

AEROSPACE MATERIAL SPECIFICATIONS

AMS 2403F

SOCIETY OF AUTOMOTIVE ENGINEERS, Inc. 485 Lexington Ave., New York 17, N.Y.

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NICKEL PLATING General Purpose

1. **ACKNOWLEDGMENT:** A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.
2. **APPLICATION:** Primarily for moderate corrosion and oxidation resistance but without control of other characteristics. If a hard plate is required, AMS 2423 should be used; if a low-stressed plate is required, AMS 2424 should be used.
3. **TECHNICAL REQUIREMENTS:**
 - Ø Note. The requirements of 3.2, 3.6, 3.9, and 3.13 will be waived when plating is performed as a preparation for brazing.
 - 3.1 Surfaces of parts to be plated shall be smooth and substantially free from blemishes, pits, tool marks, and other irregularities.
 - 3.2 Unless otherwise specified, steel parts having hardness higher than Rockwell C 40 and which have been ground after heat treatment shall be suitably stress-relieved before cleaning for plating. Temperatures to which parts are heated shall be such that maximum stress-relief is obtained without reducing hardness of parts below drawing limits.
 - 3.3 Before placing parts in plating solutions, they shall have chemically clean surfaces, prepared with minimum abrasion, erosion, or pitting.
 - 3.4 Tight electrical connections shall be made and maintained for satisfactory plating.
 - 3.5 Plating shall be performed by electrodeposition of nickel from a chloride, sulfate-chloride, or sulfamate solution containing no addition agents which might have a detrimental effect on the properties of the plate or the basis metal; stress-reducing agents shall not be used unless specifically authorized by the purchaser. Unless otherwise specified, nickel shall be deposited directly on the basis metal without a prior flash coating of metal other than nickel, except that a preliminary chemical coating, immersion plate, and/or metal flash is permissible on aluminum, magnesium, and their alloys.

3.6 After plating, washing, and drying, steel parts as listed in 3.6.1, 3.6.2, and 3.6.3 shall be treated as follows, unless otherwise permitted, to remove hydrogen embrittlement due to cleaning and plating; heating shall be in air, preferably in a circulating air furnace. Heating should be started as soon as possible after plating and preferably within 1 hour. Treatment of other parts is not required.

3.6.1 Parts Cold Worked After Hardening and Tempering: Such parts, including roll threaded parts, regardless of hardness shall be heated to $375\text{ F} \pm 10$ ($190.6\text{ C} \pm 5.6$) and held at heat for not less than 3 hr, except as specified in 3.6.3.

3.6.2 Parts Having Hardness of Rockwell C 33 and Over and Springs: Such parts shall be heated to $375\text{ F} \pm 10$ ($190.6\text{ C} \pm 5.6$) and held at heat for not less than 3 hr, except as specified in 3.6.3.

Ø Note. Some parts having hardness of Rockwell C 40 and over may require heating for 23 hours.

3.6.3 Parts Affected By Heating to 375 F (190.6 C): Such parts and assemblies, including carburized parts, which will decrease in hardness or be otherwise deleteriously affected by heating to 375 F (190.6 C) shall be heated to $275\text{ F} \pm 10$ ($135\text{ C} \pm 5.6$) and held at heat for not less than 5 hr except that parts requiring special handling shall be treated as agreed upon by purchaser and vendor.

3.7 The finished thickness of plate shall be as specified on the drawing.

3.8 The plate shall be substantially uniform in thickness on significant surfaces, except that slight build-up at exterior corners or edges will be permitted provided finished drawing dimensions are met.

3.9 No requirements are established for minimum thickness of plate for holes, recesses, contact areas of parts plated all over, and other areas where a controlled deposit cannot be obtained under normal plating conditions, but such areas shall not be masked to prevent plating. Unless otherwise noted on drawings, the resulting thickness shall be considered only when such surfaces of parts can be touched by a sphere 0.75 in. in diameter but such surfaces shall show no film of copper after being immersed in a solution containing 4 g $\text{CuSO}_4 \cdot 5\text{H}_2\text{O}$, 10 g H_2SO_4 (sp gr 1.84), and 90 ml distilled water for 6 min. at room temperature.

3.9.1 If internal surfaces as defined in 3.9 are required to be plated, the drawing will so specify.

3.10 Thickness of plate shall be determined on representative parts or specimens by microscopic method, micrometer measurement, magnetic test, or dropping method, as agreed upon by purchaser and vendor.

3.11 Plate shall be firmly bonded to the basis metal, and shall be smooth, uniform in appearance, and free from frosty areas, pin holes, nodules, blisters, and other imperfections detrimental to performance of parts. The method of determining satisfactory adhesion shall be as agreed upon by purchaser and vendor.