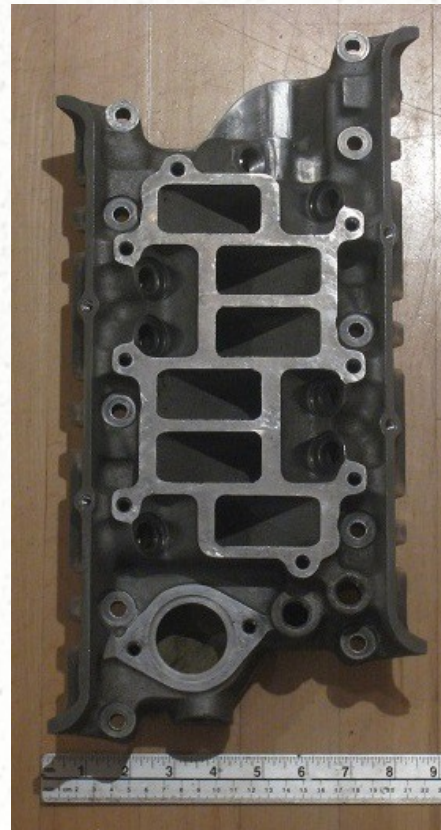
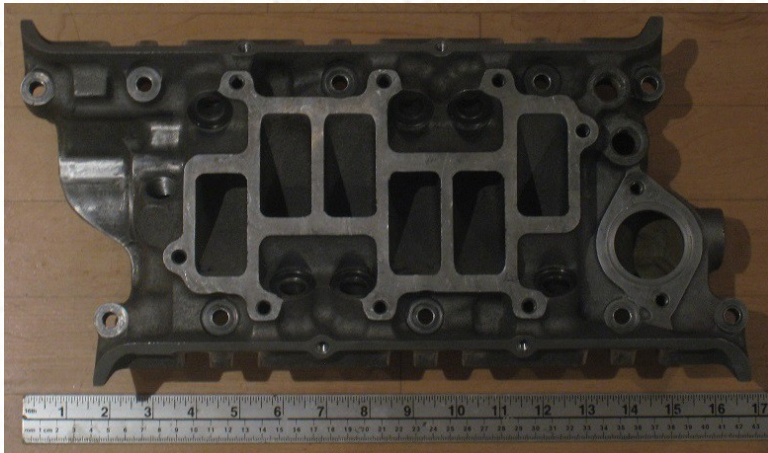


Job description

- Automotive engine intake manifold
- Material: cast aluminium (some dirt/grease contamination)
- Desired plating: electroless nickel
- ASTM B733-15
- Phosphorus Content: TYPE IV (medium phosphorus)
- Coating Thickness: SC3 (0.001" thick)
- Post Heat Treatment: CLASS 4

