



**Coastline Metal Finishing is ISO Certified and NADCAP Accredited.**

**ISO - DNV Management System Certificate: Cert –06810-2004-AQ-HOU-RAB**

**Nadcap Accredited AS7108 for Chemical Processing**

Thank you for considering Coastline Metal Finishing for your processing needs. Coastline Metal Finishing has been in business since 1987 serving the Aerospace, Automotive, Microwave, Satellite, Electronics and Medical industries. The company has developed a reputation within these industries for meeting the leading edge in Plating, Anodizing and Masking requirements for precision-machined parts.

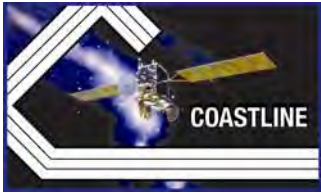
While developing a strong reputation in many industries, one of the key elements is the knowledge and experience of the Coastline Metal Finishing staff. Many of our employees have been with the company since it's inception and many key personnel have over 30 years of experience in the finishing industry.

Coastline Metal Finishing offers a variety of plating finishes which include; Electroless Nickel, Bright and Sulfamate Nickel, Copper, Gold, Silver, Tin plate and Passivation. For multiple processes we have a dedicated staff for masking requirements. We also have the capabilities and quick response to meet the single process, rack and run orders.

The Anodize & Chemical Film department can support both small and large production orders. We offer Anodize in the Type II, Sulfuric, or Type III Hard Anodize process. We also have the Teflon Coating available in the Type III Hard Anodize process. We have large tanks with overhead hoist equipment that can accommodate parts up to ten feet in length. We also have a variety of colored dyes to enhance the appearance of parts.

Coastline Metal Finishing has many RoHS compliant Processes. They are identified on the process list page. Please feel free to contact any of our staff members for any questions that you might have about our services.

Thank you.

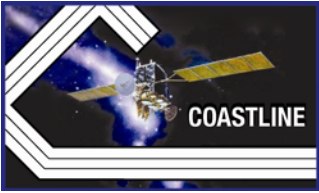


## Process List

Anodize Type II (Rohs Compliant without Dichromate Seal)  
Anodize Type III (Rohs Compliant without Dichromate Seal)  
Anodize TFE  
Chemical Film  
Clear Chemical Film (Rohs Compliant)  
Brush Plating  
Copper Plate  
Electroless Nickel (High, Mid, Low Phosphorus) (Rohs Compliant)  
Sulfamate Nickel  
Bright Nickel  
Boron Electroless Nickel (Commercial Grade Only)  
Passivation  
Gold Plate (Rohs Compliant)  
Silver Plate (Rohs Compliant)  
Tin Bright (Rohs Compliant)  
Tin Matte  
Tin Lead-Reflow  
Tin Plate-Reflow

### **Processes performed to Military specifications and Customer specifications.**

Paint Services outsourced to Coastline High Performance Coatings.  
Non-destructive Testing outsourced to Stork Material Testing & Inspection.  
These services performed only in combination with above processes.



## Contact Information

Name	Position	Phone	Email
Joe Padilla	President	(714) 895-9099 ext. 23	<a href="mailto:coastline@clmf.com">coastline@clmf.com</a>
Ron Covey	Vice President	(714) 895-9099 ext. 36	<a href="mailto:coastline@clmf.com">coastline@clmf.com</a>
Allen Fowler	2 <sup>nd</sup> Vice President	(714) 895-9099 ext. 30	<a href="mailto:allenf@clmf.com">allenf@clmf.com</a>

### Quotes/Pricing

Sosene Schuster	Quotes/Pricing/Contracts	(714) 895-9099 ext. 27	<a href="mailto:sosenes@clmf.com">sosenes@clmf.com</a>
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### Customer Support

Eduardo Padilla	Order Status/Shipping	(714) 895-9099 ext. 28	<a href="mailto:edpadilla@clmf.com">edpadilla@clmf.com</a>
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### Sales Department

Brent Hoops	Sales Manager	(714) 809-3101	<a href="mailto:brenth@clmf.com">brenth@clmf.com</a>
Fred Daichendt	Sales Representative (Arizona)	(602) 867-1680	<a href="mailto:fred_imr@Q.com">fred_imr@Q.com</a>

