamics	10544	Chemidize 727ND	Conversion coating
General Dynamics	900-800-092	Iridite NCP	Non-chrome conversion coating
General Dynamics	000-803-005A	Iridite 14-2	Chromate conversion coating
General Electric	REI-J85-8416	ACTANE 32	Removes rust and scale
General Electric	REI-J85-8416		
General Electric	REI-J85-8416	ENPREP 576 E	Removes rust, oil, silicate & lubricants
General Electric	REI-T700-7454	ENPREP 576 E	Removes rust, oil, silicate & lubricants
General Electric	70-23-99 / S-3	ENSTRIP S	Strip Ni,Zn,Cd,Ag from Ferrous
General Electric	REI-J85-8416	ENSTRIP GT-311 Revised (A,B)	Ni Brazing from Stainless Steel
General Electric	70-31-01,02,03	ENSTRIP GT-317 (A,B,C)	Strip Tungsten carbide coating
General Electric	REI-T700-7454	ENSTRIP 317	Strip Aluminum Oxide/Ni Aluminide
General Electric	70-23-99 / S-4	ENSTRIP L-90	Additive to nitric acid to Stripper
General Electric	70-23-99 / S-10	ENSTRIP S	Stripper for Ni, Zn, Cd, Ag
General Electric	70-23-99 / S-3	ENSTRIP TL CONCENTRATE	To strip Tin, Lead & Tin/Lead
Lockheed 6850	00-000-9085	Iridite 14	Chromate conversion coating
Martin Marietta	08-509-300	Isoprep 58L / 201	Cleaner
McDonnell Douglas	DPM 1510	Iridite 14-2	Chromate conversion coating
McDonnell Douglas	DPM 2776-2	Isoprep 177	Alkaline deruster
McDonnell Douglas	DPM 3305	Isoprep 44	Cleaner
McDonnell Douglas	DPM 3306	Barrett SNAP	Sulphamate nickel
McDonnell Douglas	DPM 980	Barrett SNAC	Sulphamate nickel
McDonnell Douglas	PS 13105 REV.D	ENPLATE NI-431 (A,B,C)	High speed Bright Electroless nickel
McDonnell Douglas	PS 13105 REV.D	ENSTRIP EN-86 (A,B)	Nickel stripper
McDonnell Douglas	DPM 5711	ENSTRIP S	Stripper for Ni, Zn, Cd, Ag
McDonnell Douglas	DPS 967	NiKlad 1000	Electroless nickel
McDonnell Douglas	DPM 2776-2	Isoprep 44	Cleaner
McDonnell Douglas	PS 13204	Iridite 14-2	Chromate conversion coating
MIL	38999	Enviralloy NiFlex 12	Zinc-nickel
MIL	DTL-81706	Iridite NCP	Non-chrome conversion coating
MIL	DTL-81706	Iridite 14-2	Chromate conversion coating
Pratt & Whitney	1257	NiKlad 1000	Electroless nickel
Pratt & Whitney	1584 - 15871	NiKlad 794	Electroless nickel
Pratt & Whitney	1589	NiKlad 790	Electroless nickel
Pratt & Whitney	1624- 1 & 2	Iridite 1 OD	Olive drab passivation