Part size

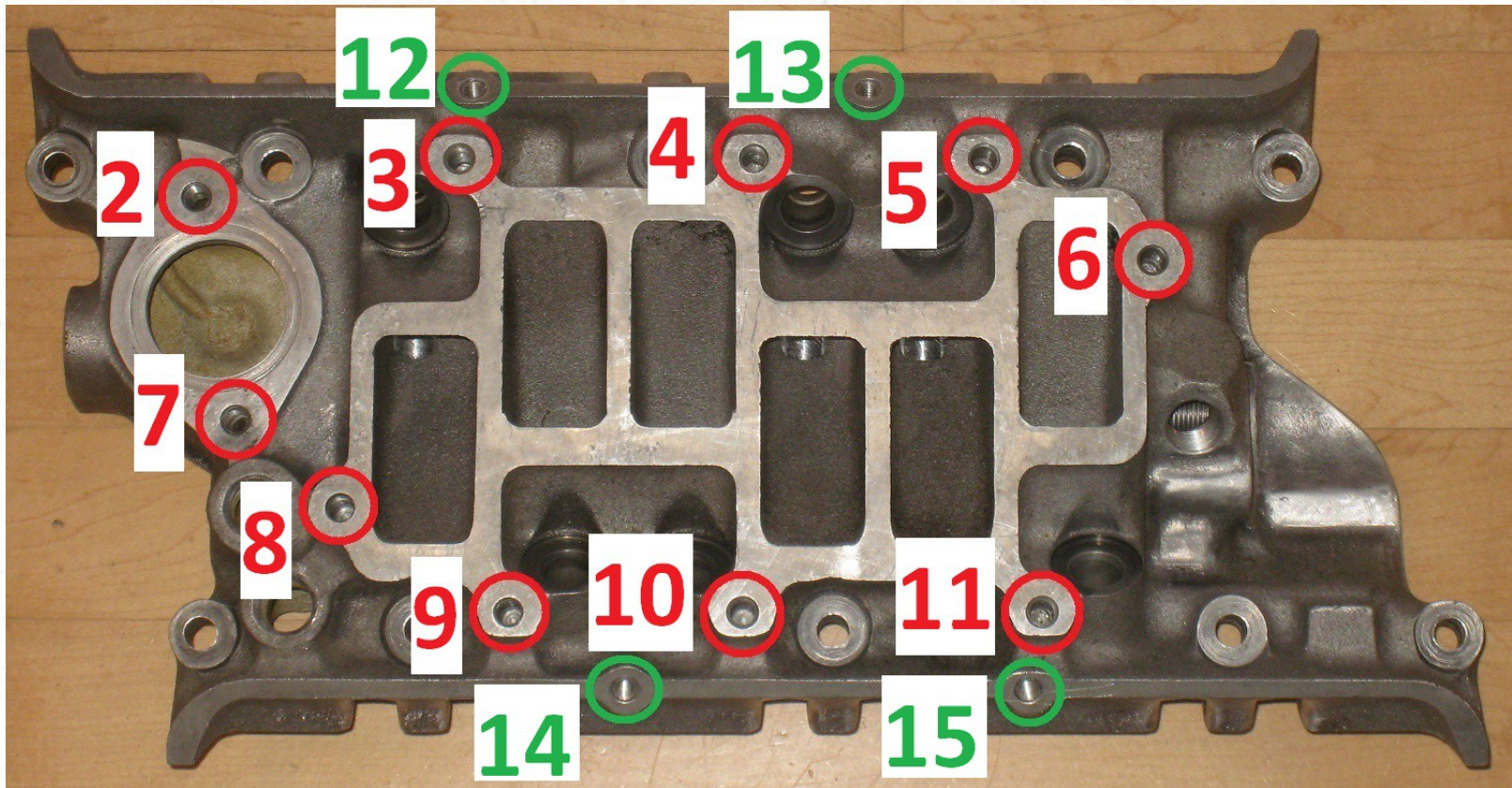
- Size: 17 x 9 x 3 in
- Weight: 9 lbs



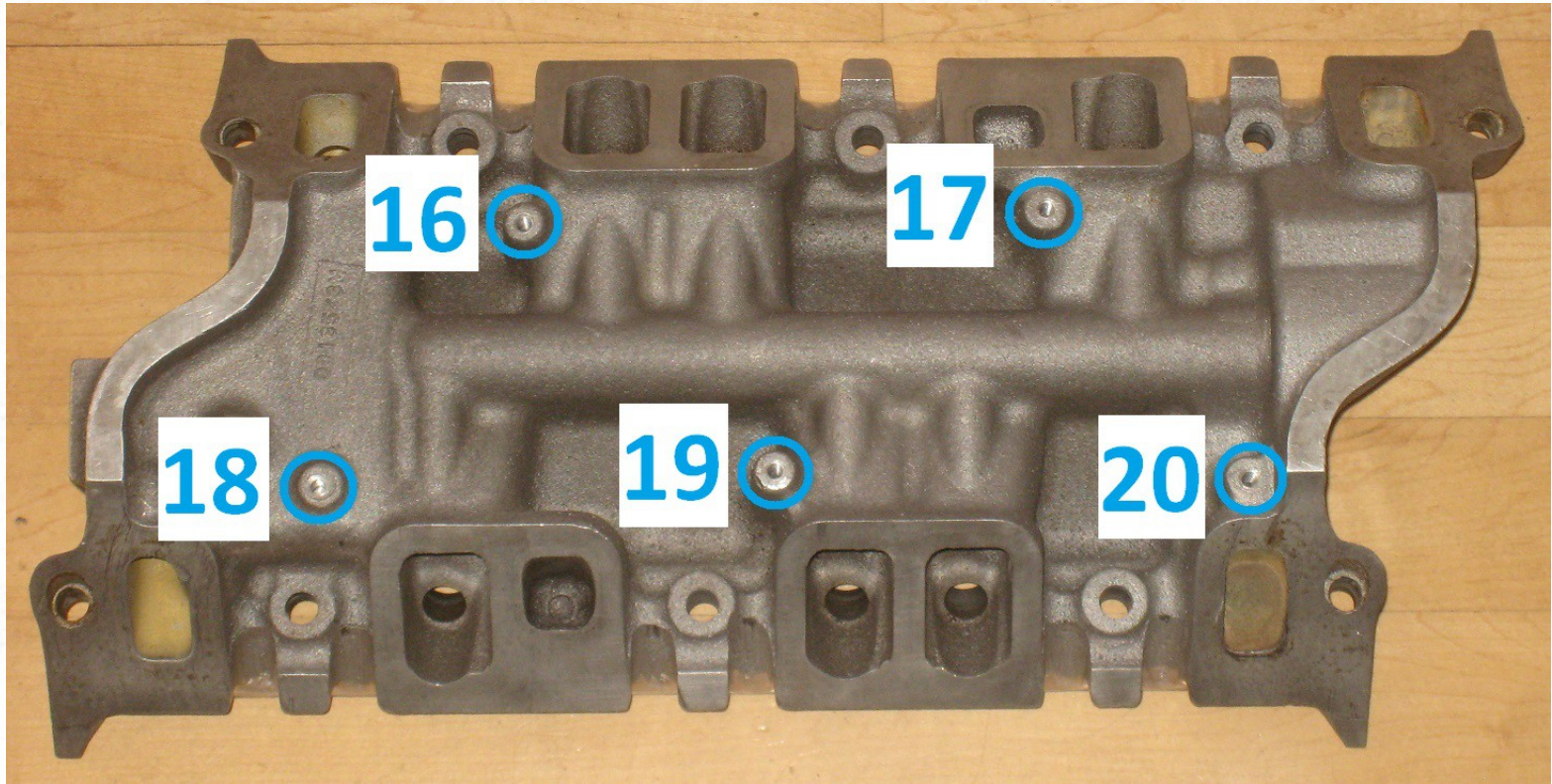
Masked holes (1)



