

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

HM-0 ELECTRO-NICKEL

HM

0

REV DATE: 10/11/2016

GENERAL DESCRIPTION

DULL NICKEL ELECTROPLATE FINISH WITH HYDROGEN EMBRITTLEMENT RELIEF.

APPEARANCE

DULL NICKEL

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST:

WHITE CORRIOSION:

COATING THICKNESS REQUIREMENTS

OVERALL MIN THICKNESS: .0004 OVERALL MAX THICKNESS: .0006
THICKNESS SHALL BE TESTED PER ASTM B487

STRESS RELIEF

PARTS TO BE BAKED AT 500-525 DEGREES F FOR 3 HOURS WITHIN 1 HOUR OF 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

GE F70E2A4

PRINT DATE:

10/11/2016