### Quality Department

Juan Cadenas	Q. A. Manager	(714) 895-9099 ext.29	<a href="mailto:juanc@clmf.com">juanc@clmf.com</a>
Rosa Vazquez	Quality Supervisor	(714) 895-9099 ext. 25	<a href="mailto:Rosav@clmf.com">Rosav@clmf.com</a>
Joe Loughry	Quality Engineer	(714) 895-9099 ext.22	<a href="mailto:jloughry@clmf.com">jloughry@clmf.com</a>

### Office

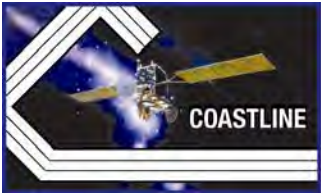
Veronica Sanchez	Office Manager	(714) 895-9099 ext.24	<a href="mailto:veronicas@clmf.com">veronicas@clmf.com</a>
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Please contact the Shipping Department with questions regarding pick up and delivery.



Process	Type	
<b>Minimum Charge</b>		
<b>Anodize &amp; Chemical Film</b>		
Sulfuric Anodize	Type II	\$75.00
Sulfuric Anodize	Type II Dyed	\$75.00
Hard Anodize	Type III	\$100.00
Hard Anodize	Type III Dyed	\$100.00
Hard Anodize	Teflon Seal	\$150.00
Chemical Film	Chromate	\$65.00
Chemical Film	Chromate/Approval Required	\$125.00
Chemical Film	Clear	\$65.00
Chemical Film	Clear/Approval Required	\$125.00
Chemical Film	RoHS compliant	\$125.00
<b>Electroless Nickel (Please see Bake charges below)</b>		
Electroless Nickel	Low, Mid, High phosphate	\$125.00
Nickel	Bright	\$125.00
Nickel	Semi Bright	\$125.00
Nickel	Sulfamate	\$125.00
Electroless Nickel	Boron	\$150.00
<b>Gold &amp; Silver &amp; Copper (Please see Bake charges below)</b>		
Gold	Type I, II, III	\$300.00
Silver Plate	Type I, II	\$200.00
Copper Plate		\$100.00
Immersion Gold		\$300.00
<b>Tin Plate (Please see Bake charges below)</b>		
Tin Plate	Matte	\$100.00
Tin Plate	Bright	\$100.00
Tin Lead	60/40	\$125.00
Tin Reflow	90/10	\$150.00
Tin Lead	60/40	\$125.00
Tin Lead Reflow	90/10	\$150.00
<b>Passivation</b>		
Passivation	No Testing	\$85.00
Passivation	Copper sulfate testing	\$105.00
Passivation	24 Hour High Humidity testing	\$125.00
<b>Misc. Process</b>		
Masking		\$65.00
Clean		\$85.00
Clean & Etch		\$175.00
Glass Bead & Sand Blasting		\$45.00
Stress Relieve Bake		\$75.00
Identify		\$65.00
Source Inspection		\$500.00
Brush Plating		Contact Estimating

\* Please note. There is a 10% Hazardous Waste Sur-Charge This applies to all lot charges and unit prices.



## Process

### Minimum Charge

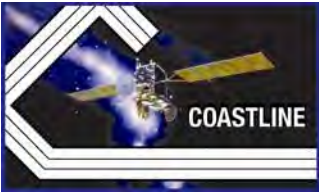
#### **Bake Charge**

Bake for Hydrogen Embrittlement	\$75.00 – 3 hours	\$125.00 -24 hours
Post Plating Bake over 3 Hours	\$75.00 – 3 hours	\$125.00 -24 hours
Post plating Bake with Nitrogen (30 Minutes – 4 Hours)	\$125.00	

#### **Additional Testing charges**

Solderability testing (includes Steam Age)	\$75.00
Purity Testing (Tin Plate ASTM B 545)	\$75.00

\* Please note. There is a 10% Hazardous Waste Sur-Charge This applies to all lot charges and unit prices.



## Customer Approvals

Adams Rite Aerospace  
Boeing D-14426  
Boeing Satellite Division  
Ducommun Technologies  
Eaton Aerospace  
General Atomics  
Aeronautical Systems  
General Dynamics  
Goodrich Aerospace  
Aerostructure  
Flight Space Systems  
Honeywell  
Kaiser Electro Precision  
Lockheed Martin  
Aeronautical Division  
Denver Division  
New Orleans Division  
L3 Electron Technologies  
L3 Cincinnati Electronics  
L3 Narda West  
Moog Aerospace  
Torrance Division  
Northrop  
Space Technology  
Parker Aerospace Group  
Irvine  
Salt Lake City  
Raytheon All Divisions

