

# BAC5640

REVISION  
B  
6/7/2022

NITRIDING OF STEEL



THIS SPECIFICATION ESTABLISHES THE REQUIREMENTS FOR NITRIDING STEELS AS WELL AS THE PRIOR OR SUBSEQUENT HEAT TREATMENT OF THESE STEELS

<b>BAC 5640 DEPARTURES</b>	<b>EFF DATE</b>	<b>AFFECTED SUBCONTRACTOR(S)</b>	<b>AFFECTED PROGRAMS</b>	<b>AFFECTED BOEING SITES</b>	<b>REASON</b>
1-1	5/31/2022	LIEBHERR AEROSPACE GMBH	777	ALL	TO ALLOW USE OF TYPE D INSTEAD OF TYPE C, WITH CLASS II FOR FINAL TERMPERING OPERATION
1-2	6/7/2022	BODYCOTE THERMAL PRODUCTS AND NORTHSTAR AEROSPACE	F/A22	NONE	TO ADD PROVISION TO USE STOP-OFF PAINT AS SUPPLEMENT TO COPPER PLATING WHEN SELECTIVE NITRIDING.
1-3	6/7/2022	ALL	ALL BOEING PHILADELPHIA	PHILADELPHIA, PA	ADD REQUIREMENTS FOR NTIRDING ALLOY STEELS SUCH AS 8740 AND 4340 STEEL. UPDATEDS INLCUDED ARE TO ALIGN WITH BASE REVISION
DCNPSO_007928_001	6/7/2022	N/A	N/A	N/A	ADD PRE AND POST NITRIDE INSPECTION POINTS FOR THE COPPER PLATE MASKANT