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OEM	Specification	Product	Description
Pratt & Whitney	1631	Iridite 14-2	Chromate conversion coating
Pratt & Whitney	1632	ARP 2	Pickle aid
Pratt & Whitney	1690	Iridite 15	Conversion coating magnesium
Pratt & Whitney	9057	Metex T 103	Alkaline cleaner
Pratt & Whitney	CPMC # 71259	Clepo 86 P	Non-etch cleaner for aluminum
Pratt & Whitney	CPS # 7200	Clepo 86 P	Non-etch cleaner for aluminum
Pratt & Whitney	CPMC # 79101	Clepo 601-LOB	Alkaline cleaner
Pratt & Whitney	PMC 1252	Metex TS-40A	Non-etch cleaner for aluminum
Pratt & Whitney	PMC 1253	Metalex W Special	Alkaline cleaner
Pratt & Whitney	PMC 1255	Metex S 438	Etch cleaner for aluminum
Pratt & Whitney	PMC 1316	AB Metex M 629 PW	Activator for steel
Pratt & Whitney	PMC 1531	Metex Strip Aid	Multi-purpose stripper
Pratt & Whitney	PMC 1549	Barrett SNAP	Sulphamate nickel
Pratt & Whitney	PMC 1550	Barrett SNAC	Sulphamate nickel
Pratt & Whitney	PMC 1551	Barrett SNR-24	Sulphamate nickel
Pratt & Whitney	PMC 1552	Barrett SN	Sulphamate nickel
Pratt & Whitney	PMC 1559	Barrett SNHA	Sulphamate nickel
Pratt & Whitney	PMC # 1256	Clepo 166	Alkaline cleaner
Pratt & Whitney	S PMC # 7750	Clepo 601-LOB	Alkaline cleaner
Pratt & Whitney	PMC 1252	Metex TS-49A	Non-etch cleaner for aluminum
Pratt & Whitney	PMC 1013	ACTANE AAA	Reduces fuming & surface tension
Pratt & Whitney	PMC 1525	ALUMON	Zincate solution to activate Al
Pratt & Whitney	PMC 1272	ALUMON SC-35	Pre treatment of aluminum
Pratt & Whitney	PMC 1262	ENPREP 114*	Alkali Smut removal
Pratt & Whitney	PMC 1286	ENPREP 576 E	Removes rust, oil, silicate & lubricants
Pratt & Whitney	PMC 1581, 2, 3	ENPLATE NI-418 (A, C)	Electroless nickel
Pratt & Whitney	SPMC 97	ENPLATE NI-422 (A, B, C)	Semi-bright Electroless nickel plating
Pratt & Whitney	SPMC 215	ENPREP 114 E	Alkali Smut removal
Pratt & Whitney	SPMC 79	ENSTRIP EN-86	Nickel stripper
Pratt & Whitney	SPMC 75	ENSTRIP GT 301 (A, B)	Strip brazing from Stainless Steel
Pratt & Whitney	SPMC 92	ENSTRIP GT-311 Revised (A, B)	Ni Brazing from Stainless Steel
Pratt & Whitney	SPMC 82	ENSTRIP GT-317 (A, B, C)	Strip Tungsten carbide coating
Pratt & Whitney	SPMC 98	ENSTRIP GT-376 Special (A, B)	Strip Ni/Ni-Cr from Ni-based alloys
Pratt & Whitney	PMC 1771	ENSTRIP L-90	Acid to strip Ni, Cu etc from Al & SS

*+ Customer supplies sodium cyanide



OEM	Specification	Product	Description
Pratt & Whitney	SPMC 101	ENSTRIP N-190 (A, B)	Strip Ni/Ni-Cd from Steel & copper
Pratt & Whitney	PMC 1564	ENSTRIP N-190 (A, B)	Alkaline stripper
Pratt & Whitney	PMC 1576	ENSTRIP REGENERATOR	Stripper for Ni, Zn, Cd, Ag
Pratt & Whitney	PMC 1531	ENSTRIP S	Stripper for Ni, Zn, Cd, Ag
Pratt & Whitney	PMC 1574	ENSTRIP S-180 (A, B)	Alkaline stripper
Pratt & Whitney	SPMC 26	ENSTRIP S	Stripper for Ni, Zn, Cd, Ag
Pratt & Whitney	PMC 1580	Liquid Potassium Carbonate 47%	To raise the pH of certain ENPLATE
Pratt & Whitney	PMC 1285	ENBOND 94	
Pratt & Whitney	SPMC 96	ENSTRIP GT-309 (A,B)	Ni Brazing from Ni-based
Pratt & Whitney	PMC 1281	STRIPPER S-16	Stripper
Pratt & Whitney	SPOP 311	OMG Fidelity 5005	High Phosphorus Electroless nickel
Pratt & Whitney	SPOP 320	OMG Fidelity 5005	High Phosphorus Electroless nickel
Rockwell Int.	LA 109-024	Iridite 14-2	Chromate conversion coating
Rolls-Royce	RRP51001	Metex M 629	Activator for titanium
Rolls-Royce	1/6 A	ENPLATE NI-415 (A, B, C)	Electroless nickel
Rolls-Royce	179	ENSTRIP CR5	Stripper
Rolls-Royce	1/223	ENSTRIP NP 1 & 2	Alkaline stripper
Rolls-Royce	1/60 C	ENSTRIP S	Stripper for Ni, Zn, Cd, Ag
Rolls-Royce	TSD594-J	OMG Fidelity 5005	High Phosphorus Electroless nickel
Westinghouse	2404	NiKlad 794	Electroless nickel

