

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

HJ-1 ELECTRO NICKEL-BAKE-RoHS

HJ

1

REV DATE: 4/1/2007

GENERAL DESCRIPTION

COMMERCIAL DULL NICKEL ELECTROPLATE FINISH WITH A UNIFORM SURFACE.
!!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

DULL NICKEL APPEARANCE

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 8

WHITE CORRIOSION:

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: .0002 MAX THICKNESS: .0004
B117

THICKNESS SHALL BE TESTED PER ASTM

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

GE F70E2C4

PRINT DATE:

6/2/2016