

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

COPP-NICKL-BAKE-CHRM-V190

FF

REV DATE: 4/1/2007

GENERAL DESCRIPTION

.00001 MIN CHROMIUM AND TODCO V109 PLUS 50% V5 (OR EQUIV) WAX WITH UV TRACER OVER .00015 MIN NICKEL OVER .00005 MIN COPPER (ELECTROPLATED) TFS/TCS

APPEARANCE

SHINY BRIGHT CHROME APPEARANCE

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 12

WHITE CORROSION: 0

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: COPPER:.00005 NICKEL:.00015 CHROMIUM:.00001
THICKNESS: COPPER: .00007 NICKEL:.00035 CHROMIUM:.00003

MAX

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 EXAMINE GROUND EDGES FOR FLAKING OR PEELING. BAKE AFTER NICKEL PLATING

EQUIVALENT SPECS

N/A

APPROVED SUPPLIERS:

PRINT DATE:
3/19/2007