

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

**BRIEF DESCRIPTION:**

FB-2 COPPR-NICKL-BAKE-CHRM-MET

**FB**

**2**

REV DATE: 4/1/2007

**GENERAL DESCRIPTION**

.00001 MIN CHROMIUM AND MET COAT#3 OVER .00015 MIN NICKEL OVER .00005 MIN COPPER (ELECTROPLATED)

**APPEARANCE**

SHINY BRIGHT CHROME APPEARANCE

**ADHESION AND DUCTILITY**

TO BE TESTED IN ACCORDANCE TO ASTM B571 (SCOTCH TAPE TEST)

**CORROSION REQUIREMENTS**

RED RUST: 96

WHITE CORRIOSION: 0

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

**COATING THICKNESS REQUIREMENTS**

MIN THICKNESS COPPER: .0005  
.00001  
ASTM E376

NICKEL: .00015  
MAX THICKNESS: .0003

CHROMIUM  
TOTAL THICKNESS TESTED PER

**STRESS RELIEF**

PARTS TO BE BAKED AT 425 DEGREES F FOR 6 HOURS WITHIN 1 HOUR OF BASE PLATING

**QUALITY CONTROL**

GRINDING WHEEL TEST: SAMPLE PARTS WILL BE GROUND ON EDGES THROUGH THE PLATED DEPOSIT & INTO THE BASE METAL & THE GROUND EDGES EXAMINED FOR FLAKING OR PEELING. VISUALLY INSPECT FOR UNIFORMITY OF COLOR AND SURFACE APPEARANCE, FREEDOM FROM BLISTERING, FLAKING OR PEELIING. BAKE AFTER NICKEL PLATE

**PROCESS TO**

GE F70D4A2

PRINT DATE:

6/2/2016