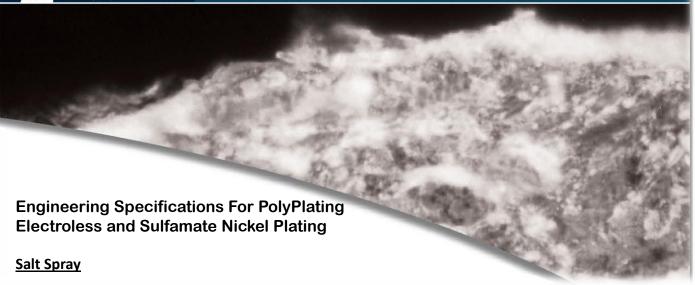


## SPECIFICATION AND TECHNICAL INFORMATION



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.

Poly Plating, Inc.

2096 Westover Road, Chicopee, MA 01022 Phone: (413) 593-5477 Fax: (413) 593-1631 www.polyplating.com www.poly-ond.com

Poly Coatings of the South

5944 Sandphil Road, Sarasota, FL 34232 Phone: (941) 371-8555 Fax: (941) 377-2247