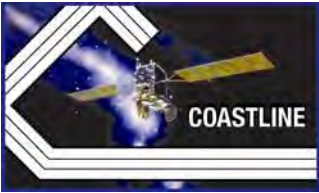
## Customer Approvals

BAE Systems  
Babcock  
Certified Fabricators  
Composite Optics  
Programmed Composite  
Daico  
Dow-Key Microwave  
Ico Industries  
ITT Aerospace  
Lark Engineering  
Leach International  
Light Works Optics  
Metalagraphics  
Micro Mode  
Micro- Semi  
Modern Industries  
OCA Applied Optics  
PB Fastener  
Remec Microwave  
Teledyne Electronics  
Teledyne Relays  
Vacco  
YS Controls  
Zycor Technologies



## Coastline Metal Finishing Facilities Capabilities

Anodizing/Plating	Tank Sizes	Specification	Type/Class	Grade
Sulfuric Anodize	(11'X11'X5'D)	Mil-A-8625	Type II, IIB Class 2-Dyed	
		AMS 2471		
Hard Anodize	(11'X11'X 5'D)	Mil-A-8625	Type III Class 2-Dyed	
		AMS2468		
		AMS2469		
TFE Hard Anodize	(36"X36"X34" D)	MIL-A-8625	Type I	
		MIL-A-63576		
Sealing:				
Hot Deionized Water	(60"X120"X60" D)			
Sodium Dichromate	(60"X120"X60" D)			
Nickel Acetate	(60"X120"X60" D)			
Chemical Film	(11'X11'X5'D)	Mil-C-5541	Class 1A	Clear or Gold
		Mil-C-5541	Class 3	Clear or Gold
		AMS-C-5541	Class 1A	Clear or Gold
		AMS-C-5541	Class 3	Clear or Gold
Tin Bright	(30"X60"X36" D)	Mil-T-10727	Type I	Bright
		ASTM-B-545	Class A - F	
Tin, Flow-Bright		Mil-T-10727	Type I	Flow-Bright
		ASTM-B-545	Class A-B	Flow-Bright
Tin	(20"X30"X24" D)	AMS2408		
Tin	(30"X60"X36" D)	ASTM-B-545	Class A-F	Matte-Bright Flow-Bright
Tin Lead	(28"X24"X30" D)	Mil-P-81728		Bright
	(30"X60"X36" D)	AMS-P-81728		Bright
	(30"X60"X36" D)	Mil-P-81728		Matte
		AMS-P-81728		Matte
		Mil-P-81728		Re-Flow
		AMS-P-81728		Re-Flow
Brush Plating (Dalic)		Mil-Std-865		
Passivation	(24"X48"X36" D)	QQ-P-365	Type II, VI, VII, VIII	Testing Required
		AMS-QQ-P-35	Type II, VI, VII, VIII	Testing Required
		ASTM-A-967		
Copper	(60"X30"X34" D)	Mil-C-14550	Class 1-4	
		AMS-2418		
Electroless Nickel				
Mid Phosphorus		Mil-C-26074	Class 1-4	Grades A,B,&C
	(30"X90"X48" D)	AMS-2404		
Low -Phosphorous	(30"X90"X33" D)	AMS-2405		(Low Phosphorus)
High -Phosphorus	(39"X36"X33" D)	ASTM-B-607	Type 1-2	
		ASTM-B-656	Class 1-5	(Nickel Phosphorus)
Bright Nickel	(24"X30"X32" D)	QQ-N-290		
Sulfamate Nickel	(30"X53"X34" D)	QQ-N-290A	Class 1	Grade A - E
		AMS-2424	Class 2	Low Stress



**COASTLINE METAL FINISHING CORPORATION**

Anodizing/Plating	Tank Sizes	Specification	Type/Class	Grade
Semi Bright Nickel	(30"X53"X34"D)	AMS-2403		General Purpose
		AMS-2423		Hard (Chloride)
		ASTM-689		
Nickel Boron	(18"X18"X18"D)	AMS-2433	Class 1-4	Grade A-D
Gold	(12"X41"X34"D)	Mil-G-45204	Type I	Grade A (or as specified)
	(18"x12"x18"D)		Type II	Grade C (or as specified)
	(18"X12"X18"D)		Type III	Grade A
Silver	(33"X60"X34"D)	QQ-S-365	Type I	Grade A & B
		AMS-2410	Type II	Grade A & B
		AMS-2411		
		AMS-2412		