

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

FF-0 COPP-NICKL-BAKE-CHRM-V190

FF

0

REV DATE: 4/1/2007

GENERAL DESCRIPTION

.00001 MIN CHROMIUM AND TODCO V109 PLUS 50% V5 (OR EQUIV) WAX WITH UV TRACER OVER .00015 MIN NICKEL OVER .00005 MIN COPPER (ELECTROPLATED) TFS/TCS

APPEARANCE

SHINY BRIGHT CHROME APPEARANCE

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 12

WHITE CORRIOSION: 0

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: COPPER:.00005 NICKEL:.00015 CHROMIUM:.00001
MAX THICKNESS: COPPER: .00007 NICKEL:.00035 CHROMIUM:.00003

STRESS RELIEF

PARTS TO BE BAKED AT 400 DEGREES F FOR 4 HOURS WITHIN 1 HOUR OF BASE PLATING

QUALITY CONTROL

GRINDING WHEEL TEST: SAMPLE PARTS WILL BE GROUND ON EDGES THROUGH THE PLATED DEPOSIT AND INTO THE BASE METAL AND EXAMINE GROUND EDGES FOR FLAKING OR PEELING. BAKE AFTER NICKEL PLATING

PROCESS TO

PRINT DATE:

6/2/2016