

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

**BRIEF DESCRIPTION:**

HC-1 COPPER NICKEL BLACK

**HC**

**1**

REV DATE: 12/2/2021

**GENERAL DESCRIPTION**

.0002" MIN. COPPER PLATE FOLLOWED BY .0003" MIN. BRIGHT NICKEL FOLLOWED BY .00003" MIN. BARREL BLACK TIN-NICKEL PLATE.

**APPEARANCE**

SHINY BRIGHT BLACK

**ADHESION AND DUCTILITY**

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

**CORROSION REQUIREMENTS**

RED RUST:

WHITE CORRIOSION:

**COATING THICKNESS REQUIREMENTS**

COPPER .0002 MIN. BRIGHT NICKEL .0003 MIN. BARREL BLACK TIN-NICKEL .00003 MIN

**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**

PRINT DATE:

12/2/2021