

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

HK-1 COPPER-NICKEL-CHROME

HK

1

REV DATE: 4/25/2016

GENERAL DESCRIPTION

.00001 MINIMUM CHROMIUM PLUS .0005 MINIMUM COPPER PLUS .001 MINIMUM NICKEL PER ES805-43226-SC 3.

APPEARANCE

BRIGHT CHROME APPEARANCE

ADHESION AND DUCTILITY

TO BE TESTED IN ACCORDANCE TO ASTM B571

CORROSION REQUIREMENTS

RED RUST: 96

WHITE CORRIOSION: 16

ES805-43226-SC3

COATING THICKNESS REQUIREMENTS

ES805-43226-SC3

STRESS RELIEF

PARTS TO BE BAKE AT 375 DEGREES F FOR 3 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

ES805-43226-SC3

PRINT DATE:

6/2/2016