

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

**BRIEF DESCRIPTION:**

HE-1 ELECTRO NICKEL-BAKE-RoHS

**HE**

**1**

REV DATE: 4/1/2007

**GENERAL DESCRIPTION**

.00015" MIN NICKEL ELECTROPLATE FINISH. NO COPPER FLASH PERMITTED !!!MUST BE RoHS COMPLIANT!!!

**APPEARANCE**

NICKEL APPEARANCE

**ADHESION AND DUCTILITY**

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

**CORROSION REQUIREMENTS**

RED RUST: 8

WHITE CORRIOSION:

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

**COATING THICKNESS REQUIREMENTS**

NICKEL: MIN THICKNESS: .00015 MAX THICKNESS:  
.00035

NO COPPER FLASH PERMITTED

**STRESS RELIEF**

IMMEDIATE BAKE AT 400 DEGREES F FOR 4 HOURS MINIMUM

**QUALITY CONTROL**

THICKNESS TEST: ELECTRONIC THICKNESS TESTER

**PROCESS TO**

ASTM B456 (FOR PROCESS DESCRIPTION) GE F70E2C4

PRINT DATE:

6/2/2016