

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

HD-1 COPPER-NICKEL-BAKE-RoHS

HD

1

REV DATE: 4/1/2007

GENERAL DESCRIPTION

.00015 MIN ELECTROPLATED BRIGHT NICKEL OVER .00005 MIN COPPER FLASH
!!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

SHINY BRIGHT NICKEL APPEARANCE

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 8

WHITE CORRIOSION: 0

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS COPPER: .0005

NICKEL:.00015

.0008 NICKEL:.00035

THICKNESS SHALL BE TESTED PER ASTM E376

MAX THICKNESS COPPER:

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 THE GROUNDED EDGES EXAMINED FOR FLAKING OR PEELING . VISUALLY INSPECT FOR UNIFORMITY OF COLOR AND SURFACE APPEARANCE, BLISTERING.

PROCESS TO

ASTM B456

PRINT DATE:

6/2/2016