

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

**BRIEF DESCRIPTION:**

FS-0 COPPER-NICKEL-CHROME

**FS**

**0**

REV DATE: 9/4/2007

**GENERAL DESCRIPTION**

.0002 MINIMUM COPPER AND .0005 NICKEL OVER .00001 MINIMUM CHROMIUM

**APPEARANCE**

BRIGHT SHINY CHROME

**ADHESION AND DUCTILITY**

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

**CORROSION REQUIREMENTS**

RED RUST: 48

WHITE CORRIOSION: 0

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

**COATING THICKNESS REQUIREMENTS**

MIN THICKNESS: .0002 COPPER : .0005 NICKEL: .00001 CHROMIUM

MAX THICKNESS: .0004

COPPER: .0005 NICKEL:.00003 CHROMIUM THICKNESS SHALL BE TESTED PER ASTM E376

**STRESS RELIEF**

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

**QUALITY CONTROL**

VISUALLY INSPECT FOR UNIFORMITY OF COLOR & SURFACE APPEARANCE, FREEDOM FROM TEARS, BARE SPOTS, POWDERY FILM. SLOUGHING OFF OF FILM & BLISTERING

**PROCESS TO**

MIDLAND ROSS 25-X-144

PRINT DATE:

6/2/2016