

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

## BRIEF DESCRIPTION:

FQ-0 COPPER-NICKEL-CHROME

**FQ**

**0**

REV DATE: 2/4/2008

## GENERAL DESCRIPTION

.00001 MIN. CHROMIUM OVER .0003 MIN. NICKEL OVER .0003 MIN. ELECTRO PLATED COPPER. BAKE AFTER COPPER PLATE

## APPEARANCE

SHINY BRIGHT CHROME

## ADHESION AND DUCTILITY

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

## CORROSION REQUIREMENTS

RED RUST: 16

WHITE CORROSION: 1

TEST PER ASTM B117

## COATING THICKNESS REQUIREMENTS

MIN. COPPER .0003 MIN. NICKEL .0003 MIN. CHROMIUM .00001 MAX. COPPER .0005 MAX. NICKEL .0005  
MAX. CHROMIUM .00003 TESTED PER ASTM E376

## STRESS RELIEF

BAKE 400 DEGREES F FOR 4 HOURS AFTER COPPER PLATE

## 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

## PROCESS TO

PRINT DATE:

6/2/2016