Masked holes (2-15)



Masked holes (16-20)



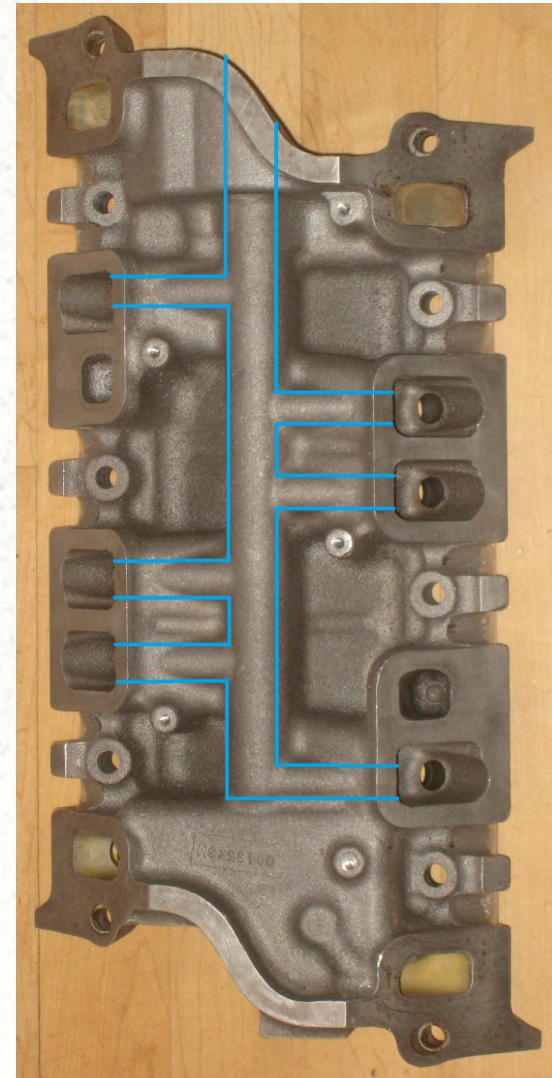
Masked holes (summary)

Hole	Thread
1	M8 x 1.25 blind
2	
3	
4	
5	
6	
7	
8	
9	
10	
11	
12	M6 x 1.0 blind
13	
14	
15	
16	#10 - 32 UNF blind
17	
18	
19	
20	

- All other surfaces to be plated
- Other threads are NPT and must be plated

Internal passage requiring plating

- Internal passage has openings on both sides and at the top



Hook

- Made of aluminium
- Screws into hole #1
- If the part cannot be shaken/turned, supporting it from the hook will minimize air pockets trapped in the internal passage

