

# Capabilities Overview



**CHRISTENSEN INDUSTRIES IS ISO9001:2008 AND AS9100:2009 CERTIFIED AND CARRIES NADCAP CERTIFICATION FOR OUR IN-HOUSE SPECIAL PROCESSES**

## Capabilities at a Glance

- Fully Capable Precision Machining and Turnkey Metal Fabrication
- Punching, Bending, Forming, Deburring, Machining and Assembly of Metal Products
- Fusion (TIG) Welding and Resistance Spot Welding of aluminum and stainless steel
- Type I and Type II Chemical Conversion Coating
- Wet Paint priming and top coating of metals
- Powder Coating of metals
- Passivation of stainless steel
- Chemical Etching of aluminum
- Heat Treating and Solution Quenching of aluminum alloys
- Artificial Aging of aluminum alloys
- In-house inspection, testing and certification of all production parts.

## Maximum Part Size Limits

- Sheet Metal Parts: 240 (in) x 60 (in) for each single part/sub-component in its flat condition (pre-bend). Multiple parts/sub-components can be joined together through assembly or welding to create larger assemblies.
- 3-axis Machined Parts: our vertical mills can accommodate up to a 22(in) deep x 51(in) wide x 22(in) tall part without indexing (repositioning of the part). Slightly larger parts can typically be accommodated through indexing.
- 4-axis Machined Parts: our horizontal machining centers can accommodate up to a 20(in) cubed part without indexing (repositioning). Slightly larger parts can typically be accommodated through indexing.
- Lathe (Turned) Parts: Up to 6(in) diameter. Length restrictions vary depending on part.

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## Specifications we are qualified to process to:

### Welding Specifications:

- DPS 10.225 TIG Welding
- DPS 10.301 Fusion Welding
- DPS 10.350-17 Standard Welding Procedure – Military
- DPS 10.800 Resistance Spot Seam Welding
- AMS-STD-2219 Fusion Welding
- AWS D17.1 Fusion Welding
- AWS D17.2 Resistance Spot Welding
- MIL-STD-1595 Qualification of Aircraft, Missile and Aerospace Fusion Welders
- MIL-STD-2219 Fusion Welding for Aerospace Applications
- MIL-W-6858 Welding, Resistance, Spot and Seam

### Aluminum Heat Treat Specifications:

- AMS 2770 Heat Treatment of Aluminum Alloy
- AMS-H-6088 Heat Treatment of Aluminum Alloys
- ASTM E18-08 Rockwell Hardness Testing
- ASTM E1004-09 Electrical Conductivity Testing
- MIL-H-6088 Heat Treatment of Aluminum Alloys
- MIL-STD-1537 Electrical Conductivity Test – Eddy Current Method

### Metal Finishing Specifications:

- DPS 4.50-4 Spray Painting Methods
- DPS 4.50-36 Epoxy FR Coating
- DPS 4.50-62 Impact Resistant Coating
- DPS 4.50-66 Paint Adhesion Tests
- DPS 4.50-152 Water Based Finish
- DPS 4.50-165-17 Aliphatic Poly Coating

- DPS 9.07 Surface Preparation of Corrosion Resistant Steels
- DPS 9.45 Chemical Conversion Coating
- DPS 9.301 Cleaning Aluminum Alloys
- AMS 2474 Chemical Treatment of Aluminum Alloys
- AMS 2700 Passivation of Corrosion Resistant Steel
- AMS-STD-753 Surface Passivation of Stainless Steel
- ASTM A380-06 Passivation of Stainless Steel Parts
- ASTM D523 Standard Test Method for Specular Gloss
- ASTM D3359 Tape Adhesion Testing
- ASTM D7091 Dry Film Thickness Testing
- FED-STD-141 Paint, Varnish, Lacquers and Related Materials, Methods of Inspection, Sampling and Testing
- FED-STD-595 Colors Used in Government Procurement
- MIL-DTL-5541 Chemical Conversion Coatings on Aluminum and Aluminum Alloys
- MIL-PRF-23377 Primer Coatings: Epoxy, High-Solids
- MIL-PRF-85285 Coating: Polyurethane, Aircraft and Support Equipment
- MIL-PRF-85582 Primer Coatings: Epoxy, Waterborne
- MIL-STD-753 Surface Passivation of Corrosion-Resistant Steel Parts
- QQ-P-35 Passivation Treatments for Corrosion-Resistant Steels
- Note: Please contact us if there is a specification you need similar to our existing capabilities but not listed here.



## Christensen Industries

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**Intertek**