

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

HF-2 COPPER-NICKEL-BAKE-RoHS

HF

2

REV DATE: 9/16/2013

GENERAL DESCRIPTION

COMMERICAL BRIGHT NICKEL ELECTROPLATE FINISH .0002" THICK WITH A UNIFORM SURFACE OVER A COPPER FLASH !!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

SHINY BRIGHT NICKEL APPEARANCE

ADHESION AND DUCTILITY

TO BE TESTED IN ACCORDANCE TO ASTM B571

CORROSION REQUIREMENTS

RED RUST: 8

WHITE CORRIOSION: 0

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

COPPER FLASH: .00005" MIN .00010" MAX NICKEL: COMBINED COPPER/NICKEL THICKNESS .0002"-
.0004" THICKNESS SHALL BE TESTED PER ASTM E376

STRESS RELIEF

PARTS TO BE BAKE 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 GE: F70E1A2 GE: F70E4A2

PRINT DATE:

6/2/2016