MacDermid Enthone and OEM's: Driving The Innovation Process

Removing oil, grease and general soils from metals such as aluminum, brass, magnesium and steel is a critical step in any surface treatment process. Additionally the **Metex** and **Isoprep** range contains products to remove oxide and activate metallic surfaces. **Iridite NCP** and **Iridite 14-2** provide excellent corrosion resistance to aluminum alloys, whereas **Iridite 15** is the recommended conversion coating for magnesium. **NiKlad** Electroless nickel coatings improve characteristics such as appearance, corrosion / wear resistance and magnetic properties. **ChromKlad** hardchromium provides both exceptional wear and abrasion resistance as well as retaining oil lubricating films. **Enviralloy** Ni Zinc-nickel gives exceptional sacrificial corrosion resistance and the coating is compatible with light metals such as aluminum and magnesium.

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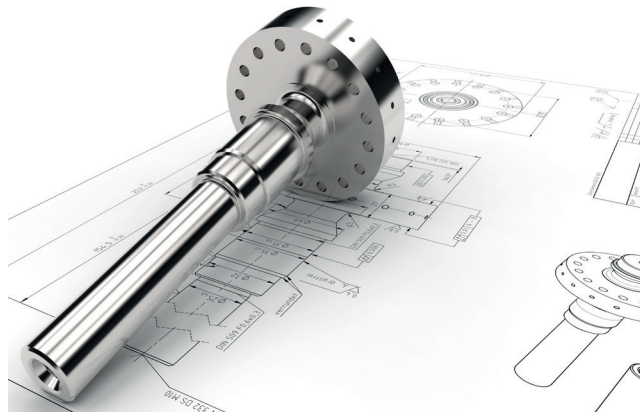
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OEM COATINGS

1. Ni plate under Cd on Al electrical connectors throughout – thousands
2. Electroless Ni-PTFE and ZnNi replacing Cd on connectors
3. Ni plate under gold plate on all connector pins – thousands
4. Ni anti-seize on threads
5. Ni alloy or Ni plated pitot tube
6. ZnNi plating for corrosion protection
7. Ni plated Cu wiring for corrosion protection
8. Electroless Ni on bearings for wear
9. Electroless Ni and electroplated Ni on critical rotating parts and shafts for wear and corrosion
10. ZnNi on bearings for corrosion
11. EN for wear and corrosion – hundreds
12. Ni plated brake disks
13. Electroless Ni for pin internals
14. ZnNi plate replacing Cd on externals
15. Electroless Ni internal coatings
16. Ni plating on Aluminum on Flight recorder "Black box"
17. Electroless Ni on Hydraulic pumps, valves
18. Electroless Ni on Gears and bearings
19. Ni plated Al on avionics boxes, dozens
20. ZnNi plated fasteners

COATINGS

1. Electroless Ni-PTFE and ZnNi replacing Cd on connectors
2. ZnNi plating for corrosion protection
3. ZnNi plating for repair
4. Electroless Ni and electroplated Ni on critical rotating parts and shafts for wear and corrosion
5. ZnNi on bearings for corrosion
6. EN for wear and corrosion – hundreds
Electroless Ni for pin internals
7. ZnNi plate replacing Cd on externals
8. Electroless Ni internal coatings
9. ZnNi plated fasteners



REPAIR COATING

1. Ni anti-seize on threads
2. ZnNi plating for repair
3. Electroless Ni and electroplated Ni on critical rotating parts and shafts for wear and corrosion
4. Sulfamate Ni for landing gear repair

OEM COATING

GREEN COATING

REPAIR COATING





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