

AERONAUTICAL MATERIAL SPECIFICATION

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SILVER PLATING Nickel Strike - High Bake

1. ACKNOWLEDGMENT: A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.
2. APPLICATION: Primarily to provide a bearing surface and/or to prevent galling or seizing of metal surfaces.
3. PREPARATION:
 - 3.1 Unless otherwise specified, roughness of surfaces to be plated shall not exceed 80 microinches, rms, prior to cleaning.
 - 3.2 Parts shall be chemically clean when immersed in plating solutions.
 - 3.3 Electrical contacts shall be made in such manner as will ensure that no chemical or immersion deposition will occur.
4. PROCEDURE:
 - 4.1 Unless otherwise specified by purchaser, plating of steel parts shall be conducted in the following sequence, by processes approved by purchaser.
 1. Nickel Strike
 2. Silver Strike
 3. Silver Plate
 - 4.2 Unless otherwise specified, all parts shall be heated to 940-960 F after plating and held at temperature for not less than 20 minutes and not more than one hour; temperature of the parts shall not be over 400 F for more than seven hours, and above 400 F the heating and cooling medium shall be a neutral or reducing atmosphere or a neutral or non-oxidizing molten salt bath. If such heating would lower hardness below drawing limits, heating shall be at the highest practicable temperature which will maintain specified properties.
5. THICKNESS:
 - 5.1 Where "silver flash" is specified, plate thickness shall be approximately 0.0001 inch.
 - 5.2 Thickness of plate other than flash shall be as specified on drawing. If machining of plated metal is required, plate thickness as deposited shall be sufficient to allow machining of all areas of plated surfaces to the dimensions specified on the drawing.

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