

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

## BRIEF DESCRIPTION:

HV-1 E NICKEL-BAKE-UVWAX-RoHS

**HV**

**1**

REV DATE: 4/1/2007

## GENERAL DESCRIPTION

.0002 MIN ELECTROPLATED BRIGHT NICKEL & WAX WITH UV TRACER. NO COPPER FLASH IS PERMITTED  
!!!MUST BE RoHS COMPLIANT!!!

## APPEARANCE

BRIGHT SHINY 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: .0002    MAX THICKNESS: .0004

THICKNESS SHALL BE TESTED PER ASTM E376

## 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 PEEELING. VISUALLY INSPECT FOR UNIFORMITY OF COLOR AND SURFACE APPEARANCE, BLISTERING AND EXCESSIVE WAX. NO COPPER FLASH IS PERMITTED!!

## PROCESS TO

ASTM B456

GE: F70E13A4

PRINT DATE:

6/2/2016