

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

## BRIEF DESCRIPTION:

HG-1 CPPR-NCKL-BAKE-UVWAX-RoHS

**HG**

**1**

REV DATE: 4/1/2007

## GENERAL DESCRIPTION

.0002 MIN ELECTROPLATED NICKEL AND WAX WITH UV TRACER WITH COPPER FLASH UNDERCOAT  
!!!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 NICKEL: .0002 COPPER: .00005      MAX THICKNESS: NICKEL: .0004 COPPER: .0001  
THICKNESS SHALL BE TESTED PER ASTM B117

## 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 AND EXCESSIVE WAX

## PROCESS TO

PRINT DATE:

6/2/2016