

Engineering Specifications For PolyPlating Electroless and Sulfamate Nickel Plating

Salt Spray

Electroless – approx. 100 hours

Continuous Operating Temperature Range

Electroless – of coated parts is -65°F to +550°F.
(intermittent range is -65°F to +750°F.)

Thickness Range

Electroless - .00005 to .003 per surface
Sulfamate - .0003 to .050

Standard Plating Thickness

Electroless - .0005 (+/- .0001)
Sulfamate - .020

Thickness Controllability

Electroless - +/- .0001

Bake Temperature Range for Coating

Electroless – 375°F to 750°F

Resultant Hardness (as deposited)

Electroless – Rc 50 (Rc 68-70 after 750°F bake)
Sulfamate – Rc 28-32

Sulfamate Nickel Plating is used to build up areas needing thick applications. These areas are machined after plating. Sulfamate Nickel Plating may be used to fix worn-out areas, and areas that have been mis-machined.

If you have specifications to meet that are not on this page ... or if you have a technical question not covered here, we may be able to help.

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